

The smooth thing ...
a hot melt cartridge with easy slide coating

SUPRAMELT 782 GL



QUALITY CERTIFICATE

The laboratory of both
HOLZ-HER and KLEBCHEMIE
have tested and approved
this

SUPRAMELT 782.5

The transparent hot melt cartridge
- ask for the relevant data sheet.

PRODUCT INFORMATION



Protected from dust

This cartridge is protected from contamination, dust and dirt whilst being stored at the work place. In addition to this even if stored in a warm environment the cartridges do not stick together.

Problem free melting

The new foil coating acts like a lubricant when in the machine. It aids smooth problem free melt rate and dissolves without trace during the melting process.

Increased melting speed

The cartridge with the easy slide coating ensures increased melting speed, which is required to bond wide edges and long substrates.

Easy change of cartridges

Cartridges, when colour changes are required can be taken out and used again easily, as the foil protects the cartridge.

KLEBCHEMIE

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FIELD OF APPLICATION

Bonding of

- HPL edges
- Epoxy resin edges
- ABS edges
- Solid wood edges
- Polyester edges
- PVC-edges
- Veneer edges

APPLICATION

- Both substrates have to be cut to an exact right angle and must be free from dust.
- Bring the substrate and the edging material up to room temperature
- The ideal moisture content of the wood is 8 - 10%, room temperature of min. 18°C, avoid drafts
- Pre heat time 2 - 5 minutes, application temperature 200 - 220°C (Thermostat)
- Correct temperature settings are especially important when bonding HPL and solid wood edges
- When bonding long and/or ridged pieces the application temperature should be in the higher temperature areas.
- Lower temperatures reduce the "wetting out" of the edges
- Coat weight and press pressure should be adjusted so that the applied beads are pressed flat and the adhesives quills out on the edges slightly. To determine the correct coat weight the use of a transparent edge is advised.

NOTE

- For solid wood edging the use of linear grain wood is preferable as this is less prone to bend.
- To achieve optimum bond strength the wood grain of the edges should be vertical on the bond surface.
- Prepare the base substrate exactly
- The chipboard should have a surface which does not have rough cutting marks.
- Adjust the press tolerance to be a little bit lower than the width of the edge.

IDENTIFICATION

identification is not required to the German hazardous substances regulation GefStoffV
When hot melt adhesive are melted and applied, vapours are set free and an unpleasant odour can occur, even is the recommended working temperature has been observed. If the recommended working temperature is exceeded over a long period of time, harmful decomposition products can develop. Precautions should be taken i.e. using suitable ventilation, to eliminate vapours.

Please observe our data sheet 782 GL

TECHNICAL PROPERTIES

- **Basis** Ethylene-Vinylacetate-Copolymer
- **Specific gravity** approx. 1,3 g/cm³
- **Softening point (Ring and Ball) DIN 1995** 110°C ± 5°C
- **Melting index DIN 53 735 (MFI 150/2.16)** 60 ± 15 g/10 min.
- **Pre heat time** 2 - 5 minutes
- **Speed** 8 - 20 m/min., depending on machine
- **Heat resistance** up to +80°C depending on edge
- **Cold resistance** up to -20°C depending on edge
- **Colours** white (10)
ivory (20)
mahogany (70)
black (99)
transparent (782.5)
- **Product formant** cartridge
Ø: 63 ± 0,5 mm
length : 80 ± 2,0 mm

CLEANING

When cleaning the application equipment observe the manufacturers instructions.

DISPOSAL

Hardened adhesive
domestic waste disposal

Our packaging is made from recyclable materials.

PACKING SIZES

Carton with 45 cartridges approx. 15 kg net.

STORAGE

KLEIBERIT SUPRAMELT 782 GL/782.5

Approx. 2 years

Store cool, dry and in original sealed packaging.

TECHNICAL DATA**SUPRAMELT
782 GL****SERVICE**

Our application department may be consulted at any time without obligation. The statements 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.

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