

- Technical Data Sheet - POLYBOND 6510

GENERALITY

Hot melt adhesive characterized by medium viscosity and medium open time, so that it can be used as an adhesive for general purposes.

TYPICAL APPLICATIONS

It's used with beading automatic bonding of straight edges in paper impregnated with melamine resin or other similar plastic edges eg. ABS, PVC, polyester, properly primed.

CHARACTERISTICS

- Nature:	EVA copolymer
- Form:	Granular
- Colour:	Natural Beige
- Viscosity Brookfield RVT-S 28-2,5 rpm to 220° C:	55.000 ± 10.000 mPa.s
- Softening point (ASTM E/28M r & b) *:	105 ± 3° C
* Methods of analysis adapted internally	

CONDITIONS FOR USE

- Temperature on spreading roller	200 - 220° C
- Glue quantity	150 - 250 gr/m ² .
- Feed speed	15 - 18 m/min.

USEFUL HINTS FOR USE

- Spread the product in an even and regular layer.
- The quantity of glue to be applied depends on the materials which are to be bonded, and is generally larger for more porous surfaces.
- Pressure must be right and evenly distributed. Inadequate pressure causes faulty bonding.
- In case of prolonged machine-stops, lower the temperature in the hot melt pot by at least 30 - 40° C in order to prevent alterations which might impair the adhesion.
- Check the temperature of the spreading roller frequently and make sure it corresponds to the value on the machine thermometer. Differences in temperature, this being either lower or higher, may unexpectedly affect bonding.
- Check quite often the quality of the obtained bonding. If new materials are used, it is always advisable to make preliminary tests before proceeding with continuous production.
- The minimum temperature of the materials to be bonded must not be lower than 18 - 20° C and the humidity must range from 8 to 12 %. With regard to these values, particular attention has to be paid when working during the cold periods of the year.
- For laminate edges gluing, it's advisable to use our PREPARATORE KA. Before applying the border it is necessary to evaporate completely the solvents.

STORAGE

The product remains stable for twelve months if it's kept closed in its original package, stored in a cool and dry environment.

SAFETY

Before using the product, please request its safety instructions.

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Soggetta alla direzione e coordinamento della "Tognon S.r.l." Iscritta al Registro delle Imprese di Padova al n. 03525140285

PACKAGING:

Kg 25 reinforced-paper sacks.

All the technical data in this literature are the result of careful experiments made in our laboratories, by specific procedure and so they are reliable. But because of the great number of environmental and applicable factors that can affect the experiments the data cannot be guaranteed.

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