

## MAKTHERM 50

EUROPEAN MANUFACTURED WHITE & NATURAL HOTMELT ADHESIVE CARTRIDGES

### CHARACTERISTICS AND APPLICATIONS

**MAKTHERM 50** is a EVA based synthetic resin adhesive with good heat resistance, which can be universally used on Holz-Her (or similar) edgebanders that work with cartridges (80mm long x 63mm diameter). The adhesive has good working properties, good thermal stability and is specially suitable for bonding of PVC.

### PHYSICAL PROPERTIES

Viscosity : 50,000 ± 7000 mPa.s (Brook. Thermosel, 204°C)  
Softening Point : 98 ± 4°C

### INSTRUCTIONS FOR USE

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

**MAKTHERM 50** 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%     |
| Melting temperature (lower resistance)     | : 170-180°C |
| Application temperature (upper resistance) | : 180-200°C |

If it is necessary a lower feed speed than is recommended, the glue temperature must be the highest one (190°C) to assure that the glue film 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 26** meets the average demands made on furniture to be used in different climatic zones.

Heat resistance tested with rising temperatures according to our method: approximately 65°C

### 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 26** Should be stored in a ventilated and fresh place. 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