

MAKATHERM HOTMELT ADHESIVE

Technical Data Guide – MAK26 Transparent Granules

Characteristics & Applications

MAKATHERM 26 is a Transparent 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
Viscosity (Brookfield HB, 204°C)	50,000 ± 6000	mPa.s	I PRO 00 04	ASTM D 3226
Softening Point (Ring & Ball)	100 + 4	°C	I PRO 00 02	ASTM E 28

The machine should be adjusted according to the recommendations of the machine manufacturers. MAKATHERM 26 can be processed in the usual way. Good results are obtained under the following conditions;

Feed Speed	Up to 20 meters per minute
Wood Moisture	8 – 10 %
Room Temp	18 - 20°C
Type Adhesive	E V A
Temp at Roller	180 – 210 °C
Adhesive Spread	150 - 250 g /m ²

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 MAKATHERM 26 meets the average demands made on furniture to be used in different climatic zones. 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.

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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