

Hranitherm 700.20

Solid hot-melt adhesive with EVA copolymers and synthetic resins

DESCRIPTION AND APPLICATIONS

Hot-melt adhesive specially formulated to be used in semi-automatic or automatic edge banders such as HOMAG, STEFANI, EGURKO BARBERAN, OLIMPIC and others, suitable to bond solid wood, chipboard, HDF board, MDF, or other fine-grained wood-based materials with different kinds of edge: wood veneer, polyester, HPL*, PVC*, ABS*, PP* and melamine. Maximum edges thickness: up to 2 mm (depending on tension or stress of each edge to bend towards to its original shape).

- Medium application temperature
- Medium open time.
- High initial tack.
- Medium setting time.
- Suitable for wood veneer, paper, polyester, HPL*, PVC*, ABS*, PP* and melamine.

*Suitable depending on the individual characteristics of the edge material and how it is primed.

TECHNICAL DATA

Parameter	Value
Appearance	Granules
Colour	Natural
Brookfield Viscosity (180 °C, TR9-200rpm)	40 000 – 60.000 mPa . s
Softening Point (Ring and Ball)	79 – 89 °C
Open Time (180 °C)	Medium
Density	1,55 – 1,65 g/cm ³

SUITABLE WORKING CONDITIONS

Parameter	Value
Melter temperature	160 – 180 °C
Application Temperature	160 – 190 °C
Temperature of the roller	180 – 190 °C
Moisture of the materials	8 – 10 %
Pressure on pressure roller	3 – 5 kg/cm ²
Feed speed (approx.) Depending on environmental conditions and temperatures of materials	5 – 30 m/min

USAGE ADVICE

In order to achieve maximum bond strength, surface must be clean and dry. All dirt, dust, oil or other extraneous materials must be removed prior to applying adhesive. Melting of the adhesive should be carried out with the application roller stopped. After it, put the application roller in motion and wait for the adhesive to reach its application temperature. Adjusting of the machine should be done according to the manufacturer's instructions.

Due to the variety of climates, the wide variety of materials and the differences observed in adhesion, we advise to carry out preliminary tests to achieve the optimal work conditions and the suitable weights to be applied. During stops, the adhesive temperature should be decreased until 120 °C in order to avoid adhesive degradation loss of the adhesive properties.

CLEANING

Melter should be cleaned regularly with a scraper, to avoid incrustations of burned adhesive, and machines should be drained with our cleaning product Hraniclean 01.

PRECAUTIONS FOR SAFE USING

Even under normal conditions of use product may produce hazardous vapours which may cause a respiratory tract irritation. Provide adequate ventilation. Before use read the SDS of the product.

STORAGE

Hranitherm 700.20 can be stored at least 2 years in the follow conditions: Keep product in a cool (between +5 and +35 °C) dry (WR <60 %) and ventilated area away from direct sunlight, heat sources and points of ignition. Always store in original container tightly closed.

PACKAGING

Information on request from your area sales manager eventually available on www.hranipex.cz/en

The information contained in this leaflet and the suggestions on how to use our products correspond to the current state of our scientific and practical knowledge. However, there aren't any warranty or liability on the final result of the carried out work using our products due to the variability of the materials and application conditions that go beyond our control. We therefore recommend to carry preliminary tests out also in relation to the subsequent applications foreseen for the product and the operating conditions of the finished product. This revision annuls and replaces any other previous ones.