



Technical Information

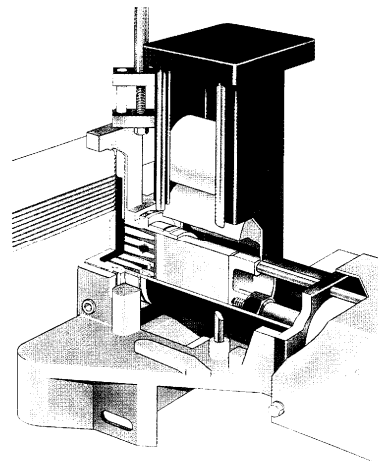
DORUS HKP 20



EVA Hotmelt Adhesive for Edgebanding Cartridge for HolzHer Edgebander Unfilled

Characteristics

- Universal hotmelt adhesive
- Fast melting
- Very good wetting
- High glue mileage
- Produces tight joints virtually not visible
- High final bond strength
- Very high heat resistance



Fields of application

- Edgebanding in HolzHer cartridge equipment as from feedrates of 10 m/min
- Edging material: solid wood, veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*
**Suitability depends on the individual characteristics of the edging material and how it is primed.*
- Particularly suitable for solid wood

Technical data

Softening point (Ring & Ball):	approx. 110 °C (230 °F)
Viscosity (Brookfield):	approx. 75 000 mPa·s / 200 °C (392 °F)
Heat resistance:	approx. 90 °C (194 °F)
<i>tested with 0.6 mm oak veneer using the DORUS method of increasing temperature</i>	

Instructions for use

Material and room temperature:	minimum 18 °C (64 °F)
Material moisture:	8 - 12 %
Heating time:	2 - 4 min
Recommended working temperature in the application nozzle:	200 - 220 °C (392 - 428 °F)
Particularly in case of long and thick panels a higher processing temperature should be chosen.	
Sufficient high pressure is to be applied to press the edging material into the hotmelt beads and to obtain an even hotmelt film.	
If possible, use only straight edges, never twisted or strongly bowed ones. If slightly bowed, insert into magazine so that concave side faces panel.	
Thin coating with primer e. g. DORUS ND 183/1 may improve the adhesion of difficult-to-bond edges.	

Colour available

Transparent

Delivery form

Cartridges

Storage

Shelf life of at least 2 years if stored in a cool and dry place.

Labelling

Hazardous warning labelling according to GefStoffV and EU Directives not required.

Safety

Hotmelt adhesives give off vapours even when the specified working temperature is not exceeded. The smells emitted may often cause irritation. When the specified temperatures are considerably exceeded over a longer period of time, there is the additional danger of decomposition products being given off. Therefore measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment.

10/2009

The information provided herein, especially recommendations for the usage and applications of our products, is based on our knowledge and experience. Due to different material used as well as to varying working conditions beyond our control we strictly recommend to carry out intensive trials to test the suitability of our products with regards to the required process and applications. We do not accept any liability with regards to the above information or with regard to any verbal recommendation, except for cases where we are liable of gross negligence or false intention.