

PUR hot melt adhesive

Application: For wrapping wood and plastic profiles with PVC foil, with veneers with or without fleece-backing, or with decor papers.

Characteristics/ Directions for Use: Crosslinking within a few days, depending on humidity and material moisture. Processing with special equipment (exception: hobcock bag melters with direct adhesive feed into a slot nozzle) from moisture-proof sealed containers. The adhesive may be applied with slot nozzles or roller applicators. Plastic profiles have to be primed with the respective Jowat® Primer.

Processing temperature [°C]:	130 – 150	(depending on application)
Appearance:	opaque	
Density at 20 °C [g/cm ³]:	approx. 1.1 ± 0.1	(Jowat test method)
Softening range [°C]:	approx. 55 ± 5	(Kofler bench)
Open time at 140 °C [s]:	approx. 35 ± 10	(Jowat test method)
Reaction time [d]:	approx. 2 – 5	(dep. on ambient conditions)

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

Specification: Viscosity at 140 °C [mPas]: 35,000 ± 5,000
(Brookfield, Thermosel, spindle 28, 5 rpm)

Cleaning: If necessary, flush out hot melt remnants from the melt and applicator units with Jowat® Flushing Agent 930.74 (red). Crosslinked, solid material has to be dissolved with Jowat® Cleaner 930.60 (please test for suitability before use). For more information, please refer to the "PUR hot melt Manual" under the heading "Maintenance and Cleaning" (available upon request).

Storage: In original sealed containers, cool and dry (15 – 25 °C). Best-before date, please refer to label on the packaging unit.

Packaging: Moisture-proof sealed containers. Types of packaging and units upon request.

Remarks: **For further information concerning safety, 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.

06/17 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 refer to the last page of this technical data sheet for additional information.

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.

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