



Adhesives for
Edgebanding

EDGBANDING ADHESIVES

Adhesive Product Selector

PRIMARY APPLICATION	ADHESIVE	DESCRIPTION	PRIMARY APPLICATION	ADHESIVE	DESCRIPTION
Thin Edgebanding	KS 207	Economy EVA	Low Speed, Manual Contour	KS 224/2	As low as 10 m/min (33 fpm)
	KS 208/2	General purpose EVA		KS 351	Clear Unfilled
	KS 217	High performance EVA	Softforming	KS 201/4	Veneer or Melamine
Thick, PVC, ABS, PP, Veneer	KS 205	Rubber modified ultimate bond strength	BAZ, Workcenter	KS 351	EVA for automatic edgebanders
	KS 217	High performance EVA		KS 230	EVA for automatic edgebanders
	KS 351	Clear Unfilled	Nordson PURBlue™ melters	PUR 270/7	2 Kg sealed cartridges
HOLZ-HER Glu Jet Cartridges	HKP 20	Premium Unfilled	HPL	ND 183/1	Primer coating for HPL strips
	HKP 21	General purpose EVA		KS 205	High Strength but flexible joint
	HKP 25	High performance EVA	Solid Wood	ND 183/1	Primer coating for Teak, Oak +
	HKP 27 / HKP 29	PUR Ultimate waterproof, heat resistant		KS 205	High Strength but flexible joint
High Heat Resistance	HKP 27 / HKP 29	150°C heat resistance		KS 217	HOL-ZER Granupress systems
	KS 270/7	150°C heat resistance		KS 351	Softforming even with difficult to bond profiles
	KS 300	120°C heat resistance			
Low Temperature	KS 224/2	120°C application temperature			

Adhesive List - Technical Data

PRODUCT	TECHNOLOGY	VISCOSITY (Brookfield) AT 200° C (392° F) IN MPAS	SOFTENING POINT	HEAT RESISTANCE	GLUE POT TEMPERATURE	MINIMUM FEEDRATE (m/min)
HKP 20	EVA, Unfilled	75,000	110°C	90°C	190°C - 200°C	10
HKP 21	EVA, Filled	87,500	108°C	90°C	190°C - 200°C	10
HKP 25	EVA, Filled	55,000	108°C	90°C	190°C - 200°C	10
HKP 27	PUR	50,000	75°C	150°C	150°C - 160°C	10
HKP 29	PUR	40,000	80°C	150°C	150°C - 160°C	10
KS 201/4	EVA, Filled	150,000	148°C	110°C	210 - 220°C	18
KS 205	EVA, Filled	155,000	120°C	90°C	200 - 220°C	15
KS 207	EVA, Filled	55,000	95°C	85°C	180°C - 200°C	20
KS 208/2	EVA, Filled	100,000	110°C	90°C	180 - 200°C	15
KS 217	EVA, Filled	55,000	105°C	90°C	180°C - 200°C	12
KS 224/2	EVA, Filled	10,000	85°C	75°C	120 - 140°C	10
KS 230/1	EVA, Slightly Filled	70,000	125°C	90°C	180 - 200°C	15
KS 270/7	PUR	45,000	80°C	150°C	120°C - 140°C	10
KS 300	Polyolefin	95,000	155°C	120°C	180 - 200°C	20
KS 351	EVA, Unfilled	75,000	110°C	90°C	180°C - 200°C	12

Cleaner List - Technical Data

PRODUCT	TECHNOLOGY	VISCOSITY (Brookfield) AT 130° C (226° F) IN MPAS	SOFTENING POINT	HEAT RESISTANCE	GLUE POT TEMPERATURE	CLEANING TEMPERATURE
Cleaner 2	Hot Melt	5,500 - 7,500	68°C -76°C	120°C	100°C - 170°C	120°C
Cleaner 4	Hot Melt	10,000	75°C	120°C	100°C - 170°C	120°C

Stocked Parts

EVA Hotmelt Adhesive

The range of DORUS® - TECHNOMELT® EVA hotmelts is suitable for manual and automatic applications, straight-line and curved panel shapes. These hotmelts can also be used with a variety of edgebander types such as HOLZ-HER®, BIESSE®, IMA® and HOMAG® machines.

Cartridge

PRODUCT	FORMAT	TECHNOLOGY	PACKAGING	PART NUMBER				
				NATURAL	WHITE	BROWN	BLACK	CLEAR
HKP 20	Cartridge	EVA, Unfilled	45 / Case - 26 lb					7501001
HKP 21	Cartridge	EVA, Filled	45 / Case - 33 lb	7501000	7501002			
HKP 25	Cartridge	EVA, Filled	45 / Case - 33 lb	7501004	7501005	7501006	7501007	

Granular

PRODUCT	FORMAT	TECHNOLOGY	PACKAGING	PART NUMBER				
				NATURAL	WHITE	BROWN	BLACK	CLEAR
KS 201/4	Granular	EVA, Filled	55 lb Bag	7501009				
KS 205	Granular	EVA, Filled	55 lb Bag	7501014	7501016			
KS 207	Granular	EVA, Filled	55 lb Bag	7501069	7501078			
KS 208/2	Granular	EVA, Filled	55 lb Bag	7501020	7501022		7501026	
KS 217	Granular	EVA, Filled	55 lb Bag	7501031	7501033	7501035		
KS 224/2	Granular	EVA, Filled	55 lb Bag	7501058				
KS 230/1	Granular	EVA, Slightly Filled	55 lb Bag	7501079				
KS 351	Granular	EVA, Unfilled	55 lb Bag					7501068

PUR Hotmelt Adhesive

The perfect solution is PUR Adhesive -- especially in high humidity areas, such as bathrooms and kitchens or extreme heat exposure, such as during transportation to Southern locations. The mechanical bonding between the Edgebanding and the panel builds a permanent link. PUR Adhesives need to be cleaned out with Cleaner 2 or Cleaner 4.

Cartridge

PRODUCT	FORMAT	TECHNOLOGY	PACKAGING	PART NUMBER	
				NATURAL	WHITE
KS 27	Cartridge	PUR	6 / Case - 3.5 lb		7501077
KS 29	Cartridge	PUR	6 / Case - 3.5 lb	7501090	

Slug

PRODUCT	FORMAT	BASE	PACKAGING	PART NUMBER	
				NATURAL	WHITE
PUR 270/7	Slug	PUR	8 / Case -35 lb	7501080	7501081

Granular

PRODUCT	FORMAT	BASE	PACKAGING	PART NUMBER	
				NATURAL	WHITE
PUR 270/7 G	Granular	PUR	16 bag/Case - 35 lb	7501084	7501085

PUR Hotmelt Adhesive Cleaners

Purging agents that must be used to clean out PUR Adhesive from woodworking equipment.

PRODUCT	FORMAT	CORRESPONDING ADHESIVE	PACKAGING	PART NUMBER
				BLUE TINT
Cleaner 2	Slug	PUR 270/7	8 / Case - 17.5 lb	7501082
Cleaner 2	Cartridge	HKP 27 & HKP 29	8 / Case - 1.8 lb	7501003
Cleaner 4	Granular	PUR 270/7 G	16 Bags / Case - 26.5 lb	7501089

Polyolefin Adhesive

Higher heat resistance, viscosity and bond strength than EVA Adhesive. Polyolefin Adhesive can be used in lieu of PUR where extreme heat resistance is not requirement.

PRODUCT	FORMAT	TECHNOLOGY	PACKAGING	PART NUMBER
				NATURAL
KS 300	Granular	Polyolefin	55 lb Bag	7501013

Primers

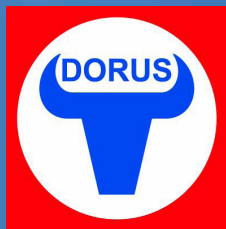
Doellken recommends the use of ND 183/1 Primer for all difficult to bond. Edgebanding materials – such as high pressure laminates and solid wood.

PRODUCT	FORMAT	TECHNOLOGY	PACKAGING	PART NUMBER
				CLEAR
ND 183/1	Liquid	Dispersion	22 lb Jug	7501056

Sealers

Ideal for kitchen cabinets and bathroom vanities, the Doellken Aqua Stop Pen seals the joint between the Edgebanding and board. The result is a watertight joint.

PRODUCT	PACKAGING	PART NUMBER
		CLEAR
Aqua-Stop-Pen	Individual Pen	1-999999-004



TECHNOMELT®

Doellken is proud to be the exclusive North America distributor for DORUS®-TECHNOMELT® high-quality hotmelt Adhesives. Our stock program includes EVA and PUR hotmelts in cartridge (for HOLZ-HER® edgebanders) and granular form, filled and unfilled. We can also provide PVA white glues.

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