

HOT-MELT EDGE ADHESIVE PELLETS



Hot-melt Edge Adhesive Pellets EVA-based hot-melt adhesive for universal use

Application areas:

Strong adhesive which is used in edge-banding machines for adhering PVC, ABS, Polyester, HPL and Melamine edgeband.

Application:

Environment temperature must be around 15°C during the application process. Adhesive must applied to one surface of the material to be adhered. Air humidity should be between 65% and 75% and product humidity should be between 8% and 10%.

Humidity in Product: 8 - 10%

Humidity in Air: 65 - 75%

Ambient temperature: > 15°C

Tank temperature: 180 - 200°C

Roller temperature: 180 - 200°C

Content [Kg]	Colour	Art. No.	U/E
25	Yellowish	892 125 537	1
20	Yellowish Transparent	892 125 311	1
20	Transparent	892 125 312	1

Technical Characteristics:	
Colour	Yellowish, Yellowish Transparent, Transparent
Appearance	Granular
Brookfield Viscosity [Yellowish]	90000 +/- 15000 mPa.s (190°C spindle 29, 50 rpm)
Brookfield Viscosity [Yellowish Transparent]	55000 +/- 10000 mPa.s (190°C soindle 29, 50 rpm)
Brookfield Viscosity [Transparent]	60000 +/- 10000 mPa.s (190°C soindle 29, 50 rpm)
Softening Point [Yellowish]	100°C +/- 5°C
Softening Point [Yellowish Transparent]	100°C +/- 3°C
Softening Point [Transparent]	90°C +/- 1°C

Recommendations:

The temperature inside the adhesive tank should be considered, and be controlled frequently due to changes in weather and conditions. During season changes adhesive temperature must be measured by thermometer devices.

The temperature of the application surface and environment must be higher than 15°C, otherwise successful results cannot be acheived due to faster drying time.

Adhesive tank should be cleaned frequently. The amount of the adhesive, which is applied on the surfaces, can vary due to type of the materials. Some undesired results may occur such as over usage and inadequate usage. In these cases, glue setting should be applied.

In case of giving a pause, adhesive temperature must be bonded at 100-110°C to keep performance higher.

Shelf life is 24 months at normal room temperature. (18-20°C).