

# MAKATHERM HOTMELT ADHESIVE

## Technical Data Guide – MAK07LS / 5707 (Low Speed)

### Characteristics & Applications

MAKATHERM 07 / 5707 low speed is an 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 especially suitable for bonding of PVC. It is a high viscosity hotmelt.

### Product Properties

	VALUE	UNIT	INTERNAL METHOD	ADAPTED STANDARD
<b>Viscosity</b> (Brookfield HB, 204°C)	Approx. 82,000	mPa.s	I PRO 00 04	ASTM D 3226
<b>Softening Point</b> (Ring & Ball)	Approx. 103	°C	I PRO 00 02	ASTM E 28

### Instructions for use

The machine should be adjusted according to the recommendations of the machine manufacturers. MAKATHERM 07LS/5707 can be processed in the usual way. Good results are obtained under the following conditions;

<b>Feed Speed</b>	Up to 10 meters per minute
<b>Room Temp</b>	18 - 20°C
<b>Running Temp</b>	190 - 210°C
<b>Type Adhesive</b>	E V A
<b>Colour</b>	Natural & White
<b>Storage</b>	At least 12 months

Adhere to the feed speed recommendations to ensure that the adhesive does not cool down prematurely and is still fluid enough to wet the entire surface of the edge strip. If you are unable to achieve an ambient room temp of 18 - 20°C during colder seasons consider increasing the running temp up to 190 - 210°C.

Edging 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.

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 hotmelt 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:

Store in closed container at room temperature. In these conditions the glue can be conserved for at least 12 months without changing its properties

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