

803.70/803.71**PUR HOTMELT****Product Characteristic**

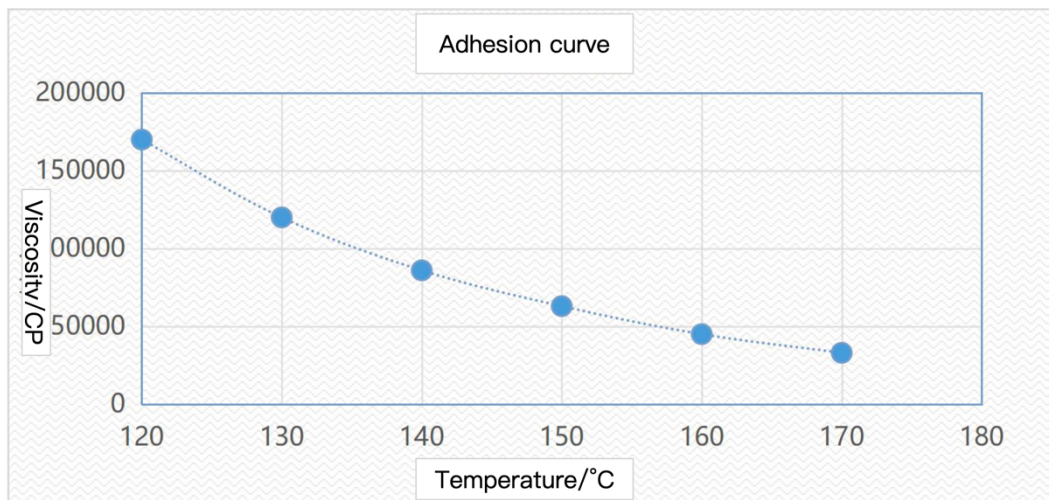
- Strong initial adhesion, high final adhesion
- Short open time, strong positioning
- Good adhesion to PVC, paper, and wood
- Good dryness, no dripping of glue at high temperature to avoid board contamination
- Good non-cleaning property

Application Field

- Can be used for edge banding of wood-based panels
- Can be used for wood board splicing

Technical Detail

- State : 803.70 beige solid / 803.71 white solid
- Density : about 1.25g/cm³
- Viscosity : 55000 - 75000 cP/150°C
- Open Time : 25±5s/40°C
- Adhesion curve:

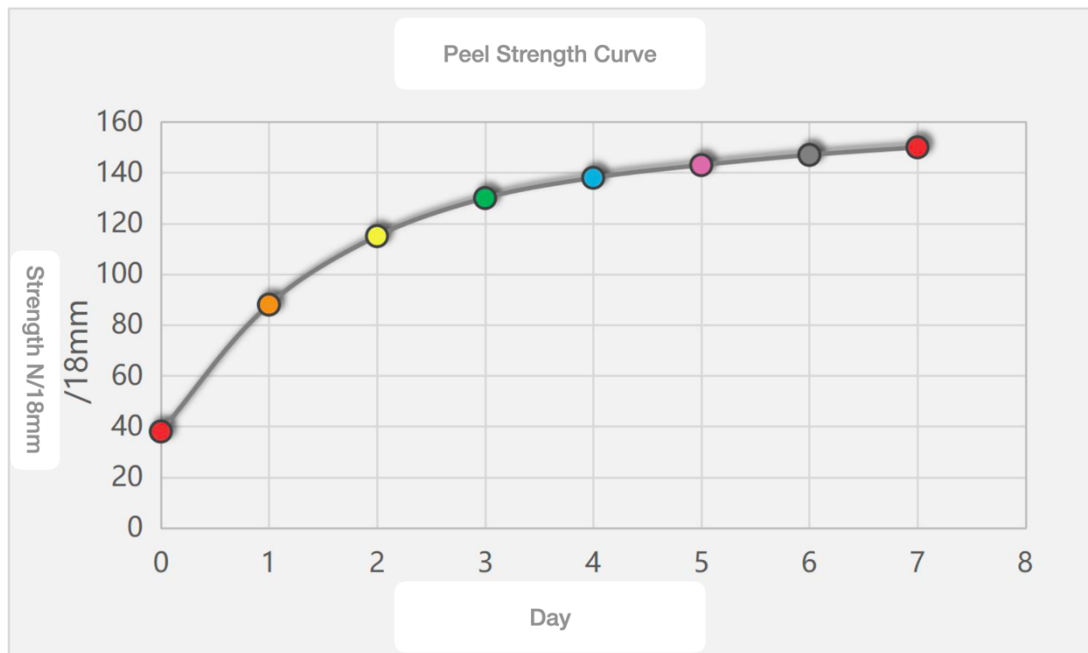


- The above data was obtained in the laboratory and is for reference only. The actual results may vary depending on the specific application.

Application Condition

- Substrate pre-treatment : The surface of the base material should be cleaned and reach a temperature of 25°C or above; The PVC edge banding tape should have a dyne value ≥ 36
- Recommended temperature and humidity range: Temperature of 20~40°C, humidity of 40~75%
- Processing Temperature : 130~170°C
- Glue Spread : 90~150g/m² (Adjusted for different substrates and bonding strength requirements) 90-120g/m² for density board, 100-130g/m² for multi-layer board, and 120-150g/m² for particle board
- Curing time: At RT > 25°C and RH > 40%, the curing time is 3-7 days until 80% of the wet curing is achieved. Proper insulation is beneficial for shortening the curing time
- No-cleaning time: 24-48 hours, depending on the environmental temperature and humidity

- Attached is the graph of peel strength curve (RT 25°C RH 40%; PVC edge band/Particleboard, 90° peel strength: N/18mm)



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Application Notes

- Check the surface of the glue in the glue pot before each startup. If there are lumps or crusts on the surface, pick them open and raise the temperature of the glue pot by 5-10°C. After using up the old glue in the glue pot, adjust the temperature back to its original setting.
- The glue gun needs to be sealed and protected at the end of each day to avoid blockage caused by the wet-cured residual glue at the nozzle.
- For the edging of regular cabinet boards, it is recommended to apply the glue on the glue roller at a temperature of 130-145°C when the ambient temperature is above 35°C. When the ambient temperature is below 25°C, the temperature of the glue roller should be raised to 150-165°C accordingly. For thick door panel edging, it is recommended to increase the usage temperature by 5-10°C compared to regular cabinet board edging to ensure the supply of glue.
- The glue roller and glue pot should be thoroughly cleaned at least once a week. If the machine is stopped for more than 48 hours, the glue pot and glue roller need to be cleaned.
- To ensure the edge banding effect, it is strongly recommended to apply a release agent before pre-milling and a cleaning agent before polishing.
- Proper moisture-proof measures should be taken during substrate storage to avoid swelling caused by moisture absorption, which may result in uneven panel surfaces.
- Check if the bottom coating is still effective if the surface material has been stored for more than 6 months.

Cleaning

Use the company's special cleaning agent HM-20 to clean the hot melt system. It is recommended to clean the glue pot and coating shaft with HM-20 first, then use HM-18 for further cleaning.

Storage

Store in a cool and dry environment and avoid direct sunlight. The storage temperature should

be below 40°C.
Shelf life: 6 months.

Services

Our service department provides free consultation services 24 hours a day. When there are changes in materials or processes, the suitability of this product must be confirmed through testing before use. Our company is not legally responsible for any amount exceeding the value of the product