



## HM220 EVA HOT MELT STRAIGHT EDGE BANDING ADHESIVE

### 1 – DESCRIPTION

**Akfix HM220** is a general purpose synthetic resin and EVA based hot melt adhesive of thermoplastic characteristic.

### 2 – PROPERTIES

Hot-Melt is used for curved 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

It is recommended that ambient temperature should be above 15°C, air moisture 65-75% and material moisture 8-10% during application, and the adhesive should spread throughout one side of the object to be adhered.

### 4- PACKAGING

Product	Volume	Package
HM 220	25KG	Bag

### 5- STORAGE AND SHELF LIFE

24 months in unopened cartridge if stored under dry and cool conditions.

### 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>	: 90 °C ± 3 (Ring and Ball)	(ASTM E28)
<b>Specific Gravity</b>	: 1,28 g/cm <sup>3</sup>	(ASTM D792)
<b>Thermosel viscosity</b>	: 100000mPas at 200°C	(ASTM D3236)
<b>Open time</b>	: 45 - 50 seconds	
<b>Tank Temperature</b>	: 180 – 200 °C	
<b>Temperature Roller</b>	: 200 – 220 °C	
<b>Feeding Speed</b>	: 10 – 27 m / min.	
<b>Water resistance</b>	: Excellent	
<b>Roller Pressure</b>	: 3 – 5 Kg. / cm <sup>2</sup>	