



# Edge Banding

With KLEIBERIT PUR hotmelt adhesives, the possibilities for using design edges are unlimited and reliable

## KLEIBERIT PUR Hotmelt

### KLEIBERIT 707.6

Reactive PUR hotmelt adhesive

- High temperature resistance from -30°C up to 150°C
- Very high humidity, water and steam resistance

### KLEIBERIT 707.7

Reactive PUR hotmelt adhesive for highly durable bonding of edges

- Optimal bond on edges which are otherwise difficult to bond
- High temperature resistance from -30°C up to 150°C
- Very high humidity, water and steam resistance
- Excellent strength, also when exposed to steam

### KLEIBERIT 707.9

Reactive PUR hotmelt adhesive

- High temperature resistance from -30°C up to 150°C
- Very high humidity, water and steam resistance
- All raw materials used comply with Directive 2002/72/EG for products which are intended to come into contact with food

## KLEIBERIT PO Hotmelt

### KLEIBERIT 754.0

For bonding straight edges, softforming and direct postforming

- high temperature resistance between -30°C and 140°C depending on edging material
- Very high green strength
- Application with roller or slot nozzle
- Excellent properties for CNC processing centres



## KLEIBERIT EVA Hotmelt

### KLEIBERIT 773.3

"Universal" and "transparent" for nearly all edging materials

- Absolutely no stringing – so smearing during routing
- Very good pre-melting properties for high line speeds up to 10-30 m/min
- Suitable for difficult softforming profiles with a tight radius
- Transparent – invisible glue line

## ADHESIVES

In the edge banding field, the adhesive requirements of the furniture industry are constantly increasing, especially regarding faster application, temperature and heat resistance, shapes and materials.

Suitable adhesive systems for edge banding are:

**Reactive PUR Hotmelts**  
(polyurethane):

- Besides the physical setting there is a chemical cross linking
- Much higher temperature and moisture resistance from -30°C up to 150°C

**EVA Hotmelts**

**PO Hotmelts**

(Ethylene-vinyl acetate and polyolefin):

- Based on thermoplastic synthetics or resins which set purely physical
- Reach strength immediately after cooling and setting/crystallisation
- Temperature resistance from -30°C to 140°C

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**KLEIBERIT EVA Hotmelt**

**KLEIBERIT 773.7**

Thermoplastic synthetic resin adhesive for polyester, CPL and melamine resin, veneer, paper, PVC and ABS edges.

- Very good melting properties
- Transparent joint
- Suitable for softforming processes and bonding in CNC processing centres (easy edge)
- Temperature resistance between -30°C and 100°C (depending on edging material)

**KLEIBERIT 773.8**

Thermoplastic hotmelt adhesive for edge-banding on CNC and continuous flow equipment

- Good melting properties
- Very clean processing
- No stringing
- Very high green strength

**KLEIBERIT 774.4**

For bonding primed polyester edges, PVC and ABS edges, veneer and paper edges.

- For line speeds from 20 up to 60 m/min
- Medium viscosity
- Good green strength

**KLEIBERIT 777.0**

Universal adhesive for bonding straight edges and softforming. Highly recommended for softforming with veneer edges and direct postforming

- High heat resistance up to 110°C depending on edging material
- Extremely good adhesion to primed PP edges and solid wood edges

**KLEIBERIT 779.6**

Universal for nearly all edge material.

- For line speeds from 20 to 70 m/min
- Suitable for pre-coating edges

**KLEIBERIT 779.7**

Universal for softforming / straight edges; pre-coating.

- Especially recommended for softforming
- For line speeds from 15 to 70 m/min

**KLEIBERIT Products in HolzHer Cartridge Systems**

Hotmelt adhesives in cartridge form with easy slide coating for HolzHer cartridge systems.

- Increased adhesive flow
- Problem-free cartridge melting, no residue

KLEIBERIT 707.6, 707.9, 773.8, 779.6 and 782.0 are available in cartridges for HolzHER systems.

**Application**

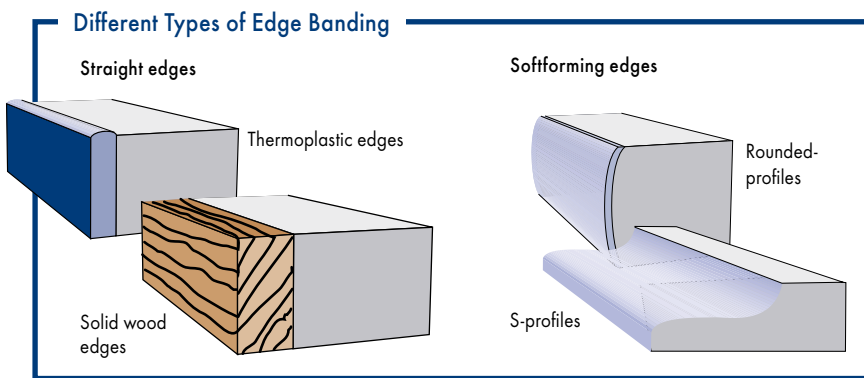
Hotmelt adhesives for bonding of edges and softforming have a medium or high viscosity, in order to fill the gaps in the middle layer of the chipboard and to achieve good strength across the whole width of the board.

Quick crystallisation in the press is necessary to avoid smearing during flush milling. The green strength of hotmelt adhesives must be very high, especially for softforming processes, so that the memory of the edging materials cannot cause the glue line to open.

Edge banding adhesives are free flowing and therefore do not cause blocking in the granulate pre-melter.

Edge banding hotmelts are melted in granulate premelters which are usually situated directly above the application system. The premelted adhesive is guided (level-controlled) through a heated hose into the application basin. The application is either with roller or with a nozzle.

For straight edges the adhesive is usually applied on the chipboard, for softforming always to the edging material.



**KLEIBERIT Adhesives for Edgebanding**

KLEIBERIT	type of machine Product	manual or slow edge banding machines	usual edge banding machines >18m/min		high-speed edge banding machines		CNC-processing center	contour edge banding machines	
			straight edges	soffforming	straight edges	soffforming		straight edges	soffforming
EVA Hotmelts	773.3		■	■	■	■	●	●	●
	773.7	●	■	■	●	●	■	■	▼
	773.8		■	■	■	■	■	●	●
	774.4		■		●				
	777.0		■	■			▼		
	779.6		■	●	▼	●	▼	●	●
PO-HM	754.0	●	■	■	■	■	■	●	●
	707.6	▼	■	■	■	●	■	■	■
PUR-HM	707.7	▼	■		■	●	■	■	■
	707.9	▼	■	■	■	●	■	■	■

■ very well suited    ▼ well suited    ● possible