



TECHNICAL DATASHEET

Hot melt in granulate for edge bonding



Products:

| | | |
|--------------------|----------------------|--------------------|
| DANAFIX 867 | DANAFIX 871 | DANAFIX 875 |
| DANAFIX 868 | DANAFIX 871-3 | DANAFIX 876 |
| DANAFIX 870 | DANAFIX 872 | DANAFIX 877 |

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Product description and application:

Hotmelts in granulate for edge bonding contain the series DANAFIX 860 and 870. The adhesives have good melting properties, good initial tack, minimal threading and are suitable for automatic edge bonding systems.

Most of the hotmelts are suitable for fast going production machinery with minimum machinery speed at 12-18 m/min. If slower application speed is needed DANAFIX 872 and 875 is recommended. The hotmelts has generally high heat resistance with softening points for most of them above 100 °C. DANAFIX 876 and 877 has the highest heat resistance. DANAFIX 868 has low heat of fusion, DANAFIX 870 is a transparent hotmelt without filler, DANAFIX 871 is a standard product in the colour nature, and DANAFIX 872 is especially suitable for complicated glue able materials. DANAFIX 876 and 877 differ only in colour.

Application:

Materials:

| | 867 | 868 | 870 | 871 | 871-3 | 872 | 875 | 876 | 877 |
|---------------------------------|-----|-----|-----|-----|-------|-----|-----|-----|-----|
| Paper:..... | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Polyester:..... | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Melamine:..... | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Pretreated PP:..... | | | ● | ● | ● | ● | ● | ● | ● |
| Pretreated PVC:..... | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Pretreated ABS:..... | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Veneer:..... | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Solid wood ¹⁾ :..... | | | | | | ● | | ● | ● |

1) Thickness max 15 mm.

Item number (25 kg):

| 867 | 868 | 870 | 871 | 871-3 | 872 | 875 | 876 | 877 |
|------|------|------|------|-------|------|------|------|------|
| 6288 | 6448 | 6337 | 6346 | 6317 | 6290 | 6528 | 6339 | 6345 |

Physical / chemical properties:

| | 867 | 868 | 870 | 871 | 871-3 | 872 | 875 | 876 | 877 |
|--------------------------------|--|------------------|------------------|-------------------|---------------|--------------|------------------|-------------------|-------------------|
| Type:..... | EVA copolymer | | | | | | | | |
| Color:..... | White | Natur | Transp. | Natur | Natur | Natur | Natur | White | Natur |
| Melting point:..... | 106-112°C | 98-108°C | 104-114°C | 99-109°C | Ca. 105°C | Ca. 105°C | 80-90°C | 108-118°C | 108-118°C |
| Viscosity ¹⁾ :..... | 70.000-95.000 cP | 60.000-80.000 cP | 55.000-75.000 cP | 88.000-146.000 cP | 70.000 cP | 50.000 cP | 35.000-80.000 cP | 70.000-100.000 cP | 70.000-100.000 cP |
| Machinery speed:..... | Min. 15 m/min | Min. 12 m/min | Min. 15 m/min | Min. 12 m/min | Min. 12 m/min | Min. 5 m/min | Min. 2 m/min | Min. 18 m/min | Min. 18 m/min |
| Storage:..... | Min. 2 years stored cold in original unsealed packaging. | | | | | | | | |

1) Measured at 150°C for DANAFIX 875 and 200°C for the rest.

Direction for use:

Preparation: The substrates have to go well together, be clean and dry, free of dust, oil and other loose particles. Boards and edges have to be conditioned to room temperature. Room temperature should not be lower than 18°C. Draughts have to be avoided. The most favorable moisture content of the wood is 8-10%.

Application: The adhesive is applied with standard hot melt equipment e.g. nozzle or roller. Always follow the instructions from the equipment supplier.

Application temperature:

| 867 | 868 | 870 | 871 | 871-3 | 872 | 875 | 876 | 877 |
|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|
| 190-210 °C | 170-200 °C | 180-210 °C | 180-210 °C | 180-200 °C | 160-180 °C | 130-160 °C | 190-220 °C | 190-220 °C |

The temperature should be checked directly at the application system. Too low temperature will result in bad adherence and too high temperature will destroy the hot melt. If the application system is not operation for a period of time the temperature must be set to 160 °C.

Amount of glue: The amount of glue must be adjusted so that the full width of the joint contains glue. Transparent edges can be used for checking the glue spreading.
The following amount of glue will normally be sufficient:

| 867 | 868 | 870 | 871 | 871-3 | 872 | 875 | 876 | 877 |
|-----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|
| 250-300 g/m ² | 150-250 g/m ² | 180-250 g/m ² | 180-250 g/m ² | 200-250 g/m ² | 200-250 g/m ² | 180-250 g/m ² | 180-250 g/m ² | 180-250 g/m ² |

Cleaning: The hot melt equipment is cleaned with DANAFIX 918 and the tools with DANAFIX 919.

Storage: Cold and dry in original sealed packaging (max. 25 °C).

Safety:

Hazard Symbols: None

Risk and safety phrases: None

For further information concerning safety, refer to Safety Data Sheet.

Further information:

DANA LIM offers a range of adhesives for professionals:

100-series: Upholstering adhesives
200-series: Flooring adhesives
300-series: Wall adhesives
400-series: Wood adhesives
500-series: Sealants & PU-foams
600-series: Building-additives, fillers etc.
700-series: Paper-, packaging- and newspaper adhesives
800-series: Hot melt
900-series: Cleaning-, release agents and hardeners.

In the 800-series Hot melts DANA LIM offers:

810-serien: Hot melt sticks
840-serien: Hot melt in cartridges for edge bonding
850-serien: Hot melt for assembling
860-serien: Hot melt for profile wrapping
870-serien: Hot melt in granulate for edge bonding
880-serien: Hot melt for packaging closing
890-serien: Pressure sensitive hot melt

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