

# Bonding of edges

## KLEIBERIT EVA-Hot Melt

### KLEIBERIT EVA-HM 774.4

bonding of primed polyester edges, PVC and ABS calendar edges, veneer and paper edges.

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

### KLEIBERIT EVA-HM 779.6

Universal hot melt adhesive for nearly all edge material

- For line speeds ranging from 10 to 70 m/min
- Suitable for pre-coating edges

### KLEIBERIT EVA-HM 788

for manual and slow moving edge banding machines.

- Very long open time
- Application possible from 160°C
- Large field of application
- Suitable for processing in humid and warm regions

### KLEIBERIT EVA-HM 779.7

Universal hot melt adhesive for softforming / straight edges; pre-coating

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

### KLEIBERIT EVA-HM 777

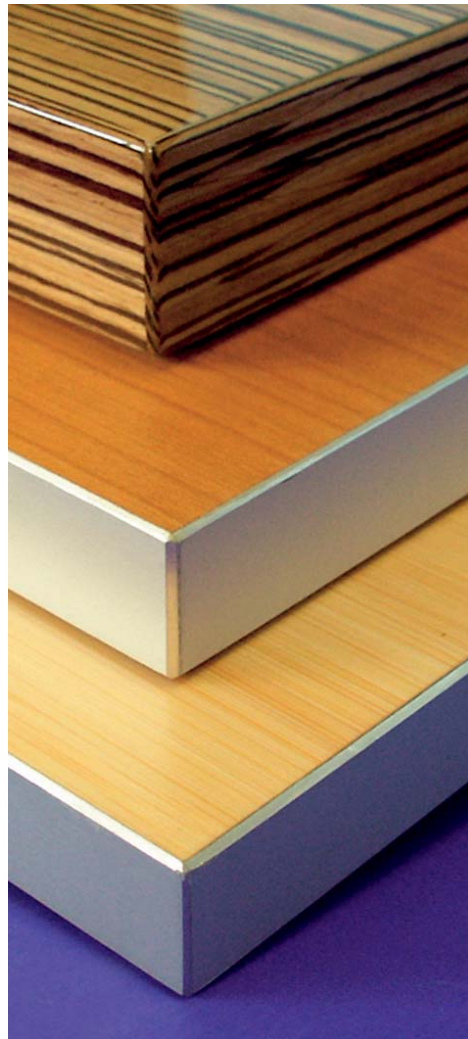
Universal adhesive for bonding straight edges and softforming. Highly recommended for softforming with veneer edges and direct postforming

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

### KLEIBERIT EVA-HM 773.1

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

- Absolutely no stringing - so smearing during routing
- Very good remelting properties - high line speeds up to 80 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:

### EVA hot melts

#### PO hot melts

(Ethylene-vinyl acetate and polyolefin):

- Based on thermoplastic synthetics or resins which set purely physical
- Reach strength immediately after cooling and setting or after crystallisation
- Temperature resistance from -20°C to 110°C (PO)

### Reactive PUR Hot Melts

(polyurethane):

- Besides the physical setting there is a chemical cross linking
- Much higher temperature and moisture resistance from -40°C up to 140°C

### KLEBCHEMIE

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**KLEIBERIT EVA-HM 773.7 HG (Easy Edge)**

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

- Very good melting properties
- Transparent joint
- Suitable for soffforming processes and bonding in CNC processing centres
- Temperature resistance between -20°C and 100°C (depending on edging material)

**KLEIBERIT Supramelt GL 782**

Hot melt cartridge with slide coating for the HOLZ HER cartridge system.

- Increased flow capacity
- Trouble-free melting of the adhesive without any residue

- Very high green strength
- Application with roller or slot nozzle
- Excellent properties for CNC processing centres

**KLEIBERIT PUR Hot Melt**

**KLEIBERIT PUR 707**

Reactive PUR hot melt adhesive

- High temperature resistance from -30°C up to 140°C
- Very high humidity, water and moisture resistance
- Available in white or transparent
- Suitable for bonding aluminium edges

**Application**

Hot melt adhesives for bonding of edges and soffforming 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 plain routing. The initial green strength of the hot melt adhesives must be very high, especially for

soffforming 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 hot melts 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 done with an application roller or with a nozzle.

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



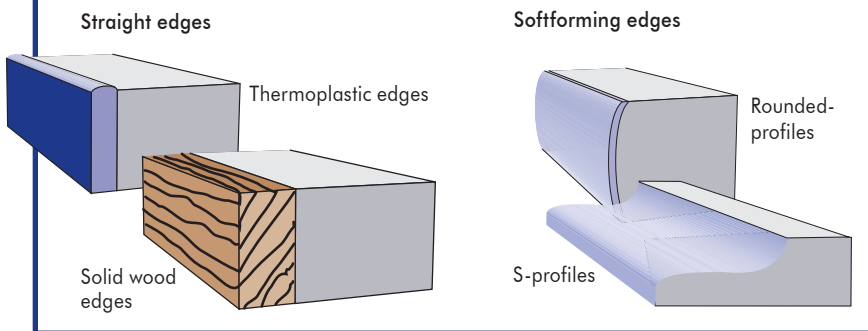
**KLEIBERIT PO-Hot Melt**

**KLEIBERIT PO 753.5**

for bonding of straight edges, soffforming and direct-postforming

- high temperature resistance between -20°C and 120°C (depending on edging material)

**Different types of Edgebanding**



**KLEIBERIT adhesive systems for bonding of edges**

KLEIBERIT	Product	type of machine manual edge bonding machines or low line-speeds in common	usual edge bonding machines >18m/min		high-speed edge bonding machines		CNC-processing center	conture edge bonding machines	
			straight edges	soffforming	straight edges	soffforming		straight edges	soffforming
EVA Hot Melts	HM 773.1		■	■	■	■	▼	▼	▼
	HM 773.7	●	■	■	●	●	■	■	▼
	HM 777		■	■			▼	▼	▼
	HM 779.6	●	■	●	▼	●	▼	●	●
	HM 779.7		■	■	▼	▼	▼	●	●
	HM 779.8				■	■			
	HM 774		■		●				
	HM Supramelt GL 782		■	■	●	●	●		
	HM 788	■	▼	▼				▼	■
PO-HM	HM 753.5	●	■	■		■	▼	■	
PUR-HM	HM 707.9	▼	■	■	▼	●	■	■	●
	HM 707.7	▼	■		▼	●	■	■	▼

■ very well suited    ▼ well suited    ● possible