KLEIBERIT Edgebanding adhesives

AWETA - Scherrenbacher - 2001-06-18

		Product	Base	Viscosity (Brookfield)	Application Temperature min.	Application Temperature max.	Line speed min	Line speed max	MFI	Soft. Point [R+B]	Temperature Resistance min.	Temperature Resistance max.	CNC-PC	Straight EB	Softforming	Direct Postforming	Edgebanding Material: Paper	CPL	HPL	Melamine	Polyester	ABS thick	ABS thinn	PVC thick	PVC thinn	PP thick	PP thinn	PMMA thick	PMMA thinn	Veneer	Solid wood	Properties
MANUAL UNITS	1	788.3	EVA	130 °C 110.000 mPa s 150 °C 55.000 mPa s 160 °C 38.000 mPa s	130 °C	- 160 °C	5 m/min	- 15 m/min	270 g/10min 150 °C/2,16	85 °C	-20 °C	70 °C		+			+			+	+		+		+					+		very low application temp. long open time, very soft glue line
	2	788.7	EVA	160 °C 120.000 mPa s 180 °C 65.000 mPa s 200 °C 45.000 mPa s	160 °C	- 200 °C	5 m/min	- 15 m/min	50 g/10min 150 °C/2,16	90 °C	-20 °C	70 °C	+	+			+		+		+	+		+	+					+		low application temp. long open time, very soft glue line
	3	788.8	EVA	120 °C 82.000 mPa s 140 °C 36.000 mPa s	120 °C	- 140 °C	5 m/min	- 15 m/min	281 g/10min 150 °C/1,2	92 °C	-25 °C	70 °C		+			+			+	+		+		+					+		very low application temp. special grade for temperature sensitive edges long open time, very soft glue line
SLOW LINE SPEED	4	782.0	EVA	180 °C 110.000 mPa s 200 °C 65.000 mPa s	200 °C	- 230 °C	8 m/min	- 20 m/min	60 g/10min 150 °C/2,16	100 °C	-20 °C	80 °C		+			+			+	+	+	+	+	+					+	+	EVA grade of HOLZHER-cartridges solid wood edges up to 12mm soft variante of 782.0
	5	782.1	EVA	180 °C 110.000 mPa s 200 °C 65.000 mPa s	200 °C	- 230 °C	8 m/min	- 20 m/min	60 g/10min 150 °C/2,16	100 °C	-20 °C	80 °C		+			+			+	+	+	+	+	+					+	+	782.0 in granulate solid wood edges up to 12mm medium hard glue line
	6	782.5	EVA	200 °C 36.000 mPa s	200 °C	- 230 °C	8 m/min	- 20 m/min	105 g/10min 150 °C/2,16	101 °C	-20 °C	80 °C		+			+			+	+	+	+	+	+					+	+	EVA grade of HOLZHER-cartridges / transp. solid wood edges up to 12mm medium hard glue line
	7	788.0	EVA	180 °C 55.000 mPa s 200 °C 35.000 mPa s	180 °C	- 200 °C	8 m/min	- 20 m/min	100 g/10min 150 °C/2,16	95 °C	-20 °C	70 °C		+			+			+	+		+		+					+		very long open time low application temp. precoating of edges
	8	707.7	PUR	120 °C 100.000 mPa s 140 °C 50.000 mPa s	120 °C	- 140 °C	8 m/min	- 20 m/min		69 °C	-40 °C	140 °C		+			+		+	+	+	+	+	+	+	+	+	+	+	+	+	PUR grade of HOLZHER-cartridges very high heat resistance very high moisture resistance
	9	709.8	PUR	120 °C 150.000 mPa s 140 °C 100.000 mPa s	120 °C	- 140 °C	8 m/min	- 30 m/min		100 °C	-40 °C	140 °C		+	+	+	+	+	+											+		high softening point suited for softforming + direct postforming
MEDIUM LINE SPEED	10	773.0	EVA	160 °C 160.000 mPa s 180 °C 95.000 mPa s 200 °C 55.000 mPa s	160 °C	- 200 °C	20 m/min	- 40 m/min	50 g/10min 150 °C/2,16	105 °C	-20 °C	90 °C	+	+			+		+	+	+		+		+					+		unfilled grade, almost transparent very high initial tack special grade for CNC-PC
	11	773.7	EVA	180 °C 250.000 mPa s 200 °C 115.000 mPa s 220 °C 65.000 mPa s	180 °C	- 220 °C	20 m/min	- 40 m/min	100 g/10min 150 °C/2,16	110 °C	-30 °C	90 °C	+	+			+			+	+	+	+	+	+					+		low filled grade high initial tack special grade for CNC-PC
	12	774.4	EVA	180 °C 98.000 mPa s 200 °C 65.000 mPa s 220 °C	200 °C	- 220 °C	20 m/min	- 60 m/min	50 g/10min 150 °C/2,16	102 °C	-20 °C	80 °C		+			+			+	+	+	+	+	+					+		regular grade for straight edge banding edgebands up to 3mm edgebands up to 3mm
	13	777.0	EVA	180 °C 115.000 mPa s 200 °C 75.000 mPa s 220 °C 42.000 mPa s	200 °C	- 220 °C	20 m/min	- 30 m/min	164 g/10min 190 °C/2,16	113 °C	-30 °C	90 °C		+	+	+	+			+	+	+	+	+	+					+	+	universal grade for edgbanding jobs extended heat resistance up to 90 °C
	14	777.2	EVA	180 °C 200.000 mPa s 200 °C 120.000 mPa s 220 °C 70.000 mPa s	210 °C	- 230 °C	20 m/min	- 30 m/min	114 g/10min 190 °C/2,16	136 °C	-30 °C	110 °C		+	+	+	+			+	+	+	+	+	+					+	+	universal grade for edgbanding jobs superior heat resistance up to 110 °C
	15	779.6	EVA	180 °C 150.000 mPa s 200 °C 85.000 mPa s 220 °C 55.000 mPa s	200 °C	- 220 °C	20 m/min	- 60 m/min	36 g/10min 150 °C/2,16	105 °C	-20 °C	80 °C		+	+		+			+	+	+	+	+	+	+	+			+	+	precoating, fast blockfree solidwood edges up to 5mm very good reactable
	16	753.5	PO	190 °C 61.000 mPa s 200 °C 47.000 mPa s 210 °C 39.000 mPa s	190 °C	- 210 °C	8 m/min	- 40 m/min		165 °C	-30 °C	120 °C	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	universal grade for edgbanding jobs very high heat resistance up to 120 °C
	17	707.0	PUR	120 °C 60.000 mPa s 140 °C 35.000 mPa s	120 °C	- 140 °C	20 m/min	- 40 m/min		75 °C	-40 °C	140 °C		+			+		+	+	+	+	+	+	+	+	+	+	+	+	+	unprimered HPL edges superior high heat resistance high moisture resistance
FAST LINE SPEED	18	773.1	EVA	180 °C 190.000 mPa s 200 °C 110.000 mPa s 220 °C 59.000 mPa s	200 °C	- 220 °C	20 m/min	- 80 m/min	40 g/10min 150 °C/2,16	110 °C	-30 °C	80 °C		+			+			+	+		+		+					+		unfilled grade, almost transparent high initial tack, no stringing special grade for HOMAG POWER LINE
	19	779.7	EVA	180 °C 150.000 mPa s 200 °C 85.000 mPa s 220 °C 60.000 mPa s	200 °C	- 220 °C	20 m/min	- 70 m/min	35 g/10min 150 °C/2,16	110 °C	-30 °C	90 °C		+	+		+			+	+	+	+	+	+					+	+	precoating solidwood edges up to 5mm special grade for HOMAG POWER LINE
	20	779.8	EVA	180 °C 92.000 mPa s 200 °C 52.000 mPa s	200 °C	- 220 °C	20 m/min	- 80 m/min	52 g/10min 150 °C/2,16	118 °C	-20 °C	100 °C		+	+		+			+	+	+	+	+	+					+	+	solidwood edges up to 5mm high initial tack, strong glue line, no smearing special grade for HOMAG POWER LINE