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COD. 6424 - POLYBOND 5033
Hot Melt adhesives

Polybond 5033 is universally applicable adhesive for edge binding machines. Good heat resistance.

FIELDS OF APPLICATION

- ABS
- Unsaturated paper
- Melamine
- Plastic laminate edges

PROPERTIES OF THE ADHESIVE

- . base : EVA
- . aspect : granular
- . colours : neutral, white, beige, brown, black
- . viscosity Brookfield HATS=21 g.=0,5/min. at 200°C. : 120.000 cps
at 220°C. : 67.000 cps
- . ring and ball ASTM/-E-28 : 110°C.
- . Melt index - according to ASTM-D1238 modified 160°C: 28 g/min.

WORKING CONDITIONS

- . melting container temperature : 180-200°C.
- . spreading roller temperature : 200-220°C.
- . line speed : 20-30 m/min.
- . materials temperature : 15°C.
- . materials humidity : 8-12%
- . pressure on the edge : 3-5 Kg/cmq.
- . application quantity : 150-250 gr/mq.

APPLICATION TECHNIQUE AND ADVICES

The temperature of the hot melt should be controlled at the point of application roller or spray nozzle, with a temperature measuring device.

While the machinery is not working a cooling down of the melt occurs. For this reason the adhesive becomes tougher and offers poorer application properties.

In this case new adhesive is recommended and, also, in case of high consumption use a premelting container.



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The necessary application quantity is dependent on the substrate material. An insufficient adhesive application results in a poor bond an excessive application leads to visible glue lines. An overheating of the adhesive should be avoided, as this could influence its properties.

It is important that the melting container be cleaned at regular intervals. This is specially necessary when the adhesive incrustations form at the walls. For the removal of adhesive residue when cold use a mixture of methylene chloride and toluene 1:1.

STORAGE

The hot melt adhesive may be stored for one year, it must be kept in cool and dry places, close in the original bags.

PACKING

Paper bags Kg. 25 net.

SAFETY ADVICE

According to the italian working material regulations, and identification of the product is not required.

The statement made herein is based on our experience up to date, this is to be considered as information without obligation. Please test and establish for yourself our products' suitability for your particular purposes.