



TECHNICAL DATA

TERMOKOL 2015

edgebanding adhesive

DESCRIPTION

TERMOKOL 2015 is hot melt adhesive for automatic edgebanders.

FIELDS OF APPLICATION

The adhesive is used for edgebanding of veneer, melamine, polyester, ABS and PVC edge bands. It can be used also as precoating hot melt.

CHARACTERISTICS

Chemical base

Viscosity at 200°C (ASTM D 3236)

Softening point (ASTM E-28, Ring & Ball)

Colour

EVA copolymers

60 000 - 80 000 mPa s

98 - 108°C

marking / 00.....snow white

/ 05 white

/ 15 natural-beige

/ 25 light brown

/ 35 dark brown

/ 45black

Marking

not subject to marking according to legislation
on dangerous materials

APPLICATION

Before gluing the adhesive must reach the working temperature. Lower working temperatures cause unsuccessful gluing (viscosity goes up, applying becomes more difficult, open time becomes shorter), higher temperatures, maintained for some time will damage the adhesive. So during longer shut -down lowering the temperature to app. 160°C is recommended. We recommend to control the temperature of the adhesive on the roll applicator regularly. The supporting material must be dry, free of dust, acclimatized to room temperature (min. 18 °C). Draughts have to be avoided. Take into account working instruction of machine producer. Working conditions, engagement of machine, operating mode, structure of paper, influence the quality of gluing essentially.

The most convenient binding conditions are:

room and material temperature

18 - 25°C

relative humidity

50 - 60 %

moisture content of wood

8 - 10 %

quantity applied

150 - 250 g/m²

working temperature on the application rolls

170 - 200°C

feed speed

min. 12 m/min

Deviations from recommended conditions result in a poor bond.

CLEANING

The melting pots should be cleaned at regular intervals. Excessive buildup of charred materials will reduce the overall effectiveness of the heaters and impair heat transfer. For removal of adhesive residue when the pot is cold, we recommend a mixture of methylene chloride and toluene in a 1:1 ratio.

PACKING

plastic bags

25 kg net.

STORAGE

TERMOKOL 2015 should be stored in original packaging in a cool and dry place at temperatures bellow +25°C far away from heat sources. Shelf life of properly stored adhesive is minimum 3 years.

The information provided herein, especially recommendations for the usage and application of our products, is based on our knowledge, results of laboratory tests and practical experience gained to date. We guarantee a constant quality of our products under our technical specifications. Technical advice of our application department is available without obligation. This does not release the buyer from testing our products in his own responsibility with respect to their suitability for intended application and application process. Such an evaluation should be repeated if materials are changed in any way or bought from a different source.

We do not accept any liability with regard to above information or with regard to any verbal recommendation since different materials used in conjunction with our products as well as varying working conditions are beyond our control.