

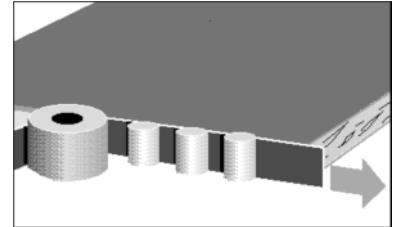


Technical Information

DORUS Q 614



EVA Hotmelt Adhesive for Pre-Coating of Edgbanding Material



Characteristics

- Low viscosity
- Fast melting
- Good machine running behaviour, clean application
- Good wetting
- High final bond strength

Fields of application

- Edgepre-coating as from approx. 12 m/min
 - Edging material: veneer, melamine
- *Suitability depends on the individual characteristics of the edging material and how it is primed.*

Technical data

Softening point (Ring & Ball):	approx. 105 °C (221 °F)
Viscosity (Brookfield):	approx. 125 000 mPa·s / 180 °C (356 °F)
	approx. 75 000 mPa·s / 200 °C (392 °F)
Heat resistance:	approx. 80 °C (176 °F)

tested with 0.6 mm oak veneer using the DORUS method of increasing temperature

Instructions for use

Recommended working temperature	
in the melting container:	190 - 200 °C (374 - 392 °F)
at the application roller for pre-coating:	170 - 190 °C (338 - 374 °F)

Colour available

Natural

Delivery form

Granules

Storage

Shelf life of at least 1 year if stored in a cool and dry place.

Labelling

Hazardous warning labelling according to GefStoffV and EU Directives not required.

Safety

Hotmelt adhesives give off vapours even when the specified working temperature is not exceeded. The smells emitted may often cause irritation. When the specified temperatures are considerably exceeded over a longer period of time, there is the additional danger of decomposition products being given off. Therefore measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment.

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The information provided herein, especially recommendations for the usage and applications of our products, is based on our knowledge and experience. Due to different material used as well as to varying working conditions beyond our control we strictly recommend to carry out intensive trials to test the suitability of our products with regards to the required process and applications. We do not accept any liability with regards to the above information or with regard to any verbal recommendation, except for cases where we are liable of gross negligence or false intention.

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