

# HOTMELT HH 103



## PRODUCT DESCRIPTION

Is a professional HOTMELT in cartridge form on EVA base for HOLZ-HER edge banding machines. HOTMELT HH 103 has a short heat-up period and provides excellent results with a transit speed starting at 8m<sup>1</sup> per minute.

## DIRECTIONS FOR USE

Suitable for edge banding machines with or without cartridge and/or slot coater. For processing PVC-, ABS-, polyester-, melamine- and HPL-edge band, edge veneer and solid wooden slats (up to 5mm.). 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 machine 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

Colour	: naturel
Viscosity	: approx. 80,000 mPas/200 °C.
Softening point	: approx. 103 °C.
Colour	: transparent
Viscosity	: approx. 38.000 mPas/200 °C.
Temperature on the roll	: approx. 190 °C – 210 °C
Transit speed	: approx. 10m./min.
Heat resistance (WPS 68)	: 70 °C – 75 °C.

## SHELF LIFE

In tightly closed packaging stored in a dry and cool place the shelf life is at least 24 months.

## PACKAGING

15 kg. Box (white, natural, black and brown)  
11,5 kg. Box (transparent)

**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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