

727

HOT-MELT ADHESIVE FOR AUTOMATIC EDGE BANDING MACHINES STRAIGHT EDGE BANDING

Description

General purpose hot melt adhesive for straight edge banding - for bonding melamine edgings, paper, plastic laminate, wood veneer, ABS and PVC to chipboard, MDF or wood panels

727 IS CHARACTERIZED BY:

Low viscosity, long open time
Suitable as well for medium-low speed automatic edge banding machines
High adhesion to a wide range of materials

Above characteristics make the adhesive especially suitable for

Use in quick melt equipment
Use on working lines operating at a speed from 15 m/min up to 40 m/min
Bonding on the same working line of edgings of different nature

CHARACTERISTICS

Composition : EVA copolymers, synthetic resins, inert fillers
Shape : granules
Colours : natural, nut

TECHNICAL DATA

Softening point (Ring & Ball) : 98° - 103°C.
Brookfield Viscosity at 210°C : 60000 - 70000 mPa.s.

The values in this table must not to be considered as specifications

APPLICATION

Recommended machine speed: should be at least 15 m/min. High working speed influences favourably bond results. at least 15 m/min.

Application temperature: 200-210°C on to the roller spreader; temperature into the melting tank should be such as to ensure the correct temperature on to the roller when the working line is running. This condition is usually reached at a temperature in the range 170°-190°C, depending on the type of melting tank.

727 is characterized by an excellent melt stability. During work breaks, anyhow, it is recommended to reduce temperature in the melting tank and on to the roller under 160°C, to prevent thermo-oxidative degradation and the need of having recourse too often to cleaning of spreader unit.

In order to reduce risk of charring it is recommended to keep high the level of melt in the tank; this also keeps temperature of the melt from any abrupt change when feeding the tank with additional cold hot-melt granules.

Surface preparation and conditioning of materials: all surfaces of edgings should be clean and dry, free from dust or any contaminants resulting from sanding. If materials to be bonded are stored for some time at low temperature, they should be adequately conditioned in a heated and dry room prior to use.

Coverage: the quantity of hot-melt adhesive to use in order to obtain a good bond is generally in the range 180 and 250 g/m², depending on the nature of edging and substrate.
A larger amount is usually required for thick edgings and chipboard lacking compactness.
A smaller quantity can prove enough in case of thin edgings to apply to solid wood.

Pressure of rollers: in order to get the best bond results, the thicker and harder the edging used, the higher should be the force applied by pressure rollers.

STORAGE STABILITY

Can be stored for 18 months in closed (unopened) packaging in a dry place

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