



TECHNICAL DATA SHEET

HM1963-7 *Edgebanding Hot Melt*

Basis: Ethylene - Vinyl Acetate (EVA)

Technical Data: Viscosity (mPas/cPs): approx. 120,000 at 190°C (374°F) Brookfield-Thermosel
approx. 90,000 at 200°C (392°F)
approx. 70,000 at 210°C (410°F)
Density (g/ml): approx. 1.33 (10.8 lbs./gal.)
Softening Point: approx. 110°C (230°F) Ring & Ball
Color: 60-natural; 61-white; 62-brown; 63 black

Characteristics: Medium-high viscosity hot melt. Very economical with good color and heat stability in the melt.

Applications: For edgebanding veneer, solid wood, resin impregnated paper edgebands, PVC, ABS, and primed HPL. Good wetting and adhesion properties. This hot melt can also be used for precoating and softforming applications.

Direction for use: Application Temp: 190-210°C (374-410°F) in the melt
Feed Speed: 12-60 m/min (30-120 ft/min)

The structure of the edge material and working conditions may influence the bond.

PRIMER MUST CONSIST OF JOWACOLL 148.60 DILUTED WITH WATER 50:50. DUE TO THE DIFFERENCES IN HPL WE STRONGLY RECOMMEND TO CARRY OUT SUITABILITY TESTS PRIOR TO PRODUCTION.

Cleaning: Preliminary cleaning while hot by scraping with a spatula.

Storage: May be stored for 12 months after date of shipment, in properly closed original containers, cool and dry (15-25°C).

Packaging: In plastic bags of 44 lbs. net.

Remarks: For further information concerning handling, transport and disposal, please refer to the Material Safety Data Sheet. Our information on this data sheet is based on test results from our laboratories as well as on experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding for us. The information given in this leaflet represents neither a performance guarantee nor a guarantee of properties, nature, condition, state or quality. No liability may be derived from these indications nor from the recommendations made by our free technical advisory service.