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Competence **PUR**

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# Surface Lamination

with liquid adhesives



Polyurethane • PVAC • EVA • Urea • Melamine

Competence **PUR**



# Surface bonding and lamination

with liquid adhesives

Surface bonding is used in a multitude of different industries: the building, automotive and furniture industry are only some examples. Depending on the range of requirements, the substrates to be bonded and the technical process, a wide variety of different adhesive systems are available.

### 1C PUR Adhesives (One Component Polyurethane)

1C PUR is highly recommended wherever joint filling and thermosetting properties are required. With its outstanding adhesion, only 1C PUR allows to join various materials such as wood, metal and plastic with smooth or coarse surfaces, in a simple process, providing bondings on highest quality levels. 1C PUR has been the preferred system for sandwich elements, insulating boards etc, made of wood, ceramic, concrete or rigid foams.

**Application:** 1C PUR liquid adhesives can be applied both manually (spatula, glue roller) and automatically. The automatic application techniques typically includes spraying or application of multiple beads next to each other.

### EVA Dispersions (Ethylene Vinyl Acetate)

Provides a hard elastic glue line after setting.  
For lamination of papers or PVC foils (loudspeakers and furniture).

### PVAc Dispersions (Polyvinyl Acetate)

Provides a hard glue line after setting.  
For bonding of veneer to a variety of wooden substrates.



































### Urea and melamine resin adhesives

for surface bonding of veneers, production of contoured parts made from multi layer veneer and parquet and door production etc.

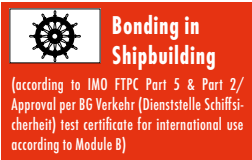
**Application:** Urea and melamine resin adhesives are sold as powder and mixed with water, hardeners and sometimes fillers - according to the recommend mixing ratio - before use. The mixed adhesive is normally applied with glue rollers. Another possibility is the application of beads using a so called "curtain coater".



### Standard Adhesives for surface bonding /lamination

Products	Sandwich-elements	Parquet		Lamination of large surfaces			Multi-layer veneer production	Properties
		2-layer	3-layer	on wood				
				PVC	paper	veneer		
KLEIBERIT 501.0 								D4 according to DIN/EN 204; joint-filling, high temperature resistance according to WATT 91 > 9 N/mm²
KLEIBERIT 502.8								short press times suitable for combination bondings
KLEIBERIT 303.0 								universal use D3 quality according to DIN/EN 204
KLEIBERIT 332.0 								long open time 20-25 minutes (at 20° C)
KLEIBERIT 453.0								especially for foil and paper lamination; suitable for cold and thermo lamination
KLEIBERIT 464.0								suitable especially for lamination of foils and paper; for cold and thermo-lamination
KLEIBERIT 871.0								E1 quality short press times
KLEIBERIT 881.0								special-purpose adhesive for production of 3-layer parquets; fulfills all requirements

■ very well suited ▼ well suited ● technically possible



### KLEIBERIT Polyurethane adhesives

#### KLEIBERIT 501.0

- moisture curing adhesive
- recommended for all common building components
  - approval for marine applications
  - certified water resistance D4 according to DIN/EN 204 (for exterior use)
  - highest temperature resistance according to Watt 91 > 9N/mm²
  - excellent joint filling
  - medium to long open time systems available (from 8-70 min.)

#### KLEIBERIT 502.8

- moisture curing adhesive
- hard elastic glue line (suited for various foam composites)
- high water resistance
- excellent temperature resistance
- short to very long open time systems available (from 6-120 min.)



### KLEIBERIT Dispersion Adhesives

#### KLEIBERIT 303.0

- Universal dispersion on PVAc basis for surface bonding of veneers and HPL materials
- approval for marine applications
  - bonding quality D3, with hardener 303.5 D4 according to DIN/EN 204
  - very good ratio open time/pressing time
  - outstanding processing performance using application machines

#### KLEIBERIT 332.0

- Special dispersion on PVAc basis for veneering
- extended open time up to 20-25 min. for manual applications
  - approval for marine applications

#### KLEIBERIT 453.0/464.0

- Dispersion on EVA basis for surface lamination of PVC and paper foils
- very good processing performance
  - suitable for cold and thermo lamination
  - very smooth surface - no telegraphing through papers
  - brilliant optic also with thin foils



### KLEIBERIT Urea and melamine adhesive

#### KLEIBERIT 871.0 hot press glue

- urea resin adhesive with built-in hardener
- easy to mix
  - low formaldehyde content E1
  - short pressing times

#### KLEIBERIT 881.0 hot press glue

- urea resin adhesive with built-in hardener. Suitable for the production of 3 layer parquet.
- A 100 quality
  - very high bond quality