

HOLZ-HER Cartridge Hot Melt Conforming to Fa. Reich Spezialmaschinen Specification

Basis: Ethylene - Vinyl Acetate (EVA)

Technical Data: Viscosity (mPas/cPs): approx. 110,000 at 180°C (356°F) Brookfield-Thermosel
 approx. 85,000 at 190°C (374°F)
 approx. 60,000 at 200°C (392°F)
 Softening Point: approx. 100°C (212°F) Ring & Ball
 Color: 80-natural; 81-white; 82-brown; 83 black

Characteristics: Medium-high viscosity hot melt. Good adhesion especially to primed HPL. Good color and heat stability in the melt.

Applications: Hot melt for HOLZ-HER cartridge edgebanders. Suitable for primed HPL, solid wood, veneer, PVC and resinated paper edgebands.

Directions for use: Application Temp: 180-200°C (356-392°F) in the melt

The structure of the edge material and working conditions may influence the bond.

PRIMER MUST CONSIST OF JOWACOLL 148.60 DILUTED WITH WATER 50:50. DUE TO THE DIFFERENCES IN HPL, WE STRONGLY RECOMMEND TO CARRY OUT SUITABILITY TESTS PRIOR TO PRODUCTION.

Tested according to Jowat test methods. Customer trials are recommended.

Cleaning: Preliminary cleaning while hot by scraping with a spatula.

Storage: At least 3 years from the date of manufacture in dry and cool (15-25°C/58-76°F) conditions according to our experience.

Packaging: In cartons of 35 lbs. net.

Marking: None. We recommend drawing off any vapors which may form. Consult Material Safety Data Sheet.

07/08 (S) All data indicated are characteristics represented as average values. Our technical data sheets are constantly revised to represent the latest state of technology. This edition is replacing all previous ones, and is valid on the date of compilation.
Please refer to last page for additional information.



JOWAT Corporation Information

Gluing, as one of the most efficient methods of bonding, is constantly expanding into new areas of application. At the same time, the number of substrates to be bonded is also growing at an unprecedented rate. New methods and equipment to process adhesives are constantly being improved and developed.

The in-house R&D department of JOWAT Corporation ("JOWAT") is responding with intensive efforts to keep pace with these constant changes. A highly trained and qualified team of chemists and engineers are using the latest techniques and the brightest ideas to make sure that our adhesives meet the needs of our customers for new and innovative applications.

We have assimilated information based on test results from our laboratories as well as on experience gained in the field by working with our customers. This information is available by contacting our technical service department. Customers who have obtained information and thereafter undertake modifications during a running production are invited to provide this information to us to assist us in maintaining our field information and obtain any updated information we may have. **However, any technical information we provide is provided for informational and assistance purposes only, and should not be relied upon or used to replace field testing by the user of the adhesive in the actual application for which the adhesive is to be used.** Our laboratory testing and field information obtained cannot simulate all eventualities that may occur in each specific application, and for that reason **we cannot and do not insure performance or results in specific applications.**

Any user of adhesives manufactured by JOWAT must test the adhesive(s) for suitability in each individual application, performing such tests in connection with the first use of a sample as well as all subsequent modifications during any ongoing production.

In addition to such other tests the users of our adhesives deem appropriate to insure suitable bonding, all users of adhesives manufactured by JOWAT should test the adhesives for suitability on original parts equal to normal processing conditions. The adhesive bond should then also be tested and assessed by subjecting it to the actual stress and conditions it will undergo in its intended use. **ALL OF THESE TESTS ARE ABSOLUTELY NECESSARY AND MUST BE PERFORMED.**

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