

It is a thermoplastic hotmelt adhesive based on synthetic resin and EVA

Application Areas:

DOLLKEN D8827 is a strong adhesive used for bonding PVC, ABS, POLYSTER, HPL and Melamine edge banding in edge banding machines

Technical Specifications:

Colour	Yellow Transparent
Appearance	Granular
Viscosity	92000 ± 15000 mPa.s (190°C de spindle 29 50 rpm)
Softening Point	115 ± 3°C

Application:

Humidity in Product	8 - 10%
Humidity in Air	65 - 75%
Environ Temperature	>15°C
Temperature of Tank	180 - 200°C
Temperature of Roller	180 - 200°C

Usage:

Environment temperature must be around 15°C during the application process. Adhesive must be applied to one surface of the material to be adhered. Air humidity should be 65 - 75% and product humidity should be 8 - 10%

Packaging:

20kg Paper Bag

Shelf Life:

Shelf life is 12 months at room temperature (18-20°C)

Recommendations:

On undesirable oil and dust surfaces, it prevents the formation of a strong bond and the desired strength cannot be obtained

The temperature inside the adhesive tank should be considered and be controlled frequently due to changes in weather & conditions. During season changes adhesive temperature must be measured by thermometer devices

The temperature of the application surface and environment must be higher than 15°C. Otherwise, successful results cannot be achieved due to faster drying time

Adhesive tank should be cleaned frequently

The amount of the adhesive, which is applied on the surfaces, can vary due to type of the materials. Some undesired results may occur such as over usage and inadequate usage. In these cases, glue setting should be applied.

In case of giving a pause, adhesive temperature must be bonded at 100-110°C to keep performance higher and a prevent glue from burning

This technical spectral content is of a general nature and does not constitute a guarantee

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