Jowatherm® PUR

PUR hot melt adhesive

607.40/41

Application:

Edgbanding
For bonding thermoplastic edgebands (e.g. ABS, PP, PVC), edgebands made of resinated décor paper or solid wood edges.
Processing with high-speed wrapping units is possible.
The properties of the bonded parts and, where necessary, the reverse primer coating of the edgebanding materials have to undergo application-related testing prior to use.

Directions for use:

Processing with special equipment from moisture-proof sealed containers.
Different types of hot melt adhesives may be incompatible with each other depending on the formulation. Therefore, we recommend to carefully clean the application equipment when changing the product. Further information is available on request.

Customer trials are required.

Typical Key Data:

Processing temperature [ºC]:	130 – 150 (266 – 302 ºF)
Appearance:	Final digit 0 = beige Final digit 1 = white
Softening range [ºC]:*	approx. 70 ± 5 (158 ± 9 ºF) (Kofler Bench)
Open time at 140 ºC (284 ºF) [s]:*	approx. 8 ± 2
Reaction time [d]:	Approx. 4-7 (depending on ambient conditions)

* According to Jowat test method.

Our application Technology Department and our Application Specialists will provide technical data to assist you in your choice of an appropriate adhesive for your requirements. Please observe the information in the section “Remarks”.

Requirements for a High-Quality Bonding Process:

The properties (e.g. surface tension, plasticiser content…..) and the conditioning of the substrates, as well as the processing conditions (e.g. ambient temperatures, humidity…) will influence the processes of joining and bonding. Customer tests under consideration of everyday production conditions are therefore absolutely necessary to define stable process parameters and to ensure that the product is fit for purpose. For best bonding results, the materials to be bonded should be free of dust, oil and grease, and be dry. Ideally, the minimum temperature should be at 18 ºC (64 ºF). Avoid draught.

Specification:

Viscosity at 140 ºC (284 ºF) [mPa·s]: (Brookfield, Thermosel, Spindle 28, 5 RPM)	75,000 ± 25,000
Density at 20 ºC [g/cm}: (Jowat test method)	1.36 ± 0.06

Cleaning:

If necessary, flush out hot melt remnants from the melt and applicator units with Jowat Flushing Agent 930.94.
For more information refer to the “PUR hot melt Manual” under the heading “Maintenance and Cleaning” (available upon request)

Storage:

May be stored in properly closed original containers, cool and dry (15-25°C (59-77°F)). Best before date, please see container label. After the elapse of the best-before-date, it is essential that you again verify that the product is fit for your intended application.
Protect from moisture

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All data indicated are characteristics represented as average values. Our technical data sheets are periodically revised to represent the latest state of technology. This edition is replacing and superseding 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 Adhesives

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Packaging: Information about packaging types and units is available upon request.

Remarks: **For further information concerning handling, transport and disposal, please refer to the Safety Data Sheet.**
The information on this data sheet is based on test results from our laboratories as well as on reported experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding upon Jowat, nor should it be relied upon in lieu of your own required testing. 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 the information contained herein nor from the information provided by our free technical advisory service.

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JOWAT Corporation Information

Gluing, as one of the most efficient methods of bonding, is constantly 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 constantly being improved and developed.

The in-house R&D department of JOWAT Corporation ("JOWAT") is responding with intensive efforts to keep pace with these constant changes. A highly trained and qualified team of chemists and engineers are using the latest techniques and the brightest ideas to provide adhesives that meet the needs of our customers for new and innovative applications.

We have assimilated information based on test results from our laboratories as well as on experience gained in the field by working with our customers. This information is available by contacting our technical service department. Customers who have obtained information and thereafter undertake modifications during a running production are invited to provide this information to us to assist us in maintaining our field information and obtain any updated information we may have. However, any technical information we provide is provided without any representation or warranty and for informational and assistance purposes only, and must not be relied upon or used to replace field testing by the user of the adhesive in the actual application for which the adhesive is to be used. Our laboratory testing and field information obtained cannot simulate all eventualities that may occur in each specific application, and for that reason we cannot and do not insure performance or results in specific applications.

Any user of adhesives manufactured by JOWAT must test the adhesive(s) for suitability in each individual application, performing such tests in connection with the first use of a sample as well as all subsequent modifications during any ongoing production.

In addition to such other tests the users of our adhesives deem appropriate to insure suitable bonding, all users of adhesives manufactured by JOWAT should test the adhesives for suitability on original parts equal to normal processing conditions. The adhesive bond should then also be tested and assessed by subjecting it to the actual stress and conditions it will undergo in all of its intended and reasonably foreseeable uses. ALL OF THESE TESTS ARE ABSOLUTELY NECESSARY AND MUST BE PERFORMED.

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