

TECHNOMELT DORUS HKP 21

Known as Dorus HKP 21
November 2014

PRODUCT DESCRIPTION

TECHNOMELT DORUS HKP 21 provides the following product characteristics:

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|---------------------|---|
| Technology | EVA |
| Product Type | Hotmelt |
| Application | Edgebanding |
| Appearance | Cartridges Natural White Brown |

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*

* 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

Technical Data

TECHNOMELT DORUS HKP 21:

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| Softening Point, Ring & Ball, °C | ~108 |
| Viscosity, Brookfield - 200 °C, mPa.s | ~87,500 |
| Heat Resistance, °C Tested with mm oak veneer using the Henkel method of increasing temperature. | ~90 |

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.

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

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