

**TECHNICAL DATA**

# TERMOKOL 2039

**wrapping adhesive****DESCRIPTION**

TERMOKOL 2039 is unfilled hot melt adhesive for wrapping with decorative paper.

**FIELDS OF APPLICATION**

The adhesive is used for wrapping wood and wood based materials with decorative paper foils where low spread quantity is required. Adhesive joints are transparent and heat resistant.

**CHARACTERISTICS**

Chemical base	EVA copolymers
Viscosity at 200°C (ASTM D 3236)	app. 5000 mPas
Viscosity at 170°C (ASTM D 3236)	app. 10 000 mPas
Softening point (ASTM E-28, Ring & Ball)	90 - 95°C
Colour	transparent (yellowish)
Marking	not subject to marking according to legislation on dangerous materials

**APPLICATION**

Before gluing the adhesive must reach working temperature. Lower working temperatures causes unsuccessful gluing, higher temperatures, maintained for some time will damage the adhesive. At longer interruptions or deadlocks it is recommended to lower working temperature on 150°C.

As the thermostats can give misleading temperatures we recommend to control the temperature of the adhesive on the roll applicator regularly.

The supporting material must be dry, free of dust, acclimatized to room temperature (min. 18°C). Avoid the draught.

Take into account working instruction of profile wrapping machine producer.

Working conditions, engagement of machine, operating mode, structure of paper,... influence the quality of gluing essentially.

**The most convenient binding conditions are:**

temperature of material and environment	18 - 25°C
relative humidity	50 - 60%
moisture content of wood	8 - 10%
working temperature on the application rolls	170 - 200°C
glue applied	40 - 100 g/m <sup>2</sup>
feed speed	min. 20 m/min.

Spread quantity depends on quality of wooden board and thickness of foil.

If the working conditions considerably differ from that mentioned above, the quality of junction will not be satisfactory.

**CLEANING**

The melting pots should be cleaned at regular intervals. Excessive buildup of charred materials will reduce the overall effectiveness of the heaters and impair heat transfer. For removal of adhesive residue when the pot is cold, we recommend a mixture of methylene chloride and toluene in a 1:1 ratio.

**PACKING**

plastic bags 25 kg net

**STORAGE**

TERMOKOL 2039 should be stored in a cool and dry place at temperatures below +25°C far away from heat sources. Shelf life of properly stored adhesive is minimum 3 years.

The information provided herein, especially recommendations for the usage and application of our products, is based on our knowledge, results of laboratory tests and practical experience gained to date.

We guarantee a constant quality of our products under our technical specifications. Technical advice of our application department is available without obligation. This does not release the buyer from testing our products in his own responsibility with respect to their suitability for intended application and application process. Such an evaluation should be repeated if materials are changed in any way or bought from a different source.

We do not accept any liability with regard to above information or with regard to any verbal recommendation since different materials used in conjunction with our products as well as varying working conditions are beyond our control.