



## TECHNICAL DATA

# TERMOKOL 2075

## edgebanding adhesive

### DESCRIPTION

TERMOKOL 2075 is hot melt adhesive for edgebanding, unfilled.

### FIELDS OF APPLICATION

The adhesive is used for edgebanding of veneer, melamine, ABS, PP and PVC edge bands on automatic edgebanders for flat bonding and softforming procedure, as well for low speed edgebanders and processing centers. So prepared bonds are transparent, strong, elastic, clean (without stringing) and heat resistant.

### CHARACTERISTICS

Chemical base	EVA copolymer
Viscosity at 200 °C (ASTM D 3236)	approx.. 50 000 mPas
Softening point (ASTM E-28, Ring & Ball)	approx. 105°C
Colour	marking /15.....natural-white, transparent
Marking	not subject to marking according to legislation on dangerous materials

TERMOKOL 2075 is currently undergoing extensive practical tests and is still in the experimental stage. Technical data may change.

### APPLICATION

Before gluing the adhesive must reach working temperature.

Lower working temperatures cause unsuccessful gluing, higher temperatures, maintained for some time will damage the adhesive. At longer interruptions or deadlocks it is recommended to lower working temperature on 160°C. As the thermostats can give misleading temperatures we recommend to control from time to time the temperature of the adhesive on the roll applicator.

The supporting material must be dry, free of dust and acclimatized to room temperature (min. 18 °C). Avoid the draught.

To obtain the good binding results take care about room temperature, temperature of all materials involved and recommendations of machine manufacturers'. Working conditions, machine appointment and types of materials to be glued influence on the results of gluing.

#### The most convenient binding conditions are:

room and material temperature	18 - 25°C
relative humidity	50 - 60%
moisture of wood	8 - 10%
applied quantity	200 - 250 g/m <sup>2</sup>
working temperature	170 - 200°C
feed speed	at least 5 m/min

Deviations from recommended conditions result in a poor bond.

### CLEANING

The melting pots should be cleaned at regular intervals. Excessive buildup of charred materials will reduce the overall effectiveness of the heaters and impair heat transfer. For removal of adhesive residue when the pot is cold, we recommend a mixture of methylene chloride and toluene in a 1:1 ratio.

### PACKING

plastic bags	25 kg net
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### STORAGE

TERMOKOL 2075 should be stored in closed original packaging in a cool and dry place at temperatures bellow +25°C far away from heat sources. Shelf life of properly stored adhesive is minimum 3 years.

The information provided herein, especially recommendations for the usage and application of our products, is based on our knowledge, results of laboratory tests and practical experience gained to date.

We guarantee a constant quality of our products under our technical specifications. Technical advice of our application department is available without obligation. This does not release the buyer from testing our products in his own responsibility with respect to their suitability for intended application and application process. Such an evaluation should be repeated if materials are changed in any way or bought from a different source.

We do not accept any liability with regard to above information or with regard to any verbal recommendation since different materials used in conjunction with our products as well as varying working conditions are beyond our control.