# EVA hot melt adhesive

# 280.50/51

**Application:**

For edgbanding for instance using edgebands of HPL/CPL, polyester, resinated paper and veneer. If thermoplastic edgebands are to be bonded, the special properties of the edgebands and the reverse primer application have to be tested before use.
May be used for straight edges, softforming and BAZ.

**Characteristics/ Directions for Use:**

Long open time, high hot tack, good adhesion and good heat resistance, excellent resistance to oxidation and colour stability in the melt. Very good mechanical processing characteristics with accurate string-free hot melt application.
Can be processed on automatic units with wide slot nozzle and roller.

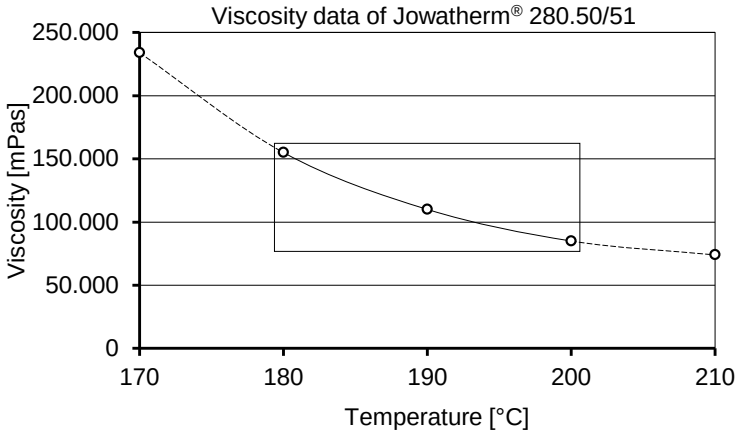
| | |
|---|---|
| Processing temperature [°C]: | 180 – 200 |
| Feed speed [m/min]: | 10 – 80 |

The properties of the substrates and the processing conditions will influence the processes of joining and bonding. Customer trials before use are recommended.

The materials to be used must be free of grease and dust and be dry, they also have to match perfectly. Wood moisture content should be at 8 – 10 %. Minimum temperature of substrates and ambient air should not be below 18 °C. Avoid draught.

**Technical Data:**

| | |
|---|---|
| Density [g/cm³]: | approx. 1.1 |
| Softening range [°C]: | approx. 95 (Kofler bench) |
| Appearance: | final digit 0 = light beige<br>final digit 1 = white |

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**01/16** All data indicated are characteristics represented as average values. Our technical data sheets are constantly revised to represent the latest state of technology. This edition is replacing all previous ones, and is valid on the date of compilation.
**Please turn this page for additional information.**

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**Cleaning:** Preliminary cleaning while hot by scraping with a spatula. Remove any residues when cold with Jowat® Cleaner 402.40.

**Storage:** Cool and dry. Best-before date, please refer to label on the packaging unit.

**Packaging:** Granulate; types of packaging and units upon request.

**Remarks:** For further information concerning handling, transport and disposal, please refer to the Safety Data Sheet.
Our information on this data sheet is based on test results from our laboratories as well as on experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding for us. The information given in this leaflet represents neither a performance guarantee nor a guarantee of properties, nature, condition, state or quality. No liability may be derived from these indications nor from the recommendations made by our free technical advisory service.

## Jowat Information

Gluing as one of the most efficient methods of bonding is constantly gaining importance and expanding into new areas of application. At the same time, the number of substrates to be bonded is also growing at an unprecedented rate. New methods and equipment to process adhesives are developed.

The in-house R & D departments of Jowat are responding with intensive efforts to keep pace with these constant changes. A highly qualified team of chemists and engineers is using the latest techniques and brightest ideas to provide the utmost in advice our customers and to make sure that they get the adhesive which meets their needs.

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The processing company itself must therefore test the adhesives manufactured by us for suitability in each individual case. This applies to the first use of a sample as well as to modifications during an ongoing production.

We are therefore requesting all our new customers to test our adhesives for suitability on original parts at conditions equal to normal processing conditions. The bond has then to be subjected to the actual stress which it would undergo when in use and has to be assessed. This test is absolutely necessary.

Customers who undertake modifications during a running production are requested to pass this information on to us. Please notify us when machines are set to new parameters as well as when the substrates to be bonded are changed. Only then will Jowat be able to provide our most up-to-date information to the processor using our adhesives.

The information given in this leaflet is based on practical experience and on results of tests in our laboratory, and does in no way constitute any guarantee of properties. No liability may be derived from these indications nor from the recommendations made by our technical advisory service.