



Technical Specifications Tece Hot Melt 48 (THM 48)

Product Name

Tece Hot Melt 48 (THM 48) Transparent Hot Melt for Edgebanding machines.

Producer

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Description

Tece Hot Melt 48 (THM 48) is thermoplastic synthetic resin adhesive based on VA-elastomers. THM 48 is used on automatic edgebanding application machines / manual edgebanding machine. The adhesive melts and flows very well offering a medium heat resistance and very good adhesive properties. THM 48 contains no calcite filler to be more transparent.

THM 48 is suitable for the application of the following edgebanding:

- Plastic edgebanding preheated with a good primer
- Melamine edgebanding
- Veneers edgebanding with fleece or without fleece

Specifications

Color : White transparent.

Machinery : This hot melt has been used on many kinds of curved edgebanding machines. From Homag to SCM, Biesse, from Turanlar to other brands in the world. All results have been satisfactory as long as the application method is right.

View : Solid round pellets

Instructions for Use

- Environment Temperature : 15 - 22 °C
- Panel Temperature : > 15 °C
- Humidity in Product : 8 -10 %
- Humidity in the Air : 65-75 %
- Amount to be Applied : 150 – 200 gr /m²
- Temperature of Tank : 170 -190 °C
- Roller Temperature : 180 -190 °C
- Application Speed : 8 -15 meter / min
- Application Pressure : 3-5 Kg. / cm²





Recommendations

- The application surface must be cleaned from dust, dirt and grease. Undesired dust and grease prevent to achieve a successful result of endurance and a strong bonding. The pressure must be applied homogenously to all edges of the panel. The temperature of the adhesive tank must be controlled often to make sure that it is in the right range.
- The temperature of the application surface and environment must be higher than 15°C.
- Otherwise, successful results may not be achieved due to faster drying time.
- Adhesive tank should be cleaned often.
- The bonded material's resistance against to heat is directly proportional to twisting, shortening, elongation of the edgebanding.
- The remained hot melt in the tank should not heated and cooled too many times. Other the glue loses its adhesion properties.



Packaging

24 kg in plastic buckets.



Storage

Dry and cool area, it can be stored for 12 months period.



Caution

Even if the recommended working temperatures are observed, hot melt adhesives will give of fumes often causing unpleasant odors. To avoid that danger, measures should be taken to remove the vapors by some sort of air exhausters.