

# 751

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

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### Description

Excellent adhesion to melamine edgings, impregnated paper, plastic laminate, wood veneer, ABS and PVC to chipboard, MDF or wood panels.  
High yield. Very clear, colourless adhesion line

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### 751 IS CHARACTERIZED BY:

Good performances even in adverse application conditions  
Elastic bonds at low temperatures  
High adhesion to a wide range of materials

### Above characteristics make the adhesive especially suitable for

Bonding difficult surfaces  
Low environment temperature and low feed speed  
Bonding on the same working line of edgings of different nature

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### CHARACTERISTICS

<b>Composition</b>	: EVA copolymers, synthetic resins, inert fillers
<b>Shape</b>	: granules
<b>Colours</b>	: natural, nut, white

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### 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

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### APPLICATION

**Recommended machine speed**: at least 14 m/min. A high machine speed enhances the bonding performances.

**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.

**751** 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.

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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/m<sup>2</sup>, 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.

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#### STORAGE STABILITY

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

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