

Assembly Hot Melt

Basis: Ethylene - Vinyl Acetate (EVA)

Technical Data: Viscosity (mPas/cPs): approx. 19,000 at 300°F (149°C) Brookfield-Thermosel
approx. 12,000 at 325°F (163°C)
approx. 8,000 at 350°F (177°C)
approx. 5,000 at 375°F (191°C)
Density (g/ml): approx. .95 (7.9 lbs./gal.)
Softening Point: approx. 167°F (75°C) Ring & Ball
Color: yellow - translucent

Characteristics: Medium viscosity elastic hot melt with long open time, high hot tack, good color and heat stability in the melt.

Applications: For assembly applications in the furniture, electrical and metal industries. Good adhesion to difficult to adhere to surfaces (lacquered, polyester, PVC and finished paper foils).

Direction for use: Application Temp: 350-400°F (177-205°C) in the melt

Open Time at 350°F: approx. 53-54 seconds
Set Time at 350°F: approx. 13-15 seconds

Open Time at 375°F: approx. 80-82 seconds
Set Time at 375°F: approx. 23-24 seconds

Tested according to Jowat test methods. Customer trials are recommended.

Cleaning: Preliminary cleaning while hot by scraping with a spatula.

Storage: May be stored for 12 months after date of shipment from Jowat, in properly closed original containers, cool and dry (15-25°C).

Packaging: In cartons of 33 lbs. net.

Remarks: For further information concerning handling, transport and disposal, please refer to the Material Safety Data Sheet. Our information on this data sheet is based on test results from our laboratories as well as on experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding for us. The information given in this leaflet represents neither a performance guarantee nor a guarantee of properties, nature, condition, state or quality. No liability may be derived from these indications nor from the recommendations made by our free technical advisory service.

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All data indicated are characteristics represented as average values. Our technical data sheets are constantly revised to represent the latest state of technology. This edition is replacing all previous ones, and is valid on the date of compilation.
Please refer to last page for additional information.



JOWAT Corporation Information

Gluing, as one of the most efficient methods of bonding, is constantly expanding into new areas of application. At the same time, the number of substrates to be bonded is also growing at an unprecedented rate. New methods and equipment to process adhesives are constantly being improved and developed.

The in-house R&D department of JOWAT Corporation ("JOWAT") is responding with intensive efforts to keep pace with these constant changes. A highly trained and qualified team of chemists and engineers are using the latest techniques and the brightest ideas to make sure that our adhesives meet the needs of our customers for new and innovative applications.

We have assimilated information based on test results from our laboratories as well as on experience gained in the field by working with our customers. This information is available by contacting our technical service department. Customers who have obtained information and thereafter undertake modifications during a running production are invited to provide this information to us to assist us in maintaining our field information and obtain any updated information we may have. **However, any technical information we provide is provided for informational and assistance purposes only, and should not be relied upon or used to replace field testing by the user of the adhesive in the actual application for which the adhesive is to be used.** Our laboratory testing and field information obtained cannot simulate all eventualities that may occur in each specific application, and for that reason **we cannot and do not insure performance or results in specific applications.**

Any user of adhesives manufactured by JOWAT must test the adhesive(s) for suitability in each individual application, performing such tests in connection with the first use of a sample as well as all subsequent modifications during any ongoing production.

In addition to such other tests the users of our adhesives deem appropriate to insure suitable bonding, all users of adhesives manufactured by JOWAT should test the adhesives for suitability on original parts equal to normal processing conditions. The adhesive bond should then also be tested and assessed by subjecting it to the actual stress and conditions it will undergo in its intended use. **ALL OF THESE TESTS ARE ABSOLUTELY NECESSARY AND MUST BE PERFORMED.**

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