

- Technical Data Sheet - POLYBOND 5030/M5

GENERALITY

Hot melt adhesive for the wood industry wishing a transparent result.

It is characterized by an high level of practical efficiency and adhesion versatility, it allows to obtain a thin glue line.

Perfect for soft forming and work stations. Little formation of wires.

TYPICAL APPLICATIONS

It is used with automatic edge banding machines and work stations for gluing edges of all kind, PVC, ABS, polystyrene, impregnated melamine papers, edges made of wood and by-products, blocks.

CHARACTERISTICS

- Base:	EVA copolymer
- Shape:	granular
- Colour:	natural (transparent when melted)
- Brookfield viscosity RVT-S.28-5 rpm	a 220° C: 30.000 ± 10.000 mPa.s
	a 200° C: 45.000 ± 10.000 mPa.s
- Softening point (Ring & ball ASTM E/28):	106 ±3° C

CONDITIONS FOR USE

- Operating temperature at the application roll:	200 - 220° C
- Glue quantity:	150 - 250 gr/m ²
- Feed speed:	15 - 18 m/min.

USEFUL HINTS FOR USE

Spread the product even and regularly layer.

The quantity of glue to be applied on the materials which are to be bonded 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 of the bonding agent by at least 30 - 40° C so as to prevent alterations which might impair 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.

Control the quality of the bonding you obtain quite often. 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 this, particular attention has to be paid when working during the cold periods of the year.

STORAGE

Twelve months when kept and dry in the original package

INFORMATION ABOUT DANGEROUSNESS

Before using the product, please request its safety instruction.

PACKING

Kg. 25 reinforced paper bags.

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 can't be guaranteed.