

HOLZ-HER EDGE BANDER HOT MELT CARTRIDGES

PRODUCT DESCRIPTION

Low viscosity, long open time hot melt with excellent adhesion to a wide variety of substrates. Lower running temperatures than competitive cartridges means faster start-ups and reduced energy costs. Applies in a thin glue line for better appearance and high mileage.

APPLICATION

Designed for Holz-Her edgebanders with cartridge glue applicators. Excellent adhesion to PVC, veneer, solid wood, melamine and primed HPL edges.

ADVANTAGES

- Excellent adhesion
- Long open time
- High mileage
- Low operating temperatures
- Good colour and heat stability

PHYSICAL PROPERTIES

Base: Ethylene Vinyl Acetate (EVA)

Form: Cartridges

Specific Gravity: 1.21

Dimensions: 62mm x 80mm

Packaging: 45 cartridges per carton

Softening Point (ASTM E-28): 98° - 112°C

Melt Viscosity: 180°C: 69,000 - 71,000 cps
190°C: 50,000 - 53,000 cps
200°C: 38,000 - 41,000 cps

Application Temperature: 180 - 200°C

Colour: **480C White** **482C Natural**

Odour: Mild

Clean-up: HELMITHERM 499C Hot Melt Cleaner

Shelf Life: 1 year at ambient temperature

PRODUCT HIGHLIGHTS

Flow Properties - HELMITHERM 480C/482C have outstanding flow properties, which is a critical requirement of the Holz-Her cartridge application system.

NOTE: When converting to HELMITHERM 480C/482C adhesive, you will normally have to reduce the temperature to compensate for the increased flow.

Low Viscosity - The viscosity profile of HELMITHERM

480C/482C is designed to maximize the melt capacity of your Holz-Her while maintaining good hold-out on the board core.

Resistance to Meltback - The softening point of HELMITHERM 480C/482C is relatively high and thus will reduce the problem of meltback associated with other "low viscosity" adhesives.

Heat Resistance - The heat resistance of HELMITHERM 480C/482C is excellent. We have designed this product to meet the humidity, shock and heat aging specifications prevalent with the major North American wood furniture manufacturers.

Storage - Extremely stable when stored at ambient temperatures and away from excessively moist or humid environments.

SURFACE PREPARATION

In order to achieve maximum bond strength, surfaces to be bonded must be clean and dry. All dirt, dust, oil, moisture or other extraneous materials must be removed prior to applying the adhesive.

Please refer to the Helmitin Hot Melt Trouble Shooting Guide for suggestions on proper techniques for hot melt adhesive bonding.

CAUTION

- AVOID CONTACT OF HOT ADHESIVE TO SKIN.
- STORE AT ROOM TEMPERATURE (23°C - 73°F).
- KEEP UNUSED MATERIAL COVERED AND FREE FROM DUST, DIRT OR OTHER PARTICLE CONTAMINATION.
- NOT TO BE TAKEN INTERNALLY.

PURCHASERS MUST DETERMINE THE SUITABILITY OF THIS ADHESIVE SYSTEM FOR THEIR MATERIALS AND MANUFACTURING PROCESS.

Hazard Information for Transportation of Dangerous Goods: Non-Regulated.

WHMIS Information: Non-Controlled
FOR INDUSTRIAL AND PROFESSIONAL USE ONLY

Revised: 11/23/2005

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