



Hot Press Glue 871.0

Low formaldehyde content

Urea resin glue in powder form, prepared for processing, built-in hardener. Meets the requirements of stressing quality IF according to DIN 68 705

Fields of application

- Bonding of veneers on standard chipboard, non-flammable A2 boards and other wooden materials
- Bonding of veneers
- Bonding of surfaces

Advantages

- Soluble, bleeding through can be avoided to a large extent
- Long pot life
- Ready for use as soon as mixed with water
- Favourable viscosity for processing

Properties of the bond

- Bond strength corresponding to stressing quality IF according to DIN 68 705 can be achieved
- When using chipboards of emission class E1 for veneering under compliance with our application instructions and at press temperatures of minimum 100 °C, values of emission class E1 can afterwards also be obtained.

Properties of the glue powder

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

Application methods

- With spatula
- With manual glueing devices

Application techniques

Mixing proportion:

100 parts by weight of glue powder
50 parts by weight of water (18-20° C)

The quantity of water may be slightly varied.

Mixing vessels made of glass, plastic or aluminium are suitable. First empty 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.

The glue mixture has to be somewhat thicker for bonding A2 board (100:30 parts by weight)

Attention, pot life is reduced!

Consistency of the mixture:

varies from viscous to fluid depending on the nature of the veneers.

Service time of the glue mixture:

at 20° C approx. 8 hours
at 30° C approx. 3 hours

Application quantity: Depending on the surface quality and absorbability of the substrate material, 100-150 g/m² must be applied.

Assembly time: The time between glue application until feeding into the press can be as much as 10 minutes.

Feeding time:

The feeding time until closing the press is
1-2 minutes

The higher the temperature, the shorter the feeding time!



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Intensity of pressure: 0.2 - 0.6 N/mm²

Press time: press temperature in ° C	base time in minutes	heating time/veneer thickness in minutes/mm
70	8	2
80	6	2
100	3	1
120	2,5	0,5

The total press time consists of base time and heating time. The values given are based on normal processing conditions and a moisture content of the wood of 8-10 %. Exceptionally long parts which are projecting out of the press, can be pushed into the press within a period of approx. 15 minutes, (staggered pressing).

Cleaning

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

Packaging

KLEIBERIT Hot Press Glue 871.0:

Bag, 25 kg net

Storage

KLEIBERIT Hot Press Glue 871.0 must be kept airtight and stored in a cool and dry place.

Shelf life in factory-sealed containers:

at 20° C approx. 6 months

at 30° C approx. 2 months

EX0999; replaces earlier 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.