SCHEDA TECNICA - DATA SHEET

UNIBORD 674

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. It doesn't present any problem of thread forming during application.

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 (200°C s27/2rpm)	70000 – 110000	mPa·s
MELT INDEX AT 190°C	145 – 190	g/10min
SOFTENING TEMPERATURE (Ring and Ball)	95 - 110	°C

FOR BEST RESULTS

TEMPERATURE IN TANK	170 - 190	°C
TEMPERATURE ON ROLLER	200 - 220	°C
HUMIDITY OF MATERIAL TO BE BONDED	8 - 10	%
IDEAL OPERATING SPEED	10 - 50	m/min
PRESSURE ON FILLETS	3 - 5	kg/cm^2

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

Bags of 25 kg.

STORAGE

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

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

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