



SCHEDA TECNICA - DATA SHEET

UNIBORD 677NA

GENERALITIES

Solid hot-melt adhesive with EVA base for automatic edge-banding machines. Its excellent melting speed, open time and viscosity make it a remarkably versatile product. It doesn't present any problem of thread forming during application.

APPLICATIONS

It is used for gluing edges made of polyester, melamine-base materials, plastic laminate, PVC and ABS with primer.

CHARACTERISTICS

FORM	granular
COLOUR	natural - walnut - black- white
VISCOSITY Brookfield at 200°C(398 °F) s27/2rpm	80000 - 110000 mPa·s
SOFTENING TEMPERATURE (Ring and Ball)	97 - 110 (207-230) °C(°F)

FOR BEST RESULTS

TEMPERATURE IN TANK	170 - 190 (338-374)	°C (°F)
TEMPERATURE ON ROLLER	200 - 220 (392-428)	°C (°F)
ROOM TEMPERATURE AND TEMPERATURE OF MATERIALS	18 - 25 (64-77)	°C (°F)
IDEAL OPERATING SPEED	10 - 50 (33 - 164)	m/min (feet/min)

USAGE ADVICE

Frequently check the temperature of the glue on the rollers. Temperatures below the recommended value for application cause a decrease in open time with consequent defective gluing results; at higher temperatures the adhesive may decompose with the detriment of colour, viscosity and adhesiveness. When gluing cold or damp surfaces, gluing defects may occur due to the reduction in open time.

In case of break of work, it is suggested to reduce of 30°C - 40°C (86°-104°F) the temperature in tray to avoid a degradation of the performance of the product.

Occasionally, unsatisfactory gluing results may be due to the type of edge or to the presence of release agents on the materials/panels; a preliminary test is therefore recommended. Should such problem occur, it is advisable to use a suitable preparatory product.

PACKAGING

25 kg (55,1 lbs) bags.

STORAGE

Shelf life: 24 months at 20°C (68°F) in original closed packages.

The information contained in this leaflet and the suggestions on how to use our products correspond to the current state of our scientific and practical knowledge. However, there aren't any warranty or liability on the final result of the carried out work using our products due to the variability of the materials and application conditions that go beyond our control. We therefore recommend to carry preliminary tests out also in relation to the subsequent applications foreseen for the product and the operating conditions of the finished product. This revision annuls and replaces any other previous ones.

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FOR PROFESSIONAL USE ONLY- THIS TECHNICAL SHEET HAS NOT TO BE CONSIDERED AS A PRODUCT SPECIFICATION -



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The industrial production and manufacturing sectors that include glue and the various phases of gluing are constantly evolving, as are the various types of materials used to create said products and their machinery application.

Unicol NA is continuously updating its products for the technical adaptations of its merchandise field.

Our expertise is based on meticulous laboratory testing and field applications. The technical specifications are regularly updated and available by contacting our technical service team.

The information provided in our technical data sheets cannot be considered declarations of guarantee and are purely for informational purposes.

Consumers must always carry out preliminary tests for each application of every individual product to verify they will have the intended results, as updates and subsequent modifications to our products are ongoing throughout production.

It is the user's responsibility to determine the suitability of our products for the user's purpose and to take any and all precautions necessary, recommended and implied, to protect the material and themselves from hazards during application of the product.

Unicol NA expressly disclaims any liability for incidental consequences or damages of any kind, including lost profits.

Bonding strength tests of the finished product should be carried out and evaluated by subjecting the material to the anticipated stresses and conditions to which it will be subjected in all foreseen and reasonably foreseeable uses.

The Unicol laboratory tests cannot simulate or cover all the production eventualities that may occur for each specific process or application, and therefore we cannot guarantee results in every specific application.

ALL THESE TESTS ARE NECESSARY AND MUST BE PERFORMED.

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