



## AKFIX HM774 EVA HOT MELT STRAIGHT EDGE BANDING ADHESIVE

### 1 – DESCRIPTION

**Akfix HM 774** is a synthetic resin and EVA based hot melt adhesive of thermoplastic characteristic that gives perfect results with straight edge banding works.

### 2 – PROPERTIES

Hot-Melt is used for straight edge banding, coating and massive adhesion operations on all kinds of domestic and foreign edge banding machines, also manually operated machines. It is short open time adhesive.

- Appropriate when immediate bonding is required.
- Environmentally friendly.
- Economical.
- High green strength.
- Non-sticky surfaces.
- Odourless.
- Easy to use.

### 3 - APPLICATIONS

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.

### 4- PACKAGING

Product	Volume	Package
Hot Melt Adhesive	25KG	Paper Bag

### 5- STORAGE AND SHELF LIFE

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

### 6- SAFETY

- With the help of a spatula or mechanically cleaned with xylene.
- Keep unused adhesives in closed carton and away from dusty area.



## 7- TECHNICAL PROPERTIES

<b>Color</b>	: Natural
<b>Appearance</b>	: Granular
<b>Softening point</b>	: 100 ± 4°C (Ring and Ball) (ASTM E28)
<b>Thermosel viscosity</b>	: 80000±5000 mPa.s (at 190°C, spindle 29 - 50 rpm) (ASTM D3236)
<b>Open time</b>	: 15-20 seconds
<b>Tank Temperature</b>	: 190 – 210 °C
<b>Temperature Roller</b>	: 190 – 210 °C
<b>Feeding Speed</b>	: 20 – 35 m / min.
<b>Water resistance</b>	: Excellent
<b>Roller Pressure</b>	: 3 – 5 Kg. / cm <sup>2</sup>

## 7- RECOMMENDATIONS

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 15C 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 binded at 100-110C to keep performance higher.

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