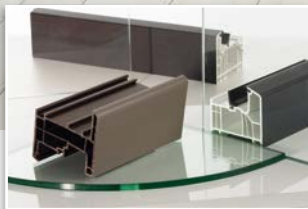


PUR Hotmelt Adhesives for **Profile Wrapping**



Adhesive systems for profile wrapping in interior and exterior applications - windows, window sills, floor and wall elements as well as modular furniture in living rooms



Adhesive systems for profile wrapping

Profile wrapping interior applications

Laminated profiles and mouldings are an integral part of interiors. They are usually in the form of window sills, door frames, baseboards or decorative applications for furniture fronts. Sophisticated shapes with curves, or notches often enhance the appearance, but also have functional reasons. The market offers countless decorative materials for this purpose. For an attractive appearance, high-quality, bubble-free processing is essential. Particularly in the case of tight radii, the demands on adhesive and processing are especially high. In addition to perfect results, the right adhesive makes a decisive contribution bonding to a fast, efficient and cost-effective manufacturing process. Reactive PUR hotmelt adhesives are the right choice in the field of profile wrapping. Together with the right primer (if required) and a perfectly adjusted wrapping machine, consistent bonding quality is ensured. In living areas, the following material combinations are common:

Profile materials

- solid wood
- wood based
- aluminum
- plastic

Decorative materials

- CPL
- paper
- veneer
- thermoplastic foils

Window profile wrapping

The demands on adhesive and primer systems for window profile wrapping are immense due to the permanent influence of the weather. KLEIBERIT® as market leader offers a complete range of products for reliable bonding for all profile and film variants approved for this application. Decades of experience are the basis for providing the optimum products for the constantly increasing requirements. All KLEIBERIT® products offered for the window lamination market have an approval according to RAL GZ 716.

For the lamination of PVC window profiles, reactive polyurethane (PUR) hotmelt adhesives have become increasingly popular over the last 25 years. They meet the highest requirements in an economical way. Especially the product range KLEIBERIT® 704 has set a quality standard in the market. Especially because of the excellent aging resistance (also known as hydrolysis/thermolysis resistance) and the good suitability for almost all PVC and aluminum profiles. They can be ideally combined with all KLEIBERIT® primers approved according to RAL GZ 716.

Completely new possibilities and individuality in the design of window sills are offered by the use of pre-coated roll material with KLEIBERIT HotCoating® technology. Decorative foils can be produced cost-effectively in both small and large runs, and even

with a unique design if desired. In terms of design, there are no limits. This means that both small and large companies can offer their customers maximum individuality, something which was previously unattainable. By adding agents for abrasion resistance,

KLEIBERIT HotCoating® technology even enables a walkable profile surface which can be walked on for floor-to-ceiling window elements in interior areas.

ME Micro-Emission Adhesives for Profile Wrapping/Window Profile Wrapping

Product	Viscosity 120 °C [mPa·s]	Application temperature [°C]	Open time [s]	Application examples/Characteristics
702.0.50	30,000	120-140	< 5	For lamination of thin foils to wood based materials
702.5.59	60,000	120-140	< 5	For lamination of foils, veneers and laminates to wood based materials and suitable plastic and aluminum profiles. Versions of this product are available for different requirements
702.8.59	60,000	120-140	< 5	For lamination of foils, veneers and laminates to wood based materials and suitable plastic and aluminum profiles
704.3.50	40,000	120-140	< 5	For lamination of all foils and PVC profiles approved according to RAL-GZ 716. Particularly suitable for all applications where high initial strength is required
704.3.57	33,000	120-140	< 5	For lamination of all foils and PVC profiles approved according to RAL-GZ 716. Accelerated adhesive with very fast setting behavior
707.3.50	120,000	120-160	< 60	Adhesive with a long hot tack phase and yet steeply increasing strength build-up immediately after the joining process. Suitable for wrapping CPL and rigid foils
708.7.50	120,000	130-150	< 10	Adhesive with very high initial strength, suitable for CPL, rigid foils and tight radii
711.1.52	10,000	110-130	< 60	Lightfast, for lamination of thin transparent foils

PUR Hotmelts for Window Profile Wrapping

Product	Viscosity 120 °C [mPa·s]	Application temperature [°C]	Open time [s]	Application examples/Characteristics
704.3.00	33,000	120-140	< 5	For lamination of all foils and PVC profiles approved according to RAL-GZ 716. Particularly suitable for all applications where high initial strength is required
704.6.00	60,000	120-140	< 5	For lamination of all foils and PVC profiles approved according to RAL-GZ 716. Particularly suitable for all applications where highest initial strength is required
704.8.00	38,000	120-140	< 10	For lamination of all foils and PVC profiles approved according to RAL-GZ 716. Particularly suitable for all applications where a very wide processing window is required
708.0.00	32,000	120-140	< 5	For lamination of all foils and PVC profiles approved according to RAL-GZ 716. Particularly suitable for all applications where a very low heat build-up is required

PUR Hotmelts for Profile Wrapping

Product	Viscosity 120 °C [mPa·s]	Application temperature [°C]	Open time [s]	Application examples/Characteristics
702.4.07	40,000	120-140	< 5	With 5% recycled raw materials, very good initial strength, also suitable for thicker foils, for wrapping on MDF, PVC and aluminum, with appropriate pre-treatment
702.5.00	60,000	120-140	< 5	For lamination of foils, veneers and laminates to wood based materials and suitable plastic and aluminum profiles. Versions of this product are available for different requirements
702.5.49	33,000	130-160	< 20	For lamination of foils and papers, for wrapping on MDF, PVC, and aluminum, with appropriate pre-treatment. Characterized by excellent melting and fast cross-linking speed
702.8.00	60,000	120-140	< 10	For lamination of foils, veneers and laminates to wood based materials and suitable plastic and aluminum profiles. Versions of this product are available for different requirements

For perfect bonding results, the profiles to be laminated are treated with a primer immediately before the bonding process. For this purpose, a wide range of different products is available for the respective application. Our modern primer systems can be

applied very easily using felt or vacuum application techniques. Due to fluorescent setting, the primer application can be easily monitored and ensured.

Primer

Product	RAL-GZ 716	Application method	VOC reduced	Application examples/Characteristics
831.0	✓	primer felt pad		For pretreatment of PVC profiles and, depending on the aluminum quality, also for aluminum profiles. Fast drying, short reaction time. Main solvent: dichloromethane
831.4		primer felt pad		For pretreatment of PMMA profiles or pretreatment of acrylate-based foils. Main solvent: MEK
831.7		primer felt pad		For pretreatment of aluminum profiles. Fast drying, short reaction time. Main solvent: Dichloromethane
842.1	✓	primer felt pad and vacuum technology	✓	For pretreatment of PVC profiles. Low application quantity, slow drying. Main solvent: NBP
842.2	✓	primer felt pad and vacuum technology	✓	For the pretreatment of PVC profiles, dries faster than other VOC-reduced primers. Particularly stable running in the device. Main solvent: NBP
842.3	✓	primer felt pad and vacuum technology	✓	For the pretreatment of PVC profiles, label-free . Low application quantity, slow drying. Main solvent: glycol ether
842.5	✓	primer felt pad and vacuum technology	✓	For pretreatment of PVC profiles. Long application time, achieves very high initial strength. Main solvent: water
842.6	✓	primer felt pad and vacuum technology	✓	For pretreatment of PVC profiles. Dries faster than other VOC-reduced primers, specially developed for vacuum technology. Main solvent: NBP
848.1	✓	primer felt pad		For pretreatment of PVC profiles. Fast drying, short reaction time. Main solvent: MEK

Cleaning products

Product	Application examples/Characteristics
761.6	Cleaning of tank and drum melters, gear pumps and transport hoses, metal application units (e.g. slot nozzle, roller). Combines the function of flushing cleaners like KLEIBERIT® 761.7 and the intensive cleaner KLEIBERIT® 826.0 in just one product
761.7	Cleaning of tank and drum melters, gear pumps and transport hoses, metal application units (e.g. slot nozzle, roller)
823.3	Cold cleaner for removal of hardened adhesive residue on machine parts, tools and devices
826.0	Hot cleaner for removing reacted or cracked adhesive residues from machine parts, tools and equipment

KLEIBERIT® offers state-of-the-art reactive PUR hotmelt adhesives and decades of experience - let us advise you!

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