



Dorus® Q-654

TYPE OF ADHESIVE:	EVA Hotmelt Adhesive
FIELD OF APPLICATION:	Woodworking > Edgebanding
BENEFITS:	High viscosity Slightly filled Fast melting High glue mileage Very high heat resistance Clean machining Produces tight joints – Virtually invisible Yields smooth surfaces with flexible materials Very good wetting on difficult edge-banding materials

TYPICAL TECHNICAL DATA:

Color:	Natural & White
Form:	Granules
Heat Resistance	Approx. 95°C (203°F)
Softening Point (R&B):	Approx. 115°C (239°F)
Viscosity	Approx. 280,000mPa's / 180°C (356°F) Approx. 170,000mPa's / 200°C (392°F)

Tested with 0.6mm oak veneer using the Dorus method of increasing temperature

Recommended Working Temperature	180-200°C (356-392°F)
In Melting Container At App Roller/Nozzle	190-210°C (374-410°F)

APPLICATION:

Edge-banding at speeds of 15 m/min or greater
Edging material: solid wood, veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*
*Suitability depends on the individual characteristics of the edging material and how it is primed.
Suitable for processing centers (BAZ) with direct application
Soft-forming

PRECAUTIONS:

No health hazards are expected with this product in its solid form. Once melted, it is like any hot liquid in that it can produce severe burns. Care should be taken to avoid getting the hot liquid adhesive on the skin. If this occurs, flush the affected area with large amounts of cold water. Do not try to remove the solidified hot melt. Seek Medical Attention immediately. Adequate ventilation is highly recommended.

Please refer to the Material Safety Data Sheet for further safety information.

STORAGE CONDITIONS:

Shelf life of at least 1 year if stored in a cool and dry place.
Shelf Life: 1 year
REV07