

## Technical Specifications Tece Hot Melt 506 (THM 506)

### Product Name

Tece Hot Melt 506 (THM 506) Hot Melt for Curved Edgebanding Application

### Producer

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### Description

- THM 506 is a special hot melt glue which is used in the application of edgebanding to curved panel in curved edgebanding machines.
- This adhesive can be used for **PVC , ABS** and **Veneer edgebanding** application.
- The panel can be plywood, MDF, or Chipboard.
- This hot melt is suitable for only curved edgebanding machines which goes on manual speed.

### Specifications

**Color** : It can be white, natural wood color, black or another other color requested by the customer.

**Machinery** : This hot melt has been used on many kinds of curved edgebanding machines. From Homag to SCM, 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.

**Viscosity** : 40000 ±3000 mPa.s (140 oC de spindle 29 100 rpm) Softening point: 80 ± 1 oC.

### Application Temperature

140-160 oC should be set in the edgebanding machine.

### Technical Specifications

- Environment Temperature : 15 - 22 °C
- Panel Temperature : > 15 °C
- Humidity in Product : 8 -10 %
- Humidity in the Air : 65-75 %
- Amount to be Applied : 220 – 350 gr /m2
- Temperature of Tank : 120 - 140 °C
- Roller Temperature: 120 - 140 °C
- Application Speed : 5 - 10 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.
- In case of having a break, adhesive temperature must be kept at 100-110C to keep performance higher.
- 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. Otherwise, the EVA glue loses its adhesion properties.



## Packaging

24 kg in plastic buckets.