



Do it better with heart.

## 820A TDS

### 1、Product Overview

This series of products is a thermoplastic adhesive made of basic resin, viscosity modifier, tackifier, antioxidant, calcium powder and other ingredients, which is widely used in this product and is mainly used in automatic edge banding machine, suitable for rapid edge banding of PVC, veneer and melamine and other materials.

### 2、Product Features and Benefits:

- 1、 Large viscosity, good fluidity, strong adhesion, wide temperature range, short curing time, especially suitable for high-end custom furniture rapid edge banding.
- 2、 It has good cold resistance, acid and alkali salt medium corrosion resistance and thermal stability, good fixation and slip resistance.
3. The solid content is 100%, which can be continuously produced and used repeatedly without carbonization;
4. Solvent-free, pollution-free, environmentally friendly and non-toxic, easy to operate.

### 3、Technical Indicators

Technical Indicators	Indicator values
Exterior color	Primary colors, white
smell	Gentle and non-irritating
Softening point (°C) (global method).	105±5
Melt viscosity (mpa.s) (Rotor 27 of Bohlerfried, 180°C).	100000±30000
Thermal stability (160°C, 12h)	The viscosity change rate is <5%, and the softening point change rate is <5%
Density (g/cm3)	1.05-1.45
Shelf life	Two years
remark	The specific indicators are subject to the factory inspection report

#### **4、Process parameters used**

Use process parameters	Parameter value
Moisture content of the material	8-10%
Room temperature and material temperature (°C).	>15
Glue box temperature (°C).	180-210
Rubber wheel temperature (°C).	180-210
Conveying speed(m/min)	10-30
Pressurized pressure(kg/cm3)	3-5
Coating weight(g/m2)	180-250

#### **5、Enforce the standard**

The physical and chemical indexes and quality of the product are in line with the enterprise standard "Hot Melt Adhesive" Q/59467940-0-1-2021

#### **6、Safety Precautions**

For details, see: Safety Data Sheet for Hot Melt Adhesives (MSDS)

#### **7、Packaging materials and specifications**

Nylon woven bag, net weight: 25kg/bag

#### **8、The product is transported and stored far away**

During transportation, avoid heavy pressure, sun and rain.

Products should be stored in a cool, ventilated warehouse with a stacking limit of 10 floors and a storage temperature of 0-40°C.

#### **9、Use and precautions for the product**

1. It is necessary to understand and master the various types and technical properties (including technical parameters) of hot melt adhesives, and control the values of each process parameter within the specified range.

2. During the production process, please close the cover of the glue tank and keep the site clean to prevent debris from falling into the glue machine and clogging.

3. If you use other brands of products, before switching, you should use the glue in the glue box as much as possible, and then add the glue to fully melt, and then clean the mixed glue before using it.

4. Clean the preheated plastic pot regularly to keep the plastic pot clean.



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5. Plates and edge banding materials should be protected from pollution.
6. The moisture content of wood should be about 8%-10%.
7. The amount of glue in the glue pot should be grasped appropriately, and the colloid will melt in turn after adding too much, which will make it deteriorate and age, reduce viscosity, and affect the adhesion.
8. During use, pay attention to prevent burns.

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