

PATRONE P2/650 NATUR

Hot melt-cartridge for HOLZ-HER edgebanding machine

Properties

The hot melt Patrone P2/650 NATUR is a thermoplastic synthetic resin, based on EVA, with very good processing-properties on the HOLZ-HER edgebanding machine. This adhesive melts very easily and doesn't draw threads. It is packed in cartridges.

Applications

- Massive round gluing
- veneer edges
- Melamin-resin edges (roll material)
- High pressure laminates
(possible with adhesive agent)
- PVC-edges
(precoated with adhesive agent)
- Polyester-edges (with paper back)

Processing

Adjust the machine in accordance with the instructions of HOLZ-HER. Type and state of the working pieces and the conditions during processing may influence the strength and the resistance of the gluing. Adapt your working system to the conditions of the individual case. Our particulars can should only be indicative values.

The resistance to heat and coldness of the joints depends on the quality of the joints, the wetting power of the edge-strips, the tensions in the material and the interaction time of the temperature.

The carrier-material and the edge-strips have to be cut exactly and to be clean. Wood should have the normal humidity content (8 – 10 %). This is particularly applicable for massive-wood strips.

The parts should have a temperature of +18 °C ... +20 °C. With cool material defective gluing is possible.

Possibly heat up the edge-surfaces before gluing. Although the hot melt joints are extremely water tight, water might reduce or remove the adhesion of melt glues by migration. Edge strips may have very different gluing-properties, also if it is the same group of material. This is why appropriate tests will have to be made at any rate in case of unknown materials or when changing the used edge-material, with a view to testing the suitability of the glues and the adjustment of the machine.

Good results will be achieved if the following conditions are observed:

Room-, material and adhesive temperature	18 ... 20 °C
Wood-moisture	8 ... 10 %
Working temperature	200 ... 220 °C
Feed speed	12 ... 20 m/min

Cleaning

Acmos 100-81 S releasing agent for pressure-rolls

Heat resistance

The heat resistance of Patrone P2/650 NATUR is adequate for all normal requirements for furniture for use in homes as met in cold, moderate, dry-warm and moist-warm climates.

Chemical-technical Data

Patrone P2/650 NATUR

Basis:	EVA-copolymer
Viscosity:	approx. 65.000 mPa.s at 204 °C
Softening point: (using ring + ball method based on ASTM E 28)	approx. 97 °C
Color:	natural

Precaution

Hot melt adhesives release vapors even when the prescribed processing temperatures are observed. These can irritate the respiratory organs. Measures should therefore be taken for the elimination of vapors, e.g. through the use of a suitable extraction system.

Labelling

Patrone K 650 P/2 NATUR is not subject to the marking regulations in accordance with the Dangerous Goods Act in its present version.

Storage

Store Patrone K 650 P/2 NATUR in a cool and dry place. Shelf life is at least 12 months.

Technical stage of development: April 2007

The data of former leaflets which differ from this version are no longer valid.



H.B. Fuller Deutschland GmbH

Henriettenstr. 32
D-31582 Nienburg
Phone: (49) (50 21) 88-0
Fax: (49) (50 21) 88-2 24

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