TECHNOMELT DORUS HKP 20

Known as Dorus HKP 20

April 2013

PRODUCT DESCRIPTION
TECHNOMELT DORUS HKP 20 provides the following product characteristics:

<table>
<thead>
<tr>
<th>Technology</th>
<th>EVA</th>
</tr>
</thead>
<tbody>
<tr>
<td>Product Type</td>
<td>Hotmelt Cartridge for HolzHer Edgebander unfilled</td>
</tr>
<tr>
<td>Application</td>
<td>Edgebanding</td>
</tr>
<tr>
<td>Appearance</td>
<td>Cartridges Transparent</td>
</tr>
</tbody>
</table>

Application Areas
- Edgebanding in HolzHer cartridge equipment as from feedrates of 10 m/min
- Edging material: solid wood, veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*
- Particularly suitable for solid wood

* Suitability depends on the individual characteristics of the edging material and how it is primed.

Product Properties
- Universal hotmelt adhesive
- Fast melting
- Very good wetting
- High glue mileage
- Produces tight joints virtually not visible
- High final bond strength
- Very high heat resistance

Technical Data
TECHNOMELT DORUS HKP 20:
- Softening Point, Ring & Ball, °C ~110
- Viscosity, Brookfield - 200 °C, mPa.s ~75,000
- Heat Resistance, °C ~90
- Tested with mm oak veneer using the Henkel method of increasing temperature.

Instructions for Use

Working Temperature
Recommended working temperature:
- at the application nozzle, °C 200 to 220
- Particular in case of long and thick panels a higher processing temperature should be chosen. Sufficient high pressure is to be applied to press the edging material into the hotmelt beads and to obtain an even hotmelt film. If possible, use only straight edges, never twisted or strongly bowed ones. If slightly bowed, insert into magazine so that concave side faces panel. Thin coating with primer e.g. TECHNOMELT PRIMER 183/1 may improve the adhesion of difficult-to-bond edges.

- Material and room temperature, °C ≥18
- Material moisture, % 8 to 12
- Heating time, minutes 2 to 4

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.

STORAGE
Store in the original tightly closed packaging in a cool, dry place.

- Shelf life
  - Shelf-life (in unopened original packaging), years 2

Classification:
Please refer to the corresponding safety data sheets for details on:
- Hazardous Information
- Transport Regulations
- Safety Regulations

DIRECTIONS OF USE

Preliminary Statement
Prior to application it is necessary to read the Material Safety Data Sheet for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.
ADDITIONAL INFORMATION

Disclaimer

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