

Timbond HM77 Hot Melt Edgebanding Adhesive



Universal use



High initial tack



Good post-melt properties

Benefits

- Universal use
- Good post-melt properties
- Suited for pre-coating melamine resin edges

Typical applications:

Bonding of:

- Primed polyester edges
- Melamine resin edges
- PVC, PP and ABS edges with pre-treated back
- Resined impregnated paper edges
- Massive and veneer edges

Product description

Timbond HM77 Hot Melt Edgebanding Adhesive is a medium viscous adhesive with super high initial tack for edgebanding and edge pre-coating. Bonds polyester, melamine, PVC, abs and many other forms of edging.

Application devices

- Automatic edge banding machines with roller application
- Automatic edge bonding machines with sword nozzle application
- Edge pre-coating equipment

Temperature control

Regularly check the temperature directly at the application system by means of a laboratory thermometer, a bimetal thermometer or by a thermometer with electric contacts. Re-adjust it, if necessary.

The thermometers installed in the machine may give incorrect readings after extended use.

Line feed

- 20-40m/min
- Higher speeds only after own testing

Application quantity

The quantity to be applied should be adjusted in such a manner as to slightly show on the edge of the part to be glued. In order to check whether the adhesive film is continuously applied, a strip of transparent rigid PVC can be used.

Packaging

Available in 6.25kg, 25kg

Storage

Keep Timbond HM77 in an airtight container stored in a cool dry place. If stored in correct conditions it can be stored for approximately 2 years.

Consumption for edge pre-treatment

80-100 g/m²

Post-treatment

The bonded material can be further processed immediately after application (sawing, routing, planing etc).

Attention

When hot melt adhesives are melted and applied, vapours are set free and an unpleasant odour can occur, even if the recommended working temperature has been observed. Moreover if the prescribed working temperature is exceeded over a longer period, harmful decomposition products can develop. Precautions should be taken to eliminate the vapours, e.g. by using a suitable ventilation system.

Technical data

Base	EVA copolymers
Specific weight	approx. 1.42 g/cm ³
Viscosity Brookfield HBTD Sp. 27/ 10 rpm at 200 °C	65,000 ± 10.000 mPa s
Melt index according to DIN EN ISO 1133 (MFI 150/2, 16):	50 ± 15 g/ 10 minutes
Softening point (ring + ball)	105 ± 5°C
Form	Granules
Colour	Ivory
Cleaner	Timbond C101/Timbond C105

IMPORTANT NOTICE: This datasheet is for general guidance only and may contain inappropriate information under particular conditions of use. All recommendations and suggestions are therefore made without guarantee. Samples will be provided on request to enable customers to satisfy themselves as to the suitability of the product for any specific purpose and to assess the product under their own working conditions.