



Hot Melt Adhesive 774.4

Medium-viscous adhesive with high initial tack

Fields of application

Bonding of

- Primed polyester edges
- PVC, PP and ABS edges with pre-treated back
- Resined impregnated paper edges
- Massive and veneer edges

Advantages

- Universal use
- Good post-melt properties

Properties of the adhesive

Base:	EVA copolymers
Specific weight:	approx. 1.4 g/cm ³
Viscosity	
Brookfield HBTD	
Sp. 27/ 10 rpm:	
at 200° C	65,000 ± 10.000 mPa s
at 220° C	55,000 ± 10.000 mPa s
Melt index according to DIN 53 735 (MFI 150/2,16):	50 ± 15 g/ 10 minutes
Softening point (ring + ball):	100 ± 5° C
Application temperature:	200-210 °C
	Low temperatures cause faulty bonding, higher temperatures - maintained for a long time - may damage the adhesive and lead to decomposition. Therefore ensure correct temperature!
Delivery form:	granules
Colours available:	ivory-20
Identification:	not required according to the German hazardous substances regulations GefStoffV (see our safety data sheet)

Attention:

When hot melt 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.

Application devices

- Automatic edge banding machines with roller application
- Automatic edge bonding machines with sword nozzle application

Application techniques

The substrates for edge banding must be processed at exactly right angles and must be free from dust. Boards as well as edge materials have to be acclimatised to room temperature. The most favourable moisture content of the wood is 8-10%. The room temperature must not be lower than 18° C. Draught has to be avoided.

Temperature control:

Regularly check the temperature directly at the application system by means of a laboratory thermometer, a bimetal thermometer or by a thermometer with electric contacts. Readjust it, if necessary.

The thermometers installed in the machine may give incorrect readings after extended use.

Line feed:

20-40m/min.

Higher speeds only after own testing.

Application quantity:

The quantity to be applied should be adjusted in such a manner as to slightly show on the edge of the part to be glued. In order to check whether the adhesive film is continuously applied, a strip of transparent rigid PVC can be used.



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Post-treatment:

The bonded material can be further processed immediately after application (sawing, routing, planing etc.).

Cleaning

Tools can be cleaned with KLEIBERIT Cleaner 827.0.

Packaging

KLEIBERIT Hot Melt Adhesive 774.4:

Bag, 25 kg net

KLEIBERIT Cleaner 827.0:

metal canister, 4.5 kg net

Storage

KLEIBERIT Hot Melt Adhesive 774.4 can be stored for approx. 2 years. Keep in a cool and dry place.

EX 1101; replaces previous data sheets

Waste Disposal

Disposal of contents and/or containers should comply with all applicable federal, state and local regulations.

Our containers are made of recyclable material.

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