Product Information Sheet

CP-0602 (KL-704.2)

PUR HM Cart. 105 sec.

Application Temperature(s):	110-140°C
Color:	White
Freeze Thaw Stable:	N/A
Min Use Temperature:	N/A
Shelf Life:	See storage
Solids (~):	NA
Specific Gravity (~):	Approx 1.1 g/cm³
Viscosity:	(on day of production) Brookfield HBTD 10 rpm @ 120°C 23.000±5.000 mPa s at 140°C 12.000±3.000 mPa s

Characteristics:
Reactive hot melt based on polyurethane (PUR) for profile wrapping.
Base: Polyurethane
Advantages: Suitable for outdoor applications, very high initial tack, very quick setting properties, heat resistance of more than 150°C (according to the material used), low temperature resistance, less than -40°C (according to the material used), resistant to steam and boiling
Because of the variety of PVC profiles, preliminary tests should be done.
It is available in tightly fitting metal containers, suited for melting systems. The application aggregate for the hot melt adhesive should protect the adhesive from any humidity.
Packaging: Cartons with 12 cartridges of 300 g net each, cartons with 4 aluminum cans of 2 kg net each, steel pails with 18 kg

Applications:
Fields of application: Wrapping PVC profiles, yellow chromatised aluminum profiles and wood based profiles with PVC foils, decorative papers and veneers (also fleece laminated)

Directions:
Pay particular attention to a precise temperature control of the entire unit. (Inspect first run and record result). The adhesive is applied to the back of the foil or the veneer section by a roller, doctor blade or slot nozzle.
Application quantity: PVC foil 30-50 g/m², Decorative papers 50-70 g/m², Veneers 80-100 g/m²
Rate of feed: from 20 m/min
The rate of feed is dependent upon the materials used and the shape of the profile. The final strength is achieved after approx. 7 days.
The primer dry fairly quickly. The primer application - a very thin film - is performed by a continuous system in the primer station of the wrapping machine. To improve efficiency of the process, we recommend the use of a tandem primer station, installed along the line of feed. The drying process may be supported by heating devices or hot air blowers which must be installed in front of the wrapping zone. When using yellow chromatised aluminum, the chromated surface itself may not be more than 4 weeks old. The surface of the PVC aluminum section must be warmed to 40°C immediately before the wrapping process is started.
Special notes on PVC window profiles: Wait two weeks after wrapping before performing weatherproofing tests or a glycerine test (5 minutes in a bath of glycerine heated to 130°C) (see also the special processing guide)

Chemical cross linking of PUR hotmelts requires moisture. Therefore, sufficient air humidity has to be present during processing.
Application devices: Cartridge pistols for manual use, bulk melting systems with a carbon-dioxide blanket, barrel for 20 and 200 litre barrels

Clean Up and Storage:

After finishing work, empty contents of aggregate or drain off the remaining adhesive. Use hot melt cleaner feed immediately, melt and rinse the emptied aggregate, until all traces have been removed. Cross-linked hot melt adhesive can only be removed mechanically.
Can be stored in factory sealed containers for the following periods: Cartridges: approx. 12 months, Aluminum cans: approx. 12 months, Pails: Approx. 9 months. Protect from humidity

Key Warnings:

Identification: Identification required according to the German hazardous substances regulations GefStoffV contains diphenylmethane-4.4'-diisocyanate (see our safety data sheet)
Hot melt adhesives release vapours, even if the prescribed working temperature is observed. Consequently, unpleasant odours can occur. If the indicated working temperatures are exceeded for a longer period of time, harmful decomposition products can develop. Therefore, measures for the elimination of the vapours have to be taken, i.e. by means of a suitable ventilation/exhaust device.
Waste disposal: Disposal of contents and/or containers should comply with all applicable federal, state and local regulations.