



Hotmelt Adhesive 782.5

Fields of application

Bonding of

- Veneer and solid wood edges
- Melamine edges (laminated edges)
- PVC and ABS edges with pre-treated backing
- Polyester edges
- Resin-impregnated paper edges

Advantages

- delivered in cartridges with protection film and granulates

Properties of the bond

- Heat resistance approx. 100°C according to the edge (the bond withstands temperatures of up to 120°C in a drying tunnel for a short period)
- Cold resistance according to the edge down to approx. -30°C
- Good resistance to water (important when staining or bleaching veneer edges)
- Good ageing resistance

Properties of the adhesive

Base: EVA Copolymer
Specific gravity: approx. 0.96 g/cm³
Colour: transparent yellowish

Viscosity

Brookfield HBTD, Sp. 27/10 rpm:
 at 200°C: approx. 36,000 mPa·s

Melting index according to DIN 53 735 (MFI 150/2,16): approx. 105 g/10 min

Softening point (ring + ball):
 approx. 101°C

Melting time: 2-5 min

Working temperature:
 Above 200°C. For solid edges or difficult plastic edges up to 230°C (short period only). Low temperatures can cause faulty bonding – ensure that the temperature is correctly set.

Delivery form:
 1. Cartridge Ø 63 ± 0.5 mm
 Length 80 - 2 mm
 2. Granulate

Identification: Identification not required according to EU regulations (see our safety data sheet)

When hotmelt 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.

Processing

The substrates for edge bonding have to be processed at exact right angles and should be free from dust. Boards and edges have to be conditioned to room temperature. The most favourable moisture content of the wood is 8-10%. Room temperature should not be lower than 18°C. Draughts have to be avoided.

Melting time: 2 - 5 min

Working temperature above 200°C

When processing wood types which are difficult to bond, the working temperature can be briefly raised to 230°C.

Temperature control is particularly important when bonding solid wood edges. For long and thick items, work within the higher temperature range. Lower temperatures lessen the wetting of the edge. The amount of adhesive and pressure applied should be set so that the beads applied are squeezed to form an adhesive layer all-over the surface to be bond and the adhesive pearls slightly at the edge. This can be checked best with a transparent test edge.

Tips for solid wood bonding:

- For solid wood edges select plain, mature wood which does not tend to sag
- Wood edges with standing year rings for the glue line provide optimal strength
- Prepare the carrier material carefully
- Chipboard should not have any rough cut surfaces
- Adjust the press rollers to somewhat less than the edge thickness.

Further processing:

The finished material can be processed further immediately following bonding (Sawed, milled, planed, etc.).



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Because the characteristics of edging materials can vary, individual testing is essential!

Cleaning

Observe the manufacturer's recommendations when cleaning tools and application plant.

Packaging

KLEIBERIT SK 782.5:

Delivery carton with 45 cartridges, approx. 11 kg
Paper bag, 20 kg net

Storage

KLEIBERIT Supramelt 782.5 can be stored for 2 years. Keep cool and dry.

EX0411; replaces previous versions

Klebstoff- und Gebinde-Entsorgung
Klebstoffrückstände ausgehärtet: HMD = Hausmülldeponie
Abfallschlüssel 55906 HMV = Hausmüllverbrennung

Unsere Gebinde sind aus recyclingfähigem Material. Gut entleerte Gebinde können der Wiederverwertung zugeführt werden.

Service

Unser anwendungstechnischer Beratungsdienst steht Ihnen jederzeit zur Verfügung. Unsere Angaben beruhen auf unseren bisherigen Erfahrungen und sind keine Eigenschaftszusicherungen im Sinne der BGH-Rechtsprechung. Prüfen Sie selbst, ob sich unser Produkt für ihre Zwecke eignet. Eine Haftung, die über den Wert unseres Produktes hinausgeht, kann aus den vorliegenden Ausführungen nicht hergeleitet werden, auch nicht aus der Inanspruchnahme unseres kostenlos und unverbindlich zur Verfügung gestellten Beratungsdienstes.

**Safety Data Sheet**
acc. to OSHA HCS

Printing date 04/08/2015

Version-No. 4

Reviewed on 04/08/2015

1: Identification· **1.1. Product identifier**· Trade name / Article No: **KLEIBERIT 782.5**· **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 NY 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.

· **For safety reasons unsuitable extinguishing agents:** Water with full jet

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** Not required.

· **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.

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.

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- 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:
- Breathing equipment: Not required.
- Protection of hands: Heat resistant gloves
- Eye protection: Goggles recommended during refilling.
- Body protection: Vacuum clean contaminated clothing. Do not blow or brush off contamination.
- Limitation and supervision of exposure into the environment Void

9: Physical and chemical properties

- 9.1. Information on basic physical and chemical properties
- General Information
- Appearance:

Form:	Solid
Color:	Light yellow
Odor:	Weak, characteristic
pH-value:	Not applicable
- Change in condition

Boiling point/Boiling range:	Undetermined.
Softening temperature / range:	ca. 101 °C (ca. 214 °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. 0.96 g/cm³ (ca. 8.011 lbs/gal)
- Solubility in / Miscibility with

Water:	Insoluble.
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- Partition coefficient (n-octanol/water): Not determined
- 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.
- 10.6. Hazardous decomposition products: No dangerous decomposition products known.

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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:

The product is not subject to classification according to internally approved calculation methods for preparations:

When used and handled according to specifications, the product does not have any harmful effects according to our experience and the information provided to us.

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 burned with household garbage after consulting with the waste disposal facility operator and the pertinent authorities and adhering to the necessary technical regulations.

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:

Empty contaminated packagings thoroughly. Disposal must be made according to official regulations.

Non contaminated packagings can be used for recycling.

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

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- **14.5. Environmental hazards:**
- **Marine pollutant:** No
- **14.6. Special precautions for user:** Not applicable.
- **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:**
- **Proposition 65 - USA**
- **Chemicals known to cause cancer:**
All ingredients are 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