

MAKTHERM 30

EUROPEAN MANUFACTURED WHITE, NATURAL & BLACK HOTMELT ADHESIVE

CHARACTERISTICS AND APPLICATIONS

MAKTHERM 30 is a EVA based synthetic resin adhesive with good working properties, which can be universally used on edgebanders. The adhesive, melts and heats well, has good thermal stability and is specially suitable for bonding of PVC. It is a high viscosity hot-melt.

PHYSICAL PROPERTIES

Viscosity : 120,000 \pm 15.000 mPa.s (Brook. Thermosel, 204°C)
Softening Point : 105 \pm 4°C

INSTRUCTIONS FOR USE

The machine should be adjusted according to the recommendations of the machine manufacturers.

MAKTHERM 30 can be processed in the usual way. Good results are obtained under the following conditions:

Room and materials temperature : 18-20°C
Wood moisture : 8-10%
Temperature at the applicator roll : 190-210°C

The feed speed should be at least 20 m /min so that the adhesive does not cool down prematurely and is still fluid enough to wet the entire surface of the edge strip.

Edges strips can have very different adhesion properties, even if the base material is the same. For this reason, it is advisable to make trials if the edges are of an unknown type in order to test the suitability of the adhesive.

The recommendations given by the edge strip manufacturers should be followed.

The heat resistance of **MAKTHERM 30** meets the average demands made on furniture to be used in different climatic zones.

Heat resistance tested with rising temperatures according to our method: 75°C

During long stops the adhesive temperature should be lowered to 160°C to avoid degradation of the characteristics.

All residual encrustations of adhesive must be completely cleaned from the melting tank from time to time as they conduct heat poorly and cause a lowering of the adhesive temperature.

HAZARDOUS INFORMATION

At the recommended working temperature the hot-melt will give off fumes which can irritate the respiratory organs. If the working temperature is exceeded over a long period, harmful decomposition products will form. In any case an appropriate e exhausting system shall be installed in the working area.

STORAGE

MAKTHERM 30 Should be stored in well-closed original containers at room temperature. In these conditions the glue can be conserved for at least 12 months without changing its properties.

At the information in this technical datasheet is given in good faith and is the result of our own experience and tests and can only be considered as a guideline for operation.

We guarantee the constant quality of our products but we cannot be responsible for the results obtained in their use, since the conditions of work are beyond our control.

We recommend that tests should be made to determine the suitability of the product for a specific purpose before the production is started

