

# JOWATHERM

## Edgebanding Hot Melt

280.10

<b>Basis:</b>	Ethylene - Vinyl Acetate (EVA)
<b>Technical Data:</b>	Viscosity (mPas/cPs): approx. 250,000 at 190°C (374°F) Brookfield-Thermosel approx. 170,000 at 200°C (392°F) approx. 120,000 at 210°C (410°F) Density (g/ml): approx. 1.05 (8.8 lbs./gal) Softening Point: approx. 120°C (248°F) Ring & Ball Color: natural
<b>Characteristics:</b>	High viscosity hot melt with high heat resistance and good cold flexibility. Excellent color and heat stability in the melt.
<b>Applications:</b>	Hot melt for automatic edgebanding suitable for solid wood, veneer, PVC and resinated paper edgebands. Also used for softforming application (especially on BAZ and Combiformer machines).  The structure of the edge material and working conditions may influence the bond.
<b>Directions for use:</b>	Application Temp: 190-210°C (374-410°F) Feed Speed: roller application: 18-60 m/min (50-180 ft/min) nozzle application: 10-40 m/min (30-120 ft/min)
	Tested according to Jowat test methods. Customer trials are recommended.
<b>Cleaning:</b>	Preliminary cleaning while hot by scraping with a spatula; when cold with Jowat Cleaner 401.20.
<b>Storage:</b>	At least 3 years from the date of manufacture in dry and cool (15-25°C/58-76°F) conditions according to our experience.
<b>Packaging:</b>	In plastic bags of 55 lbs. net.
<b>Marking:</b>	None. We recommend drawing off any vapors which may form. Consult Material Safety Data Sheet.
<b>Date Revised:</b>	May 2002 (S)

The information contained in this leaflet is based upon our practical experience and the results of tests in our laboratory. The information contained represents average values under our test conditions. Although our testing is constantly being revised to represent the latest conditions, the information provided in this leaflet and by our free technical information service should be used only as a guide, but cannot be relied upon as a guaranty of performance or results. We strongly recommend that any user of our products conduct its own testing.

SEE THE BACK OF THIS PAGE FOR ADDITIONAL IMPORTANT INFORMATION.

**Jowat**  
Adhesives

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