

Strong Glue 121

USE

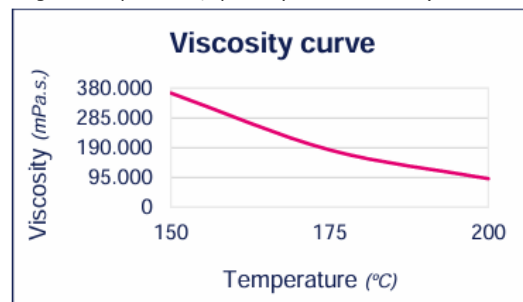
Strong Glue 121 is EVA based highly filled hot melt for the wood working industry. Edge banding (automatic and manual) with thermoplastics (primed PVC, PP and ABS edge bands 0,4 – 1,0mm), fleece backed veneer, solid wood and HPL.

Characteristics

- Filled and therefore good 'gap' filling properties
- Dissolves easily due to the small prill size which will save energy and cost
- High viscosity
- Good temperature resistance

TECHNICAL SPECIFICATION

Base:	EVA
Viscosity at 200 °C:	90 000 mPa.s (<i>depending on temperature, quantity and substrate</i>)
Appearance:	prills
Colour:	121.12 = natural 121.11 = white
Softening Point (<i>R&B</i>):	approx. 110°C
Open time (<i>DSC method</i>):	approx. 25
Density (@20°C):	1,60 ± 0,05 g/cm ³



INSTRUCTION FOR USE

Ambient temperature and material:	18 – 20 °C
Application temperature:	170 – 200 °C
Application:	all major types of edge banding machines (<i>roller application, nozzle application</i>)
State of substrates:	dry, clean, free of dust and grease
Recommended moisture content of the wood (%):	8 – 10
Line speed (m/min.):	7 – 30 m/min ; 5 – 20 (for low temp. application)

We recommended the use of suitable equipment for processing hotmelt adhesives, which is set to the desired application method and the extent of adhesion. Apply the adhesive to the surface free of dirt and dust.

Adhere to the application temperatures of the environment and material as various glued joint failures occur when gluing cold and damp surfaces. Check the temperature of the adhesive continuously in the application equipment. Temperatures lower than those recommended for application, cause higher adhesive consumption, shortened open time, higher temperatures can cause discoloration, viscosity and stickiness and consequently poor bonding results. Avoid overheating of the adhesive above 210 °C. If the adhesive is not working, it is recommended to switch of the device or at least put in into a "stand by" temperature mode so that it does not overheat unnecessarily and maintains the adhesive properties of the unused amount of adhesive. Product colour may vary due to different raw material batch. This change does not affect the product.

The structure of the bonded material and the application conditions affect the bonding, so it is advisable to carry out your own tests. Failure to observe storage and processing conditions will adversely affect bonding results.

CLEANING

Pre-clean while still warm with a spatula.

Glue residues from the melter and hoses can be removed with Termomelt 301. We recommend using AG-Silicone spray to protect plastic, metal and rubber parts. AG-CLEAN M01 is used to clean metal surfaces of machines, applicators and machine parts.

STORAGE

The minimum storage time in original and well-sealed packaging, dry and cool place at temperature between 10 °C to 35 °C is 12 months from removal from storage. Do not expose to direct sunlight or heating sources.

HEALTH AND SAFETY INSTRUCTION

Do not touch the molten adhesive. In case of hot burns, wash the affected area with cold water. Cover with a clean bandage, do not remove the adhesive. Further handling, transport and disposal warnings are provided in the corresponding safety data sheet.

The data in this technical sheet is based on our practical experience and laboratory test results. As they cannot take into account all possible uses, they are not-binding. The data are neither a guarantee of quality nor assurance of properties. No legal claims can be drawn from these data, as well as from our free technical advisory service. Values are continuously updated according to the latest technology. This edition replaces all previous releases and is valid as of that date.