

# Hot Press Glue 862.0

## *with built-in hardener*

### Thermosetting urea resin glue in powder form for very short press times

#### Fields of application

- Bonding of veneers
- Bonding of plywood
- Suited for veneers made of hard and soft wood

#### Advantages

- Well soluble, bleeding through can be avoided to a large extent
- Mix with water - immediately ready for use
- Good application properties - high yield

#### Properties of the bond

- When using emissions class E1 chipboard, when complying with our processing instructions and with press temperatures of at least 100°C, values for emissions class E1 are also achieved after veneering

#### Properties of the glue powder

<b>Base:</b>	urea formaldehyde condensation resin
<b>Delivery form:</b>	powder
<b>Colour:</b>	white
<b>Identification:</b>	identification not required according to the German hazardous substances regulations GefStoffV (see our safety data sheet)

#### Application methods

- With spatula
- With manual gluing devices
- With glue spreading machines

### Application techniques

#### Mixing proportion:

100 parts by weight of glue powder  
 50 parts by weight of water (18-20° C)  
 (or dosed by means of a measuring cup:  
 3 parts by volume of glue powder  
 1 part by volume of water (18-20° C)

The quantity of water may be slightly varied. A higher viscosity of the glue mixture can be achieved by adding rye flour (10-30 %). Mixing vessels made of glass, plastic or aluminium are suitable. First insert the glue powder into the mixing vessel, then add approx. 2/3 of the water. Stir with stirring spindle or suitable tool until the mixture is free from lumps, then add the remaining water. The glue mixture is ready for use immediately.

#### Consistency of the glue mixture:

May be varied from viscous to fluid, depending on the nature of the veneers.

#### Service time of the glue mixture:

at 20° C approx. 2.5 hours  
 at 30° C approx. 45 minutes

#### Application quantity:

Depending on the surface quality and absorbability of the substrate material 100-150 g/ m<sup>2</sup> must be applied.

#### Assembly time:

The time between glue application until feeding into the press can be about 5 minutes.

#### Feeding time:

The feeding time until closing of the press is about 1 minute

**The higher the temperature, the shorter the feeding time.**

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### Intensity of pressure:

0.3 - 0.8 N/ mm<sup>2</sup> (3-8 kp/cm<sup>2</sup>)

### Press time:

at 20° C: 4.5 hours

at 40° C: 50 minutes

Press temp. ° C	base time	heating time/ veneer thickness minutes/ mm
60	6 min	2
80	2 min	2
90	70 sec.	1
100	40 sec.	1
110	35 sec.	1/2

The total press time consists of base time and heating time. The values given are based on normal processing conditions at a moisture content of the wood of 8-10 %. Exceptionally long parts which are projecting can be pushed into the press within a period of approx. 5 minutes (staggered pressing).

### Cleaning

It is recommended to clean the work tools with cold water.

### Packaging

Bag, 25 kg net

### Storage

KLEIBERIT Hot Press Glue 862.0 must be kept airtight and in a cool and dry place.

Shelf life in factory sealed containers:

at 20° C approx. 6 months,

at 30° C approx. 2 months

EX0509, 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.

#### Service

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.