

HOTMELT HG 90⁰



PRODUCT DESCRIPTION

Is a professional hot melt in granular form on EVA base for edge banding machines. HOTMELT HG90 has a short heat-up time and provides excellent results with a transit speed starting at 8m¹ per minute.

DIRECTIONS FOR USE

Suitable for edge banding machines. For processing PVC-, ABS-, polyester-, melamine-, and HPL-edge band, edge veneer and solid slats (up to 5 mm).

The glue must be applied evenly. The processing temperature must be between 190°C and 210°C. The thermostat of the edge banding machine may show deviations after some time, therefore check the temperature of the glue on the roll regularly by using a surface thermometer. During down-time, the temperature in the glue container must be lowered by at least 30°C to 40°C to prevent the hot melt from charring. Always make sure that the temperatures of the materials to be glued do not differ. For a perfect result, the materials to be glued and the room temperature must be between 18°C and 20°C and the humidity of the wood must be between 8% and 12%. Solid slats must be glued on within 24 hours after preparation.

TECHNICAL INFORMATION

Viscosity	: approx. 112,000 mPas/180°C.
(Haake RV 20, D=25s ⁻¹)	: approx. 70,000 mPas/200°C.
	: approx. 37,000 mPas/220°C.
Softening point	: approx. 90°C.
Heat resistance (WPS 68)	: 70 °C – 75 °C.
Colour	: white, natural, black, transparent.
Temperature on the roll	: approx. 200°C – 220 °C.
Transit speed	: starting at approx. 8 m/min.

SHELF LIFE

HOTMELT HG90 has, in tightly closed packaging stored in a dry and cool place, at least 24 months shelf life.

PACKAGING

10 kg bucket, 25 kg bag, 500 kg big-bag.

Our processing advice is based on extensive research and practical experience. We can accept no liability for the results obtained and / or any damage resulting from the use of this product because of the wide range of materials and circumstances in which the glue is used. Nevertheless we would be pleased to advise you.

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