



# SCHEDA TECNICA - DATA SHEET

## UNIBORD 655

### GENERALITIES

Solid hot-melt adhesive with EVA base for automatic edge-banding machines. Its excellent melting speed, open time and viscosity make it a remarkably versatile product.

### APPLICATIONS

It is used for gluing edges made of polyester, melamine-base materials, plastic laminate, PVC and ABS with primer.

### CHARACTERISTICS

FORM	granular	
COLOUR	natural - walnut - white	
VISCOSITY Brookfield at 200°C g27/1rpm	75000 - 100000	mPa·s
MELT INDEX AT 190°C	130 - 170	g/10min
SOFTENING TEMPERATURE (Ring and Ball)	90 - 100	°C

### FOR BEST RESULTS

TEMPERATURE IN TANK	160 - 180	°C
TEMPERATURE ON ROLLER	190 - 200	°C
HUMIDITY OF MATERIAL TO BE BONDED	8 - 10	%
IDEAL OPERATING SPEED	10 - 30	m/min
PRESSURE ON FILLETS	3 - 5	kg/cm <sup>2</sup>

### USAGE ADVICE

Frequently check the temperature of the glue on the rollers. Temperatures below the recommended value for application cause a decrease in open time with consequent defective gluing results; at higher temperatures the adhesive may decompose with the detriment of colour, viscosity and adhesiveness. When gluing cold or damp surfaces, gluing defects may occur due to the reduction in open time.

In case of break of work, it is suggested to reduce of 30°C - 40°C the temperature in tray to avoid a degradation of the performance of the product.

Occasionally, unsatisfactory gluing results may be due to the type of edge or to the presence of release agents on the materials/panels; a preliminary test is therefore recommended. Should such problem occur, it is advisable to use a suitable preparatory product.

### PACKAGING

Paper-bags of 25 kg.

### STORAGE

Shelf life: 24 months at 20°C in original closed packages.

*The information contained in this leaflet and the suggestions on how to use our products correspond to the current state of our scientific and practical knowledge. However, there aren't any warranty or liability on the final result of the carried out work using our products due to the variability of the materials and application conditions that go beyond our control. We therefore recommend to carry preliminary tests out also in relation to the subsequent applications foreseen for the product and the operating conditions of the finished product. This revision annuls and replaces any other previous ones.*

**Date: May 2019;**

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- THIS TECHNICAL SHEET HAS NOT TO BE CONSIDERED AS A PRODUCT SPECIFICATION -