

Product Information Sheet

CP-0303

Edge Banding Adhesive

Application Temperature(s): 200°C – 210°C (392°F – 410°F)
 Color: Ivory
 Freeze Thaw Stable: N/A
 Min Use Temperature: Refer to Application Temperature
 Shelf Life: 2 years, cool, dry conditions
 Solids (~): NA
 Specific Gravity (~): Specific weight: approx. 1.38 g/cm³

Viscosity:

Brookfield HBTD)sp.27/10tr/mn:
 at 180°C (356°F)
 130.000±22.000 mPas
 at 200°C (392°F)
 80.000±15.000 mPas



Characteristics:

EVA copolymers

Delivery Form: Granules

Thermoplastic synthetic resin adhesive for bonding and pre-coating of edges. Universally applicable. Good remelting properties. Suitable for pre-coating of edges.

Packaging: Bag, 25 kg net

Properties of the bond:

Heat resistance depending on the edge: approx. 80°C (176°F).

(In a drying channel, the bond resists temperatures of up to 120°C (248°F) for a short time)

Cold resistance, depending on the edge: approx. -20°C (-4°F)

Good water resistance (important when staining and bleaching veneer edges)

Good ageing resistance

Good oxidation resistance

Softening Point:

(ring and ball): 105±5°C For long stoppage of the machine, the temperature should be reduced to approx. 160°C (320°F).

Applications:

Hot melt for automatic edgebanding suitable for solid wood, veneer, PVC and resinated paper edgebands.

Directions:

Melt index according to DIN 53 735 (MF1 150/2.16): 50±15 g/10 min.

Rate of Feed: 20-50 m/min., depending on the width of the edge, a very slow line speed may cause faulty gluing.

Application Quantity: The quantity applied should be adjusted in such a manner as to slightly show on the edge of the part to be glued. In order to check whether the adhesive film is evenly applied, a strip of rigid transparent PVC can be used. Consumption for pre-coating of edges: 80-100 g/m²

Post-Treatment: The glued material can be further processed immediately after bonding, (sawing, routing, planing, etc.)

Application machinery

Automatic edge banding machines with roller applicator
Automatic edge banding machines with spray nozzle applicators
Machines for pre-coating edges.

Process temperature

Run at 200-210°C (392° - 410°F). Lower temperatures may cause faulty gluing, higher temperatures maintained for a long period of time may damage the adhesive and lead to decomposition. 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 acclimatized to room temperature. The most favorable moisture content of the wood is 8-10%. The room temperature must not be lower than 18°C (64°F). Draughts have to be avoided. Regularly check the temperature directly on the application system by means of a laboratory thermometer, bi-metal thermometer or by a thermometer with electrical contacts. Readjust if necessary. The thermometers installed in the machine may give incorrect readings after extended use.

Clean Up and Storage:

Preliminary cleaning while hot by scraping with a spatula or knife. Tools can be cleaned with cleaner.
Can be stored for 2 years. Keep in a cool dry place

Key Warnings:

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.

Waste Disposal: Disposal of contents and/or containers should comply with all applicable federal, state and local regulations.