KLEIBERIT®
ADHESIVES • COATINGS

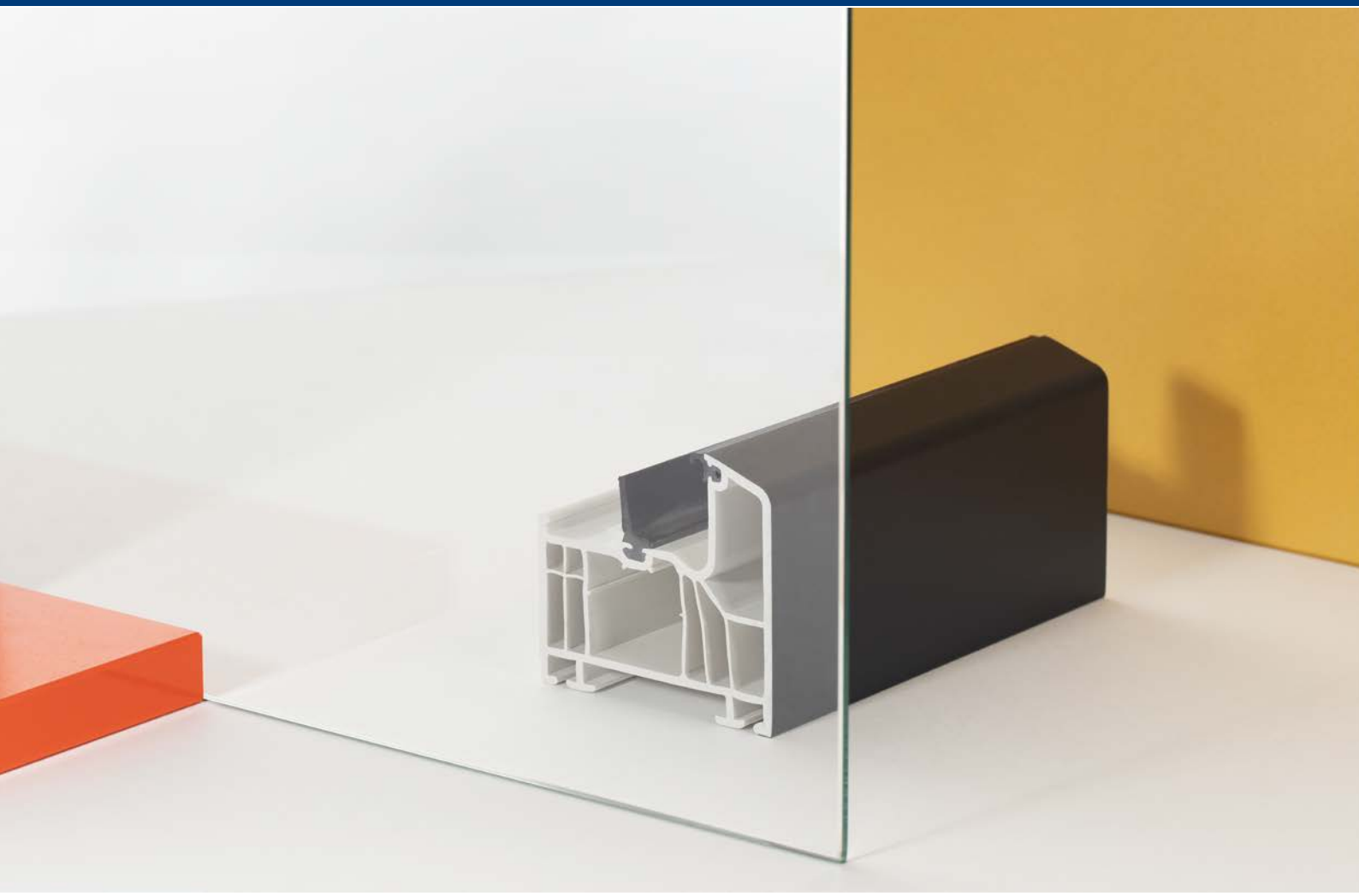
PUR Hotmelt Adhesives for

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

Competence PUR



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 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

- wood
- wood based
- aluminum
- plastic

Decorative materials

- CPL
- paper
- veneer
- thermoplastic films

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 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 PUR HM KLEIBERIT 704 series 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, HotCoating technology even enables a walkable profile surface which can be walked on for floor-to-ceiling window elements in interior areas.

Micro-Emission Adhesives for Profile Wrapping

Product	Viscosity 120 °C [mPa·s]	Application temperature [°C]	Open time [s]	characteristics/applications
702.0.50	30,000	120 - 140	< 5	For lamination of thin films to wood based materials
702.5.50	60,000	120 - 140	< 5	For lamination of films, veneers and laminates to wood based materials and suitable plastic and aluminum profiles. Versions of this product are available for different requirements.
702.7.59	100,000	120 - 140	< 5	For lamination of films, veneers and laminates with higher material tensions onto wood-based material profiles and suitable plastic and aluminum profiles.

Reactive Hotmelts for window Profile Wrapping

Product	Viscosity 120 °C [mPa·s]	Application temperature [°C]	Open time [s]	characteristics/applications
704.3.00	33,000	120-140	< 5	For lamination of all films 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 films 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 films 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 films and PVC profiles approved according to RAL GZ 716. Particularly suitable for all applications where a very low heat build-up is required.

Reactive Hotmelts for Profile Wrapping

Product	Viscosity 120 °C [mPa·s]	Application temperature [°C]	Open time [s]	characteristics/applications
702.5.00	60,000	120-140	< 5	For lamination of films, veneers and laminates to wood based materials and suitable plastic and aluminum profiles. Versions of this product are available for different requirements.
702.7.00	100,000	120-140	< 5	For lamination of films, veneers and laminates with higher material tensions to wood based materials and suitable plastic and aluminum profiles.
702.8.00	60,000	120-140	< 10	For lamination of films, veneers and laminates to wood based materials and suitable plastic and aluminum profiles. Versions of this product are available for different requirements.


window profile wrapping


interior


flooring/wall elements


window sills

Primer

Product	Viscosity at 20 °C [mPa·s]	Solvents according to Hazardous Material Regulation	Flam-mable	Application method	Application
831.0.00	20	methylene chloride	no	primer felt pad	Fluorescent primer for wrapping PVC and aluminum profiles
831.4.00	30	solvent mixture	yes	primer felt pad	Fluorescent primer for PMMA profile wrapping and for pretreating acrylate films
842.0.00	15	solvent mixture	no	primer felt pad and vacuum technology	Fluorescent primer for wrapping PVC profiles with PUR hotmelt
842.1.00	20	solvent mixture	no	primer felt pad and vacuum technology	Fluorescent primer for wrapping PVC profiles with PUR hotmelt
842.3.00	20	solvent mixture	no	primer felt pad and vacuum technology	Fluorescent primer for wrapping PVC profiles with PUR hotmelt
848.1.00	10	solvent mixture	yes	primer felt pad	Fluorescent primer for wrapping PVC profiles

Cleaners

Product	Characteristics/Applications
761.6.00	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
761.7.00	Cleaning of tank and drum melters, gear pumps and transport hoses, metal application units (e.g. slot nozzle, roller)
823.3.05	Cold cleaner for removal of hardened adhesive residue on machine parts, tools and devices
826.0.05	Cleaning liquid for removing cured adhesive residue using heat

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.

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

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