



Hot Melt Adhesive 779.6

Thermoplastic synthetic resin adhesive for bonding and pre-coating of edges.

Fields of application

Bonding of

- Polyester edges
- Melamine resin edges
- PVC, PP and ABS edges with pre-treated backs
- Uncompressed resin-impregnated paper edge bandings
- Solid wood and veneer edges

Advantages

- Universally applicable
- Good re-melting properties
- Suitable for pre-coating of edges

Properties of the bond

- Heat resistance, depending on the edge: approx. 80° C
- (In a drying channel, the bond resists temperatures of up to 120° C for a short time)
- Cold resistance, depending on the edge: approx. -20° C
- Good water resistance (important when staining and bleaching veneer edges)
- Good ageing resistance
- Good oxidation resistance

Properties of the adhesive

Base:	EVA-Copolymers
Specific weight:	approx. 1.38 g/cm ³
Viscosity (Brookfield HBTD) sp. 27/10 tr/mn:	
at 180°C	130.000 ± 22.000 mPas
at 200°C	80.000 ± 15.000 mPas
Melt index according to DIN 53 735 (MFI 150/2.16):	50 ± 15 g/ 10 min.
Softening point (ring and ball):	105 ± 5° C
	For long stoppage of the machine, the temperature should be reduced to approx. 160°C.

Process temperature: 200-210°C
Lower temperatures may cause faulty gluing, higher temperatures maintained for a long time may damage the adhesive and lead to decomposition.

Delivery form: granules
Colour numbers: white - 10, ivory-20,
Identification: identification not required according to the German hazardous substances regulation GefStoffV (see our safety data sheet)

When hot melt adhesives are melted and applied, vapours are set free and an unpleasant odour can occur, even if the recommended working temperature has been observed. Moreover if the prescribed working temperature is exceeded over a longer period, harmful decomposition products can develop. Precautions should be taken to eliminate the vapours, e.g. by using a suitable ventilation system.

Application machinery

- Automatic edge banding machines with roller applicator
- Automatic edge banding machines with spray nozzle applicators
- Machines for pre-coating edges

Application techniques

The substrates for edge bonding have to be processed at exactly 90 °s and must be free from dust. The boards as well as the edges have to be acclimatised to room temperature. The most favourable moisture content of the wood is 8-10 %. The room temperature must not be lower than 18 °C. Draughts have to be avoided!

Temperature Control:

Regularly check the temperature directly on the application system by means of a laboratory thermometer, bi-metal thermometer or by a thermometer with electrical contacts. Readjust if necessary. The thermometers installed in the machine may give incorrect readings after extended use.

**Rate of Feed:**

20-50 m/min., depending on the width of the edge, a very slow line speed may cause faulty gluing.

Application Quantity:

The quantity applied should be adjusted in such a manner as to slightly show on the edge of the part to be glued. In order to check whether the adhesive film is evenly applied, a strip of rigid transparent PVC can be used.

Consumption for pre-coating of edges:

80-100 g/m²

Post-Treatment:

The glued material can be further processed immediately after bonding, (sawing, routing, planing, etc).

Cleaning

Tools can be cleaned with KLEIBERIT Cleaner 827.0.

Packaging

KLEIBERIT Hot Melt Adhesive 779.6

bag, 25 kg net

KLEIBERIT Cleaner 827.0

metal canister, 4,5 kg net

Storage

KLEIBERIT Hot Melt Adhesive 779.6 can be stored for approx. 2 years. Keep in a cool and dry place.

EX0801 – replaces all previous data sheets

Waste Disposal

Disposal of contents and/or containers should comply with all applicable federal, state and local regulations.

Our containers are made of recyclable material.

Service

Our application department may be consulted at any time without obligation. The statements made herein are based on our experience gained to date. They are to be considered as information without obligation. Please test and establish for yourself the suitability of our products for your particular purposes. No liability exceeding the value of our product can be derived from the foregoing statements. This also applies to the technical consultancy service which is rendered free of charge and without obligation.



Safety Data Sheet acc. to OSHA HCS

Printing date 03/16/2015

Version-No. 3

Reviewed on 03/13/2015

1: Identification

· **1.1. Product identifier**

· Trade name / Article No: **KLEIBERIT 779.6**

· **1.2. Relevant identified uses of the substance / mixture or uses advised against**

No further relevant information available.

· **Application of the substance / the mixture** Adhesives

· **1.3. Details of the supplier of the safety data sheet**

· **Manufacturer/Supplier:**

KLEBCHEMIE
M.G.Becker GmbH + Co. KG
Max Becker Str. 4
D - 76356 Weingarten / Baden
Germany

EdgeCo Inc.
194 Candlewood Rd
Bay Shore, N.Y. 11706
USA

· **Information department:**

Phone 1-800-644-6449
FAX 1-631-434-2775

· **1.4. Emergency telephone number:**

email: hse@kleiberit.com

1-800-424-9300 (CHEMTREC)
1-800-451-1403 (SARA-HOTLINE)

2: Hazard(s) identification

· **2.1. Classification of the substance or mixture**

· **Classification according to Regulation (EC) No 1272/2008 - GHS/CLP**

The product is not classified as hazardous to health or environment according to the CLP regulation.

· **2.2. Label elements**

· **Hazard pictograms** Void

· **Signal word** Void

· **Hazard statements** Void

· **Hazardous Material (US)**

This material is not considered as hazardous by the OSHA Hazard Communication Standard (29 CFR 1910.1200)

· **Classification system:**

· **NFPA-ratings (scale 0 - 4) - USA:**



Health = 0
Fire = 1
Reactivity = 0

· **HMS-ratings (scale 0 - 4) - USA:**

Health = 0
Fire = 1
Reactivity = 0

· **CARCINOGENICITY** NTP: No IARC: No OSHA: No

· **2.3. Other hazards**

· **Results of PBT and vPvB assessment**

· **PBT:** Not applicable.

· **vPvB:** Not applicable.

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3: Composition/information on ingredients

3.2. Mixtures

· **Description:** Mixture of synthetic plastics, based on ethylene vinyl acetate

· Dangerous components:

CAS NO.	Description	Void	%

4: First-aid measures

4.1. Description of first aid measures

· **General information:** No special measures required.

· **After inhalation:** Supply fresh air; consult doctor in case of complaints.

· After skin contact:

After contact with the molten product, cool rapidly with cold water.

Generally the product does not irritate the skin.

If skin irritation continues, consult a doctor.

· After eye contact:

Rinse opened eye for several minutes under running water. If symptoms persist, consult a doctor.

· **After swallowing:** Seek medical treatment.

· Information for doctor:

4.2. Most important symptoms and effects, both acute and delayed

No further relevant information available.

4.3. Indication of any immediate medical attention and special treatment needed

No further relevant information available.

5: Fire-fighting measures

5.1. Extinguishing media

· Suitable extinguishing agents:

CO₂, extinguishing powder or water spray. Fight larger fires with water spray or alcohol resistant foam.

· **5.2. Special hazards arising from the substance or mixture** Ethanoic acid

· 5.3. Advice for firefighters

· **Protective equipment:** Wear self-contained respiratory protective device.

6: Accidental release measures

6.1. Personal precautions, protective equipment and emergency procedures

Avoid formation of dust.

Use respiratory protective device against the effects of fumes/dust/aerosol.

See Pos. 8 - Breathing equipment.

· **6.2. Environmental precautions:** Do not allow to enter sewers/ surface or ground water.

· **6.3. Methods and material for containment and cleaning up:** Allow to solidify. Pick up mechanically.

· **6.4. Reference to other sections** No dangerous substances are released.

7: Handling and storage

· Handling:

7.1. Precautions for safe handling

Any deposit of dust which cannot be avoided must be regularly removed.

Use appropriate industrial vacuum cleaners or central vacuum systems for dust removal.

Prevent formation of dust.

· Information about protection against explosions and fires:

>> **Protect against electrostatic charges.** <<

Dust can combine with air to form an explosive mixture.

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- **7.2. Conditions for safe storage, including any incompatibilities**
- **Storage:**
- **Requirements to be met by storerooms and receptacles:** No special measures required.
- **Information about storage in one common storage facility:** Observe the national regulations.
- **Further information about storage conditions:** None.
- **7.3. Specific end use(s)** No further relevant information available.

8: Exposure controls/personal protection

- **Additional information about design of technical systems:** No further data; see item 7.
- **8.1. Control parameters**
- **Components with limit values that require monitoring at the workplace:**
The product does not contain any relevant quantities of materials with critical values that have to be monitored at the workplace.
- **8.2. Exposure controls**
- **Personal protective equipment:**
- **General protective and hygienic measures:**
The usual precautionary measures for handling chemicals should be followed.
Wash hands before breaks and at the end of work.
- **Breathing equipment:** Use suitable respiratory protective device only when dust is formed.
- **Protection of hands:** Heat resistant gloves
- **Material of gloves:** Leather gloves
- **Eye protection:** Safety glasses

9: Physical and chemical properties

- **9.1. Information on basic physical and chemical properties**
- **General Information**
- **Appearance:**
- **Form:** Solid
- **Color:** According to product specification
- **Odor:** Weak, characteristic
- **Change in condition**
- **Boiling point/Boiling range:** Undetermined.
- **Softening temperature / range:** 105 +/- 5 °C (221 +/- 41 °F)
- **Flash Point:** Not applicable.
- **Auto Igniting:** Product is not selfigniting.
- **Danger of Explosion:** Product does not present an explosion hazard.
- **Density at 20 °C (68 °F):** ca. 1.38 g/cm³ (ca. 11.516 lbs/gal)
- **Solubility in / Miscibility with**
- **Water:** Insoluble.
- **Organic solvents:** 0.0 %
- **9.2. Other information** No further relevant information available.

10: Stability and reactivity

- **10.1. Reactivity** see item 10.3
- **10.2. Chemical stability** Stable when stored and used properly.
- **Thermal decomposition / conditions to be avoided:** To avoid thermal decomposition do not overheat.
- **10.3. Possibility of hazardous reactions** No dangerous reactions known.
- **10.4. Conditions to avoid** No further relevant information available.
- **10.5. Incompatible materials:** No further relevant information available.

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- **10.6. Hazardous decomposition products:** No dangerous decomposition products known.

11: Toxicological information

- **11.1. Information on toxicological effects**
- **Acute toxicity:**
- **Primary irritant effect:**
- **on the skin:** No irritant effect.
- **on the eye:** No irritating effect.
- **Sensitization:** No sensitizing effects known.
- **Additional toxicological information:**
- **Carcinogenic categories**
- **NTP (National Toxicology Program)**
- None of the ingredients is listed.
- **OSHA-Ca (Occupational Safety & Health Administration)**
- None of the ingredients is listed.

12: Ecological information

- **12.1. Toxicity**
- **Aquatic toxicity:** No further relevant information available.
- **12.2. Persistence and degradability** No further relevant information available.
- **Other information:** The product is difficultly biodegradable.
- **12.3. Bioaccumulative potential** No further relevant information available.
- **12.4. Mobility in soil** No further relevant information available.
- **12.5. Results of PBT and vPvB assessment**
- **PBT:** Not applicable.
- **vPvB:** Not applicable.
- **12.6. Other adverse effects** No further relevant information available.

13: Disposal considerations

- **13.1. Waste treatment methods**
- **Recommendation:**
- Can be disposed of with household garbage in small quantities after curing.
- On the basis of the necessary technical regulations and after consultation with the disposal agent and the relevant authorities, can be disposed of with domestic waste or incinerated with domestic waste.
- **Uncleaned packagings:**
- **Recommendation:**
- Non contaminated packagings can be used for recycling.
- Empty contaminated packagings thoroughly. Disposal must be made according to official regulations.

14: Transport information

- **14.1. UN-Number** Void
- **14.2. UN proper shipping name** Void
- **DOT, IMDG**
- **Class** No dangerous good
- **IATA**
- **Class** Not classified as dangerous goods under IATA regulations
- **14.4. Packing group** Void
- **14.5. Environmental hazards:**
- **Marine pollutant:** No
- **14.6. Special precautions for user** Not applicable.

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- **14.7. Transport in bulk according to Annex II of MARPOL73/78 and the IBC Code** Not applicable.

15: Regulatory information

- **15.1. Safety, health and environmental regulations/legislation specific for the substance or mixture**
See position 2 - Hazards Identification
- **Sara - USA:**
- **Section 355 (Extremely hazardous substances):** None of the ingredients is listed.
- **Section 313 (Specific toxic chemical listings):** None of the ingredients is listed.
- **TSCA (Toxic Substances Control Act) - USA:** All components of this product are on TSCA.
- **Proposition 65 - USA**
- **Chemicals known to cause cancer:**
None of the ingredients is listed.
- **Chemicals known to cause reproductive toxicity for females:**
None of the ingredients is listed.
- **Chemicals known to cause developmental toxicity (Prop 65):**
All ingredients are listed.
- **EPA (Environmental Protection Agency):**
None of the ingredients is listed.
- **NIOSH-Ca (National Institute for Occupational Safety and Health) - California/USA:**
None of the ingredients is listed.
- **15.2. Chemical safety assessment:** A Chemical Safety Assessment has not been carried out.

16: Other information

This information is based on our present knowledge. However, this shall not constitute a guarantee for any specific product features and shall not establish a legally valid contractual relationship.

- **USA: Relevant labels and warnings HAZCOM LABEL: NOT REQUIRED**
- **Department issuing SDS:** Safety & Environment
- **Contact:** Dr. Wolfgang Stüber
- **Abbreviations and acronyms:**
RID: Règlement international concernant le transport des marchandises dangereuses par chemin de fer (Regulations Concerning the International Transport of Dangerous Goods by Rail)
ICAO: International Civil Aviation Organisation
IMDG: International Maritime Code for Dangerous Goods
DOT: US Department of Transportation
IATA: International Air Transport Association
GHS: Globally Harmonised System of Classification and Labelling of Chemicals
EINECS: European Inventory of Existing Commercial Chemical Substances
ELINCS: European List of Notified Chemical Substances
CAS: Chemical Abstracts Service (division of the American Chemical Society)
NFPA: National Fire Protection Association (USA)
HMIS: Hazardous Materials Identification System (USA)
PBT: Persistent, Bioaccumulative and Toxic
vPvB: very Persistent and very Bioaccumulative
- *** Data compared to the previous version altered. -**

USA