

**Veneer / Fleece Laminating**

**KLEIBERIT PUR-HM 702**

**Glue joint**

- Water free
- Higher flexibility
- Higher water and temperature resistance
- No veneer discolouration



**Production cost**

- Increased line speeds up to 100 m/min
- Machine can also be used for multi-layer veneer
- Low coat weights to 35 g/m<sup>2</sup>

**Compatibility**

- PUR is compatible with EVA and PO hot melts

**Multi-layer Veneer**

**KLEIBERIT PUR-HM 702**

**Glue joint**

- Water free
- Higher flexibility
- Higher water and temperature resistance
- No veneer discolouration
- High green strength



**Production cost**

- Increased line speeds up to 25-80 m/min
- Energy savings - no pre-heating or heated press rolls are needed
- One-sided adhesive application



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# KLEIBERIT HotCoating<sup>®</sup>

## Surface Refinement of Veneer/Paper Fleece Laminating



INFORMATION

With **KLEIBERIT PUR HC 717**, the company KLEBCHÉMIE developed a new technological process which:

- revolutionises surface sealing
- achieves a surface which enhances the natural optic and haptic of solid wood
- significantly simplifies the complete process

HotCoating is the process in which **KLEIBERIT PUR HC 717** is applied to the surface. Even with low coat weight, the coating has high wear resistance and shock resistance. The coat weight and the degree of gloss can be adjusted to customer requirements.

The **KLEIBERIT HotCoating<sup>®</sup>** process is not only uncomplicated and easy to operate, there are also no VOC or formaldehyde emissions.

HotCoating – this process offers a wide variety of advantages:

- Singular application
- No interim sanding
- 100 % solids
- Smaller production areas
- Lower capital expenditure
- Reliable production
- Variable
- High scratch resistance (> AC5)

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# KLEIBERIT HotCoating® ...

The alternative to laquering ...

## HotCoating of Veneer / Paper

### Up to now...

Continuous veneer is produced from finger jointed veneer. Fleece backed roll material is being used in the furniture industry for the wrapping of profiles and similar items.



After wrapping, **further processing steps** are required to complete the surface effect:

- Sanding of the profile
- Base coating of the profile
- Sanding of the profile
- Sealing / lacquering

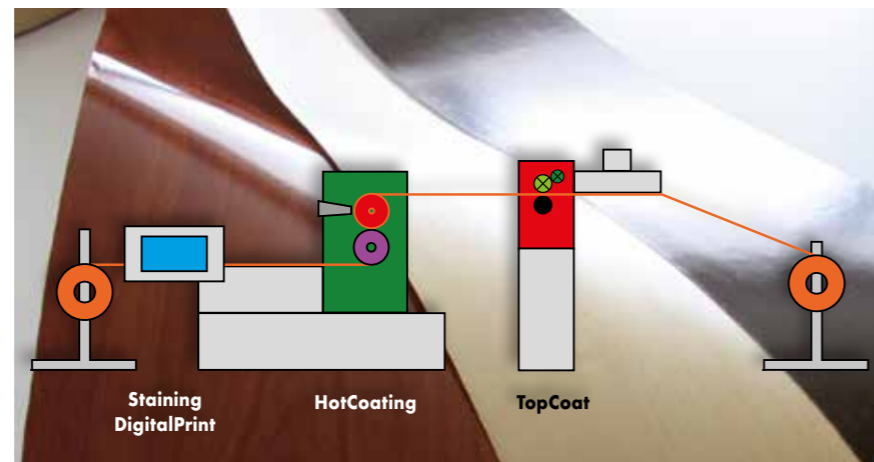
Complex and difficult profiles require either expensive multi axle machinery or have to be produced by hand.

Using HotCoating technology, a product is "ready to sell" after wrapping, without requiring further processing.

### From today...

The **KLEIBERIT HotCoating®** technology, which seals the veneer surface in only one work process, is based on a PUR coating of the surface and has these advantages:

- Good flexibility after curing
- High UV stability
- Very high scratch resistance
- Suitable for tight wrapping radiuses



The unique advantage of this technology is:

### Only 1 work process

- No sanding of the profile
- 100% solid content
- Low capital expenditure for machinery
- Multi functional application system i.e. a combination with fleece lamination or veneer doubling

## Application

**HC 717** is applied onto roll material with a special slot nozzle which creates a very smooth and streak-free film. Beforehand, the desired pattern or colouring can be applied through inline staining or printing processes. After application of the UV hardening topcoat, the roll material can be immediately wound and is ready for further processing.

The end product is veneer or paper with a finished, refined surface which distinguishes itself through extraordinary flexibility. Complex profiles with tight radiuses can be wrapped **without problems** and are afterwards "ready to sell".

## Decorative Surfaces/Digital Print

In profile wrapping, diverse decorative papers and foils are being used in addition to real wood veneer.

The first trends and imminent future use of printing technology shows individual and creative design which can also be realized with smaller lot sizes.

**KLEIBERIT HotCoating®** offers many possible combinations in laminating and printing technology.



The very good bonding properties of **PUR HC 717** to paper, print colours and lacquer systems allows for the use as protective refinement or as the sealing basis for printing.

## KLEIBERIT HotCoating® for Exterior Applications

The expert opinion regarding exterior coatings is clear - the number 1 characteristic required before anything else is:

### FLEXIBILITY!



**HotCoating** boasts flexibility which is far from conventional coating systems and furthermore offers very good weathering protection.

Very high water resistance and excellent adhesion in a wet state predestine HC as the protective layer for dimensionally stable building components.

With this technology, window systems, plywood or facade elements have a surface which maintains its protective function even with swelling, shrinking and mechanical stress. Decorative colouring and combinations with conventional staining or lacquering technology is also possible.

A nearly perfect combination shows building components which are pre-treated with **KLEIBERIT PUR 555** and **KLEIBERIT HC 717**.

**KLEIBERIT PUR 555** is a reactive PUR system which deeply penetrates components and has excellent properties for reinforcing softwood, repelling water and as a flame retardant.

When a surface is coated with **HC 717** after pre-treating, it is an extremely weather stable component with a refined surface suitable for exterior weathering.



### HotCoating High Abrasion Resistance and Flexible

**KLEBICHEMIE** has further developed the innovative HotCoating technology. The industry can now use a HotCoating coating with the highest abrasion resistance reaching the highest abrasion class (>AC5) according to DIN EN 13329. It is still applied in one simple step with uncomplicated application technology. Users can now, on their own, produce highly scratch resistant paper or veneer which is very processable. The characteristics open new possibilities in the market:

- Flooring
- Transition Profiles
- Mouldings
- Window Sills

Product	Application	Basis	Viscosity [mPas] at 120 °C at 140 °C	Application temperature	Coat weight	Colour	Properties
<b>PUR HC 717.0</b>	Veneer/Paper	PUR	30.000 15.000	100°C - 140°C	25-100 g/m <sup>2</sup>	transparent	• high flexibility • UV resistant
<b>PUR HC 717.5</b>	Veneer/Paper	PUR	16.000 8.000	100°C - 140°C	60-100 g/m <sup>2</sup>	transparent	• high abrasion resistance • up to > AC5 according to EN 13 329 • contains corundum
<b>UV TopCoat 659</b>	Topcoat	Acrylate	20 s (6 mm DIN cup)	20 - 30°C	5-15 g/m <sup>2</sup>	transparent	• various gloss settings