

MAKATHERM HOTMELT ADHESIVE

Technical Data Guide – MAK50 Cartridges

Characteristics & Applications

MAKATHERM 50 is an 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 well working properties, good thermal stability and is especially suitable for bonding of PVC.

Product Properties

	VALUE	UNIT	INTERNAL METHOD	ADAPTED STANDARD
Viscosity (Brookfield HB, 204°C)	50,000 ± 7000	mPa.s	I PRO 00 04	ASTM D 3226
Softening Point (Ring & Ball)	98 + 4	°C	I PRO 00 02	ASTM E 28

The machine should be adjusted according to the recommendations of the machine manufacturers. MAKATHERM 50 can be processed in the usual way. Good results are obtained under the following conditions;

Feed Speed	Up to 20m/min
Wood Moisture	8 - 10 %
Room Temp	18 - 20°C
Temp at Roller	180 - 200 °C
Type Adhesive	E V A
Colour	Natural, White & Black
Melting Temp	170-180°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 MAKATHERM 50 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 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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The information in this technical datasheet is given in good faith and is the result of manufacturers 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.

