



Hot Melt Adhesive 773.3

Thermoplastic hot melt adhesive for edge banding on edge banding machines.

Fields of application

Bonding of

- Polyester edges
- CPL and melamine resin edges, also so called thin edges
- PVC and ABS edges (primed)
- Uncompressed resin-impregnated paper edges

Advantages

- Good melting properties
- Very clean processing
- No stringing
- High green strength

Properties of the adhesive

Base:	EVA-Copolymers
Specific weight:	approx. 1.03 g/cm ³
Viscosity (Brookfield HBTD):	
at 180° C:	80,000 ± 15,000 mPa s
at 200° C:	50,000 ± 10,000 mPa s
Melting index according to DIN 53 735 (MFI 150/2,16):	50 ± 10 g / 10 minutes
Softening point (ring and ball):	105 ± 5° C
Process temperature:	
- edge banders:	180 - 200°C
	Lower temperatures may cause faulty gluing, higher temperatures maintained for a long time may damage the adhesive and lead to decomposition.
Delivery form:	granules
Colours:	beige-transparent
Identification:	not required according to the German hazardous substances regulations GefStoffV (see our safety data sheet).

When hot melt adhesives are melted and applied, vapours are set free and an unpleasant odour can occur, even if the recommended working temperature has been observed. Moreover if the prescribed working temperature is exceeded over a longer period, harmful decomposition products can develop. Precautions should be taken to eliminate

the vapours, e.g. by using a suitable ventilation system.

Application devices

- Automatic edge banders with roller applicator

Application techniques

The substrates for edge bonding have to be processed at exactly right angles and must be free from dust. The boards as well as the edges have to be acclimatised to room temperature. The most favourable moisture content of the wood is 8-10 %. The room temperature should not be lower than 18°C. Draughts should be avoided!

Temperature Control:

Regularly check the temperature directly at the application system by means of a laboratory thermometer, bimetal thermometer or by a thermometer with electrical contacts. Re-adjust if necessary. The thermometers installed in the machine may give incorrect reading after extended use.

Speed

Machine speed is 10-30 m/min., depending on width of edges; insufficient speed might result in faulty bondings.

Application quantity

Please adjust application quantities so that the adhesive can be seen at the edges of the bonding. You can check an even glue film with transparent PVC strips.