EVA hotmelt

284.00/01

Application examples:

Edge bonding For bonding thermoplastic edge tapes (such as ABS, PP, PVC), resin-coated decorative paper and veneer edge tapes (with fleece lamination). In principle, the bonding properties and, if necessary, the backside priming of the edge materials must be checked for the application before use.

Processing notes:

Automatic conveyor systems can be used to process the adhesive granules. An ambient temperature of 30 °C should not be exceeded.

Depending on the formulation, different types of hot melts may be incompatible with one another. We therefore recommend cleaning the application equipment carefully when changing products.

Further information is available upon request. The processing properties can vary depending on the application technology used and also with different feed speeds, which can have an impact on the bonding process.

Customer trials are required!

Typical characteristics:

Processing temperature [°C]: 190 - 200 Feed speed [m/min]: 20 - 60

Appearance: Final digit 0 = beige Final digit 1 = white

Softening range [°C]: approx. 90 ± 5 (Kofler heating bench) Heat level [°C]: approx. 80 ± 5

Open time at 200 °C [s]*: approx. 8 ± 1

Setting time: not applicable * measured on a 200 µm film Characteristics determined according to Jowat test methods.

Requirements for a high-quality bonding process:

The properties of the materials (e.g. surface tension, plasticizer content, ...) and their conditioning as well as the processing conditions (e.g. ambient temperature, humidity, ...) influence the joining process and bonding.

Your own tests, taking everyday conditions into account, are therefore essential in order to define process-reliable parameters and ensure the usability of the product. For ideal bonding, the materials to be bonded should be free of dust, oil, grease and dry.

The wood moisture content should be between 8 - 10%. The minimum temperature should ideally be 18 °C.

Drafts should be avoided.

Our application technology department and application consultants offer technical support in selecting a product that meets your requirements. Please note our information under “Comments”. As a suggestion for establishing high-quality bonding processes, we refer to DIN 2304.

Specification:

Viscosity at 200 °C [mPas]: 116,000 ± 20,000 (Brookfield, Thermosel, Spindle 29, 5 RPM)

Density at 20 °C [g/cm³]: 1.45 ± 0.06 (pycnometer, 100 ml)

The values are always determined on the day of production.

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09/21 All information represents average property values. Our technical data sheets are continuously updated to reflect the current state of technology. This edition replaces all previous editions and is valid at the time of issue. Please observe the notes on the last page of this technical data sheet.

Cleaning: Mechanical pre-cleaning when hot (e.g. with a suitable spatula that does not damage the system). Elimination of residues in the application environment when cold using Jowat ® Cleaner 402.40.

Safety instructions: This product, like any other hot liquid, can cause serious burns when molten. Please take appropriate precautions (e.g. using appropriate protective gloves) to prevent the hot adhesive from coming into contact with the skin.

If this happens, immediately cool the affected area with water. Do not attempt to remove the adhesive from the skin and seek medical attention.

Fumes can arise when processing hot melt adhesives that do not require labeling. It is advisable not to exceed the specified processing temperature in order to keep the development of steam as low as possible.

Extraction is recommended, particularly for open application systems.

Storage: Store in closed, original containers in a dry and cool place. Please refer to the container label for the best-before date. After the best-before date has expired, the suitability of the product for your particular application must be verified again.

Packaging: Information on containers and packaging units can be obtained on request.

Remarks: Further information on safety, handling, transport and disposal can be found in the relevant safety data sheet. The information on this data sheet is based on laboratory tests carried out by us and practical experience reported by our customers.

However, they cannot cover all the parameters that have to be taken into account in the respective application and are therefore non-binding and do not serve as a replacement for the necessary customer tests. The information does not represent a guarantee of quality in the legal sense.

Unless otherwise agreed with our customers, the values listed under "Specification" shall be deemed to be the final agreed product characteristics. No legal claims can be derived from the information contained herein or from the use of our free technical consulting service.

Notes from Jowat

Bonding is becoming increasingly important as one of the most efficient joining techniques and is opening up new areas of application. At the same time, the number of materials that must be joined is increasing rapidly. New processes and equipment for processing adhesives are being developed.

Jowat responds to this continuous change through intensive research and development. A qualified team of chemists and engineers works innovatively to ensure that you receive optimum advice as a customer and the adhesive suitable for your application.

Our information is based on laboratory tests performed by us and on practical experience reported by our customers. However, it cannot cover every parameter that must be considered for a specific application and is therefore non-binding. In every case, please contact our application technology department for the current technical status of the product and request the latest data sheet. Use without this precaution is at your own risk.

The user must therefore test the suitability of the adhesives manufactured by us for the intended application. This applies both to the initial sampling of a product and to changes in an ongoing production process.

We therefore point out to new customers the need to test the adhesives we present on original parts under operating conditions. The resulting bonds must then be exposed to and assessed under the conditions that actually occur. This test is essential.

Customers who make changes in ongoing production are asked to inform us. This is necessary both when changing machine parameters and when changing the substrates to be bonded. Only then can Jowat pass on knowledge corresponding to the current state of knowledge to the adhesive processor.

The information in this data sheet is based on results from practice and does not constitute a guarantee of properties within the meaning of the latest German Federal Court of Justice case law. No binding obligation can be derived from this information or from use of our free technical consulting service.