



# Adhesives for woodworking, furniture and upholstery



Jowat product portfolio with adhesives for all common applications in the woodworking craft and trade:

- solid wood bonding
- flat bonding
- foam upholstery bonding
- edgebanding

# PVAc glues - Dispersion adhesives

for solid wood and flat bonding

■ Jowacoll® 103.30  
103.36

■ Jowacoll®  
Multi-D3<sup>Plus</sup> 103.70

■ Jowacoll® 107.20

■ Jowacoll® Five Star  
102.49



## Application:

**General-purpose D3/D4 glue** for all bonding purposes requiring increased resistance to wet environments, e.g. for doors, windows and furniture in high-humidity areas. General-purpose glue for soft and hardwood bonding, as well as for particleboard and other wood-based substrates, for high frequency bonding, etc.

**General-purpose D3 glue** for moisture-resistant bonds with highest stress resistance requirements. Used for the assembly of doors, staircases and for tongue-and-groove bonds (parquet and laminate flooring), for hard and soft wood species and for flat surface veneering.

**One-component D4 glue** for all bonds requiring increased resistance to wet environments, e.g. for doors, windows and furniture in high-humidity areas. General-purpose glue for soft and hardwood bonding, as well as for particleboard and other wood-based substrates.

**Five Star glue.** For bonding hardwood species (oak, beech), species with high resin content (pine), tropical wood species (e.g. Teak, Meranti) and wood with moisture content up to 15 %. For assemblies exposed to direct weathering, with adequate surface protection, e.g. window frames or formwork panels.

## Basis / Characteristics / Standards:

PVAc dispersion. If used correctly, the glue will meet the durability class D3, with an addition of 5 % of Jowat® crosslinking agent 195.40 durability class D4 under EN 204/205. **Meets heat resistance according to WATT 91 > 7.0 N/mm<sup>2</sup> at 80 °C.** 103.36: IMO certified ("low flame-spread characteristics"). Minimum pressing times: at RT approx. 30 min. at 40 °C approx. 8 min. bei 60 °C approx. 3 min.

PVAc dispersion. Free of formaldehyde and components releasing formaldehyde; discolourations of the wood components related to the pH are suppressed. **Will meet the requirements of durability class D3 according to EN 204/205.**

Minimum pressing times: at RT approx. 30 min. at 40 °C approx. 8 min. at 60 °C approx. 3 min.

PVAc dispersion. If used correctly, the glue will meet the requirements of durability class D4 according to EN 204/205. **Meets heat resistance according to WATT 91 > 7.0 N/mm<sup>2</sup> at 80 °C.**

Minimum pressing times: at RT approx. 20 min. at 40 °C approx. 6 min. at 60 °C approx. 2.5 min.

Copolymer dispersion. Very high water resistance, temperature resistance, mechanical strength, very good joint filling, relatively resistant to solvents, excellent long-term resistance. If used correctly, the glue will meet the requirements of durability class D4 according to EN 204/205 and heat resistance according to WATT 91 > 10.0 N/mm<sup>2</sup> at 80 °C.

## Directions for use:

Processing with brush, trowel, nozzle and roller. Avoid contact with iron. Tanniferous wood may discolour. Avoid contact with alkaline substrates. The materials to be bonded must be free of grease and dust, and they also need to be dry and match perfectly. Wood moisture should be at 6 - 10 %. In general, application to one surface will be sufficient. For hardwood, two-sided application is recommended to increase strength. This will lead in consequence to extension of the open time. Minimum temperature for substrates, glue and ambient air: 15 °C.

Processing with brush, trowel, nozzle and roller. Avoid contact with iron. Tanniferous wood may discolour. The materials to be bonded must be free of grease and dust, and they also need to be dry and match perfectly. Wood moisture should be at 6 - 10 %. In general, application to one surface will be sufficient. For hardwood, two-sided application is recommended to increase strength. This will lead in consequence to extension of the open time. Minimum temperature for substrates, glue and ambient air: 15 °C.

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Processing with brush, trowel, nozzle and roller. Avoid contact with iron. Tanniferous wood may discolour. The materials to be bonded must be free of grease and dust, and they also need to be dry and match perfectly. Wood moisture should be at 6 - 10 %. In general, application to one surface will be sufficient. For hardwood, two-sided application is recommended to increase strength. This will lead in consequence to extension of the open time. Minimum temperature for materials, glue and ambient air: 15 °C. Jowacoll® FiveStar 102.49 has to be processed with Jowat® Crosslinking Agent 195.60. Mixing ratio: 100 : 15 ppw

## Open time at 20 °C:

up to 12 minutes

up to 7 minutes

approx. 10 minutes

up to 12 minutes

## Minimum pressing time at 20 °C (>0.2 N/mm<sup>2</sup>):

approx. 30 minutes

approx. 30 min. (>0,5 N/mm<sup>2</sup>)

approx. 20 min. (>0,5 Nm<sup>2</sup>)

approx. 25 minutes

## Application amount:

150 - 200 g/m<sup>2</sup>

150 - 200 g/m<sup>2</sup>

100 - 200 g/m<sup>2</sup>

150 - 200 g/m<sup>2</sup>

## Viscosity at 20 °C (Brookfield):

approx. 12,000 mPas

approx. 10,000 mPas

approx. 6,000 mPas

approx. 11,000 mPas (no crossl.)

## Storage:

May be stored for 9 months after date of production in properly closed original containers, cool and dry (15 - 25 °C). Best-before date, please refer to label on the packaging unit. Protect against frost!

May be stored for 9 months after date of production in properly closed original containers, cool and dry (15 - 25 °C). Best-before date, please refer to label on the packaging unit. Protect against frost.

May be stored for 4 months after date of production in properly closed original containers, cool and dry (15 - 25 °C). Best-before date, please refer to label on the packaging unit. Protect against frost!

May be stored for 12 months after date of production in properly closed original containers, cool and dry (15 - 25 °C). Best-before date, please refer to label on the packaging unit. Protect against frost!

## Packaging:

1 kg bottles, 10 and 25 kg non returnable containers

10 and 25 kg non-returnable containers

10 and 25 kg non-returnable containers

10 and 25 kg non-returnable containers, measuring cup / 195.60: 150 g bottles (10 per carton)

# PUR adhesives

for solid wood and flat bonding

## Jowacoll® 113.10

## Jowacoll® 119.60

## Jowacoll® 124.79

## Jowat-PowerPUR® 687.40

## Jowat®-MultiPUR Express® 685.06<sup>1)</sup> Jowat®-MultiPUR 685.17<sup>2)</sup>



**Super fast Binder D2 glue.**  
General-purpose assembly glue for hard and soft wood species and other wood-based substrates. For fast pressing applications with shortest possible setting times, also for flat bonding of laminate panels.

**Super lacquer**  
glue with excellent adhesion on difficult surfaces. For DD, NC and UV lacquers, also for plastic surfaces. In many cases, bonding can be carried out without preliminary sanding.

**General-purpose for flat bonding** for doubling of particleboard, for flat lamination using veneer, HPL/CPL and similar substrates. For bonding plasterboard and plaster carton to/among each other.

**One-component PUR adhesive** for high strength bonds of windows, doors, staircases and outdoors furniture, for hard and exotic wood species, wood-based substrates, laminates, mineral and ceramic building materials, metals and compound elements as well as for many other materials.

**One-component PUR adhesive** for high strength bonds of windows, doors, staircases and outdoors furniture, for hard and exotic wood species, wood-based substrates, laminates, foam and insulating materials, mineral and ceramic building materials, metals and compound elements as well as for many other materials.

PVAc dispersion. Short open time, very fast setting, high final strength, tough-elastic glue film.  
**Meets the requirements of durability class D2 according to EN 204/205.**

Synthetic resin dispersion. Easy processing, fast setting, high final strength, good moisture resistance.

PVAc dispersion. Long open time, medium setting time, high initial and final strength, tough-elastic glue film.

1-component, liquid poly-urethane prepolymer, free of solvents and formaldehyde. Moisture-curing, high strength data, almost invisible glue lines after bonding, high heat and moisture resistance. **Meets the requirements of D4 according to EN 204/205, heat resistance according to Watt '91 > 7.0 N/mm<sup>2</sup> at 80 °C and HRT 92 approx. +120 °C. IMO-certified ("low flame spread characteristics").** Bonded larch is to be protected against direct contact with water.

1-component, pasty poly-urethane prepolymer. Free from formaldehyde. Moisture-curing, high strength data, fast lapping strength, very good gap-filling properties, high heat and moisture resistance. **Meets the requirements of durability class D4 according to EN 204/205, and heat resistance according to Watt 91 > 7.0 N/mm<sup>2</sup> at 80 °C.** Bonded larch is to be protected against direct contact with water.

Minimum pressing times:  
at RT approx. 3 min.  
at 40 °C approx. 2.5 min.  
at 60 °C approx. 1.5 min.

Minimum pressing times:  
at RT approx. 15 min.  
at 40 °C approx. 10 min.  
at 60 °C approx. 5 min.  
Flat lamination:  
3 - 4 min.

Processing with brush, trowel, nozzle and roller. Avoid contact with iron. Tanniferous wood may discolour. The materials to be bonded must be free of grease and dust, and also need to match perfectly. Wood moisture should be at 6 - 10 %. In general, application to one surface will be sufficient. For hardwood, two-sided application is recommended to increase strength. This will lead in consequence to extension of the open time. Minimum temperature for substrates, glue and ambient air: 15 °C.

Processing with brush, trowel, squeezable bottle or pressurised container. Avoid contact with iron. Tanniferous woods may discolour. One of the substrates must be absorbent (uncoated/unlacquered). The materials to be bonded must be free of grease and dust, and also need to match perfectly. Bond as wet as possible for optimum wetting. In general, application to one surface will be sufficient. Minimum temperature for substrates, adhesive and ambient air: 18 °C.

Processing with brush, trowel, nozzle and roller. Avoid contact with iron. Tanniferous wood may discolour. The materials to be bonded must be free of grease and dust, and also need to match perfectly. Wood moisture should be at 6 - 10 %. In general, application to one surface will be sufficient. Two-sided application may lead to a significantly extended open time. Minimum temperature for substrates, adhesive and ambient air: 15 °C.

Standard application of the adhesive by spatula or roller. The materials to be bonded must be free of grease and dust, and also need to match perfectly. In case of non-absorbent substrates and wood with moisture content below 8 %, the adhesive film or the materials to be bonded are to be fogged. Pressure for laminates and joint bonding at least 0.6 N/mm<sup>2</sup>. Please take care during pressing to prevent the press from gluing shut. Coat the press with a suitable Jowat® separating agent for PUR adhesives. We recommend using release paper. Minimum temperature for substrates, adhesive and ambient air: 10 °C.

Standard application of the adhesive is by one-sided bead application, spread with spatula as required. The materials to be bonded must be free of grease and dust, and also need to match perfectly. In case of non-absorbent substrates and wood with moisture content below 8 %, the adhesive film or the materials to be bonded are to be fogged. Pressure for laminates and joint bonding at least 0.6 N/mm<sup>2</sup>. Please take care during pressing to prevent the press from gluing shut. Coat the press with a suitable Jowat® separating agent for PUR adhesives. We recommend using release paper. Minimum temperature for substrates, adhesive and ambient air: 10 °C.

up to 5 minutes

up to 8 minutes

up to 10 minutes

up to 40 minutes

up to 5 min.<sup>1)</sup>/ 15 min.<sup>2)</sup>

approx. 3 minutes

approx. 15 minutes

approx. 15 minutes

approx. 115 minutes

approx. 18 min.<sup>1)</sup>/ 50 min.<sup>2)</sup>

100 - 160 g/m<sup>2</sup>

100 - 160 g/m<sup>2</sup>

100 - 150 g/m<sup>2</sup>

approx. 16,500 mPas

approx. 7.000 mPas

approx 19.500 mPas

approx. 6.000 mPas

pasty

May be stored for 12 months after date of production in properly closed original containers, cool and dry (15 - 25 °C). Best-before date, please refer to label on the packaging unit. Protect against frost!

May be stored for 8 months after date of production in properly closed original containers, cool and dry (15 - 25 °C). Best-before date, please refer to label on the packaging unit. Protect against frost!

May be stored for 12 months after date of production in properly closed original containers, cool and dry (15 - 25 °C). Best-before date, please refer to label on the packaging unit. Protect against frost!

May be stored for 12 months after date of production in properly closed original containers, cool and dry (15 - 25 °C). Best-before date, please refer to label on the packaging unit. Protect against temp. below +5 °C!

May be stored for 6/12 months after date of production in properly closed original containers, cool and dry (15 - 25 °C). Best-before date, please refer to label on the packaging unit. Protect against temp. below +5 °C!

10 and 25 kg non-returnable containers

500 g squeezable bottles (12 per carton), 9 kg non-returnable containers

10 and 25 kg non-returnable containers

0.5 kg bottles (12 per carton), 12 kg non-returnable containers, 25 kg canisters

310 ml cartridges (12 per carton)

# Foam bonding adhesives

for the upholstery trade

■ Jowat® 445.00

■ Jowat® 401.10

■ Jowatac® 471.54

■ Jowatac® 456.20  
456.24

■ Jowat® 403.40



**Application:**

**Multi-purpose contact adhesive for general applications.**  
For bonding laminates, particleboard and hardboard panels, as well as for rubber, felt and many plastics, among each other and to metals.

**Special thinner for Jowat® contact adhesive 445.00.**  
Also to be used as cleaner for the processing unit.

**General-purpose solvent-based adhesive for one-sided application.**  
For bonding foam, formed foam and upholstery wadding to each other and to wood, hardboard, particleboard, cardboard, rubber hair and other upholstery materials, also for expanded polystyrene.

**General-purpose solvent-based adhesive for two-sided application.**  
For bonding foam, formed foam and upholstery wadding to each other and to wood, hardboard, particleboard, cardboard, rubber hair and other upholstery materials, also for expanded polystyrene.

**Special thinner**  
for Jowatac® solvent-based adhesives 471.54, 456.20 and 456.24.  
Also as cleaner for applicators.

**Basis / Characteristics / Standards:**

Polychloroprene (CR). Low in aromatics, high solid content, excellent spreading and spraying properties, high yield, superior initial adhesion, good resistance to high and low temperatures.

Mixture of easily flammable organic solvents.

Styrene-butadiene-styrene rubber (SBS). Typical adhesive for one-sided application, minimal odour, easy to spray, good initial strength, practically no post-tack, good heat resistance, high solid content and good yield.

Styrene-butadiene-styrene rubber (SBS). Typical adhesive for two-sided application, easy to spray, good initial strength, practically no post-tack, very good heat resistance, high solid content and good yield.

Mixture of easily flammable organic solvents.

**Directions for use:**

Stir well before application. Processing with brush, toothed trowel, doctor's knife or by spray methods. The materials to be bonded must be free of grease and dust, and they also need to be dry and match perfectly. Wood moisture may not exceed 12 %. The adhesive may only be thinned with Jowat® thinner 401.10. Application is always to both surfaces. After an evaporation time (3 - 10 min.) the parts are bonded under highest possible pressure (for flexible materials at least 0.3 N/mm<sup>2</sup>, for rigid materials at least 0.5 N/mm<sup>2</sup>). This depends on the application amount, the temperature and the circulation of the ambient air. Minimum temperature for substrates, adhesive and ambient air: 15 °C.

Avoid all contact of the thinner/cleaner with hot items or electrical connections. Adequate extraction or ventilation systems must be in place. Caution, flammable product!

Processing with cup spray gun and from pressurised container or barrel pump, either directly or via circulation system. Pressurised container, pump, ductwork and other parts coming into contact with the adhesive may not be of galvanised metals or zinc alloys. This may act aggressively with the adhesive, which can then no longer be used. In general, one-sided application is sufficient. Two-sided application is possible. The parts can be joined and bonded after an evaporation time of 1 - 7 minutes under sufficient pressure, for two-sided application after 1 - 25 minutes.

Processing with cup spray gun and from pressurised container or barrel pump, either directly or via circulation system. Pressurised container, pump, ductwork and other parts coming into contact with the adhesive may not be of galvanised metals or zinc alloys. This may act aggressively with the adhesive, which can then no longer be used. Two-sided application is necessary. The parts can be are joined and bonded after an evaporation time of 30 seconds to 15 minutes under sufficient pressure.

Avoid all contact of the thinner/cleaner with hot items or electrical connections. Adequate extraction or ventilation systems must be in place. Caution, flammable product!

**Viscosity at 20 °C:**

ca. 1.300 mPas (Höppler)

dünnflüssig

ca. 300 mPas (Höppler)

ca. 220 mPas (Höppler)

fluid

**Storage:**

In properly closed original containers, cool and dry (15 - 25 °C), for 15 months after date of production. Best-before date, please refer to label on the packaging unit.

In properly closed original containers, cool and dry (15 - 25 °C), for 18 months after date of production. Best-before date, please refer to label on the packaging unit.

In properly closed original containers, cool and dry (15 - 25 °C), for 15 months after date of production. Best-before date, please refer to label on the packaging unit.

In properly closed original containers, cool and dry (15 - 25 °C), for 15 months after date of production. Best-before date, please refer to label on the packaging unit.

In tightly closed original containers, cool and dry (15 - 25 °C), for 18 months after date of production. Best-before date, please refer to label on the packaging unit.

**Packaging:**

0.6 kg cans (12 per carton), 10 and 23 kg non-returnable containers

1 litre bottles with funnel spout (12 per carton), 9 kg non-returnable containers

9 and 22 kg non-returnable containers

0.6, 9 and 22 kg non-returnable containers

1 litre bottles with funnel spout (12 per carton), 8 kg non-returnable containers

# Special adhesives • Auxiliary

2K SE polymer

Instant glue

Urea resin glue

Separating agent

Hand cleaner

■ Jowat® 690.00

■ Jowat® 405.69

■ Jowat® 950.20

■ Jowat® 900.00

■ Jowat® 407.50



## Two-component SE polymer adhesive

for flexible bonding of plastics, metal and rubber materials, wood, glass, concrete, and mineral substrates, also for sealing of seams and casting compound.



## Instant adhesive

for bonding numerous substrates in the wood-working industry, the electrical and electronics industry, the toy and rubber industry as well as for precision mechanics and the optical industry. Not suitable for bonding glass.



## Urea resin glue in powder form

with integrated hardener. For bonding veneers, decor paper, HPL, CPL to wood and wood-based substrates, in warm and cold presses, and for solid wood bonding. Frequently used in HF presses for the production of formed multilayer parts.



## General-purpose separating and release agent

For short-cycle, daylight presses and caul sheets, also for other parts coming into contact with adhesive. Allows easy and complete removal of adhesive residues from parts treated with the release agent.



## Hand Cleaner

Super fast, mild and non-aggressive hand and skin cleaner. Pleasant smell, clinically tested.

2-component, hybrid system from epoxy and silane resins. Pasty mass with good flowing properties and good spreading. Free of isocyanates and solvents. Resistant to ageing and heat up to 120 °C as permanent processing temperature. Short-term exposure to higher temp. possible. Flexible bond line that can absorb tensile and vibration stress.

Cyanoacrylate. Very fast setting, excellent strength results, allows non-stress and vibration-free bonds. Superior resistance to high and low temperatures (from -50 °C to +80 °C).

Urea Formaldehyde resin (UF resin) with integrated hardener. The glue penetration is minimised due to thickening agents that are selected for optimum performance and dosage.

**For manufacturing procedures to achieve the classification class 1 acc. to EN 314, section 2 and E1 and EN 717, section 2.**

Oil-wax dispersion. Excellent anti-adhesive and sliding effect. High yield.

Wash-active substances. Excellent cleaning effect, economical, mild and non-aggressive, renews protective fat content of the skin, free of silicones and terpene hydrocarbons, does not contain abrasive additives that could clog drains

The surfaces to be bonded have to be clean, dry and grease-free. Application is done using a 2-component cartridge with a static mixer (at least 18 - 24 elements). Larger quantities can also be mixed homogeneously in a clean container and then applied with a toothed spatula within the pot life (approx. 25 - 30 min.). Application to one of the substrates, then fix both substrates for approx. 2 hours at RT. Increasing the temperature will reduce the curing time. Curing is bubble-free, no reaction shrinkage.

The materials to be bonded must be free of grease and dust, and also need to match perfectly. Gaps are limited to 0.5 mm, but this is a limit value depending on the substrate and needs to be determined for each individual case. One-sided application of the adhesive is sufficient; join the parts to be bonded immediately, slight pressure will allow a cure within a few seconds. The cure depends on the relative ambient humidity. At an ambient humidity < 40 %, curing may become difficult.

The glue has to be diluted in lukewarm water (18 - 22 °C) with a weight ratio of approx. 2 : 1 (UF resin : water) (e.g. 10 kg UF resin + 5 kg water or 10 l UF resin + 3 l water). To the urea resin in the mixing container, add about 3/4 of water, then stir until lump-free (spiral drill attachment or similar device), then add the remaining amount of water and stir until smooth. The glue is immediately ready to use. The pot life at 20 °C is about 7 hours. Glue application with spatula, hand roller or applicator roller.

Application amount:  
80 - 150 g/m<sup>2</sup>

Open time: approx. 13 min.  
Pressing times:  
at 70 °C approx. 5 min.  
at 80 °C approx. 3 min.  
at 90 °C approx. 2 min.

Distribute the separating agent with a dry rag or fine-pored sponge in small amounts and evenly onto the surfaces, (platens, caul sheets etc.) in order to achieve an uninterrupted and durable protective coating. It is recommended to treat the platens of the press while still warm. After wet cleaning, applicator units should be treated with the agent in the respective surface areas.

Distribute a small amount of hand cleaner without water evenly on the soiled parts of the skin using your fingertips, and rub until dirt comes off; then wipe off with cloth, and wash hands thoroughly using liquid soap and water. Rinse hands off under running water. In case of heavy soiling, repeat the process. Protect the cleaned skin with a handcare cream to prevent excessive skin drying. After use, close containers well to avoid drying.

approx. 50,000 mPas (mixture)

approx. 2.050 mPas (cone/plate)

powder

pasty

In properly closed original containers, cool and dry (15 - 25 °C), for 15 months after date of production. Best-before date, please refer to label on the packaging unit.

In properly closed original containers, as cool as possible, but not below 0 °C, for 12 months after date of production. Best-before date, please refer to label on the packaging unit.

In properly closed original containers, cool and dry (15 - 25 °C), for 6 months after date of production. Best-before date, please refer to label on the packaging unit.

In properly closed original containers, cool and dry (15 - 25 °C), for 9 months after date of production. Best-before date, please refer to label on the packaging unit. Protect against frost!

In properly closed original containers, cool and dry (15 - 25 °C), for 15 months after date of production. Best-before date, please refer to label on the packaging unit.

205 g/180 ml double chamber cartridges (12 per carton)

50 g bottles (20 per carton)

Kraft paper bags with PE liner, 25 kg net

1 kg containers (24 per carton), 9 kg containers, 25 kg hobbicks

0.5 kg plastic cans (12 per carton)

# Hot melt adhesives

for edgebanding

■ Jowatherm® 280.50  
280.51

■ Jowatherm® 282. 20

■ Jowatherm® 288.60

■ Jowatherm® 286.30\*  
286.60  
286.61  
286.62



## Application:

**Unfilled general-purpose edgebanding hot melt adhesive** on EVA basis. Excellent adhesion to edgebands made of HPL, PVC, ABS, PP, paper and veneer. For straight edgebanding, softforming, applications and also for BAZs.

**Edgebanding hot melt adhesive** on EVA basis. Excellent adhesion to resinated paper edges. For straight edgebanding with low application temperatures like e.g. manual edgebanders.

**Filled general-purpose edgebanding hot melt adhesive** on EVA basis. Good adhesion to edgebands made of HPL, PVC, ABS, PP, paper and veneer. For straight edgebanding and softforming.

**Edgebanding hot melt adhesive** on EVA basis in cartridges form. Especially developed for Holzher machines. Wide area of application, for edgebands made of HPL, PVC, ABS, PP, paper and veneer. \*unfilled

## Basis / Characteristics / Standards:

Ethylene Vinyl Acetate (EVA). Good wetting, high hot tack, elastic adhesive film, excellent adhesion and high heat resistance. Good resistance to oxidation and colour stability in the melt. Very good mechanical processing characteristics for clean, string-free application, no surface soiling.

Ethylene Vinyl Acetate (EVA). Long open time, high hot tack, good adhesion and good heat resistance. Good resistance to oxidation and colour stability in the melt. Excellent mechanical processing characteristics for clean, string-free application.

Ethylene Vinyl Acetate (EVA). Excellent initial and subsequent melting properties, good wetting, elastic adhesive film, good adhesion, and resistance to high and low temperatures. Good resistance to oxidation and colour stability in the melt. Very good mechanical processing characteristics for clean, string-free application.

Ethylene Vinyl Acetate (EVA). Low melt viscosity, good wetting, elastic adhesive film and good adhesion. Good resistance to oxidation and colour stability in the melt. The form stability and processing requirements were confirmed by Holzher. Very good mechanical processing characteristics, accurate, string-free application. Diameter: 63 mm, Length: 80 mm.

## Directions for use:

For slow to medium-speed automatic edgebanders with roller or nozzle applicators. The materials to be bonded must be free of grease and dust, and they also need to be dry and match perfectly. Wood moisture should be at 8 - 10 %. Minimum temperature for substrates, adhesive and ambient air should not be below 18 °C. Avoid draught. Processing temperature of the adhesive: 180 - 200 °C.

For slow to medium-speed automatic edgebanders with roller applicators. The materials to be bonded must be free of grease and dust, and they also need to be dry and match perfectly. Wood moisture content should be at 8 - 10 %. Minimum temperature for substrates and ambient air should not be below 18 °C. Avoid draught. Processing temperature of the adhesive: 130 - 150 °C.

For slow to medium-speed automatic edgebanders with roller or nozzle applicators. The materials to be bonded must be free of grease and dust, and they also need to be dry and match perfectly. Wood moisture content should be at 8 - 10 %. Minimum temperature for substrates and ambient air should not be below 18 °C. Avoid draught. Processing temperature of the adhesive: 180 - 200 °C.

For slow to medium-speed automatic edgebanders (Holzher cartridge melter). The materials to be bonded must be free of grease and dust, and they also need to be dry and match perfectly. Wood moisture content should be at 8 - 10 %. Minimum temperature for substrates and ambient air should not be below 18 °C. Avoid draught. Processing temperature of the adhesive: 190 - 210 °C

## Viscosity at processing temperature:

approx. 110.000 mPas

approx. 40.000 mPas

approx. 110.000 mPas

286.30: ap. 50.000 mPas  
286.60/61/62: ap. 60.000 mPas

## Density:

approx. 1,1 g/cm<sup>3</sup>

approx. 1,3 g/cm<sup>3</sup>

approx. 1,3 g/cm<sup>3</sup>

286.30: ap. 1,0 g/cm<sup>3</sup>  
286.60/61/62: ap. 1,3 g/cm<sup>3</sup>

## Application amount:

approx. 150 - 180 g/m<sup>2</sup>

approx. 230 - 280 g/m<sup>2</sup>

approx. 230 - 280 g/m<sup>2</sup>

approx. 230 - 280 g/m<sup>2</sup>

## Storage:

Cool and dry, for 24 months after date of production. Best-before date, please refer to label on the packaging unit.

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Cool and dry, for 24 months after date of production. Best-before date, please refer to label on the packaging unit.

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## Packaging:

Granulate in paper bags, 25 kg net

Granulate in paper bags, 25 kg net

Granulate in paper bags, 25 kg net

48 cartridges per carton, 15.4 kg net  
12.2 kg net (286.30)

# PUR hot melt adhesives

for edgebanding

## ■ Jowatherm-Reaktant® 607.50 607.51



**PUR edgebanding hot melt** for automatic edgebanders and high-speed profile wrapping machines. Wide area of application, e.g. for edges made of HPL/CPL, polyester, PVC, ABS, PP, resinated paper, solid wood or veneer.

Polyurethane (PUR). Fast setting, high initial strength, crosslinking within a few days, depending on humidity and moisture of the materials. Good elasticity at low temperatures as well as good resistance to solvents.

Currently highest quality standard in edgebanding for water-resistant "zero-bond-lines."

Processing with special equipment from moisture-proof sealed melting units. Also in cartridge form for Holzher machines and as granulate. Processing temperature of the hot melt adhesive: approx. 140 °C (depending on application method). Reaction time: approx. 5 days (depending on ambient conditions)

approx. 70.000 mPas

approx. 1,3 g/cm<sup>3</sup>

approx. 150 g/m<sup>2</sup>

In properly closed original containers, cool and dry (15 - 25 °C), for 12 months after date of production. Best-before date, please refer to label on the packaging unit.

600 g cans with granulate  
310 ml cartridges, 320 g cartridges, 2,5 kg pull ring cans

## ■ Jowatherm-Reaktant® 607.30 607.31



**PUR edgebanding hot melt** for automatic edgebanders and high-speed profile wrapping machines. Wide area of application, e.g. for edges made of HPL/CPL, polyester, PVC, ABS, PP, resinated paper, solid wood or veneer. Ideal also without a heated roller applicator.

Polyurethane (PUR). Fast setting, high initial strength, crosslinking within a few days, depending on humidity and moisture of the materials. Good elasticity at low temperatures as well as good resistance to solvents.

Currently highest quality standard in edgebanding for water-resistant "zero-bond-lines."

Processing with special equipment from moisture-proof sealed melting units. Also in cartridge form for Holzher machines. Processing temperature of the hot melt adhesive: approx. 110 °C (depending on application method). Reaction time: approx. 5 days (depending on ambient conditions).

approx. 70.000 mPas

approx. 1,1 g/cm<sup>3</sup>

approx. 150 g/m<sup>2</sup>

In properly closed original containers, cool and dry (15 - 25 °C), for 12 months after date of production. Best-before date, please refer to label on the packaging unit.

310 ml cartridges,  
260 g cartridges,  
2,0 kg pull ring cans

## ■ Jowat® 930.74 930.94



**Flushing agent** for flushing out applicator units for PUR hot melts.

930.74: medium viscosity (for e.g. 607.30)  
930.94: high viscosity (for e.g. 607.50)

Due to a special additive, the chemical reaction of the PUR hot melt adhesive is prevented during the flushing procedure.

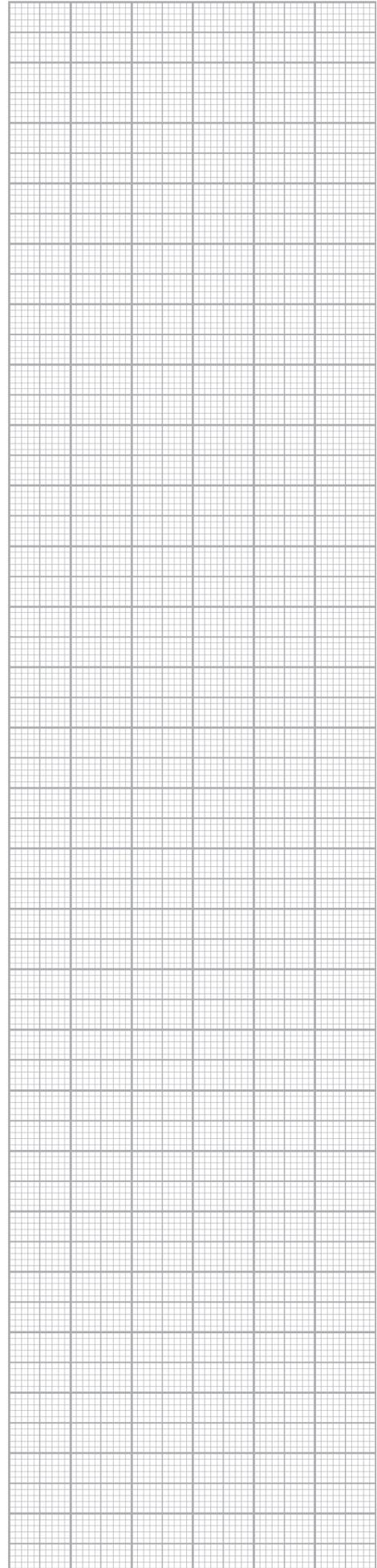
Allow all adhesive to be extruded completely. Then fill the unit with the Jowat® flushing agent and melt. The entire amount of flushing agent has to run through the hose and nozzle; then repeat the procedure to ensure that all hot melt residues have been removed. Before taking up work again, the flushing agent has to be completely removed from the equipment. If this is not done, it may be possible that the desired crosslinking reaction will not take place when reactive PUR hot melt adhesives are processed.

930.74: appr. 25.000 mPas  
930.94: appr. 50.000 mPas

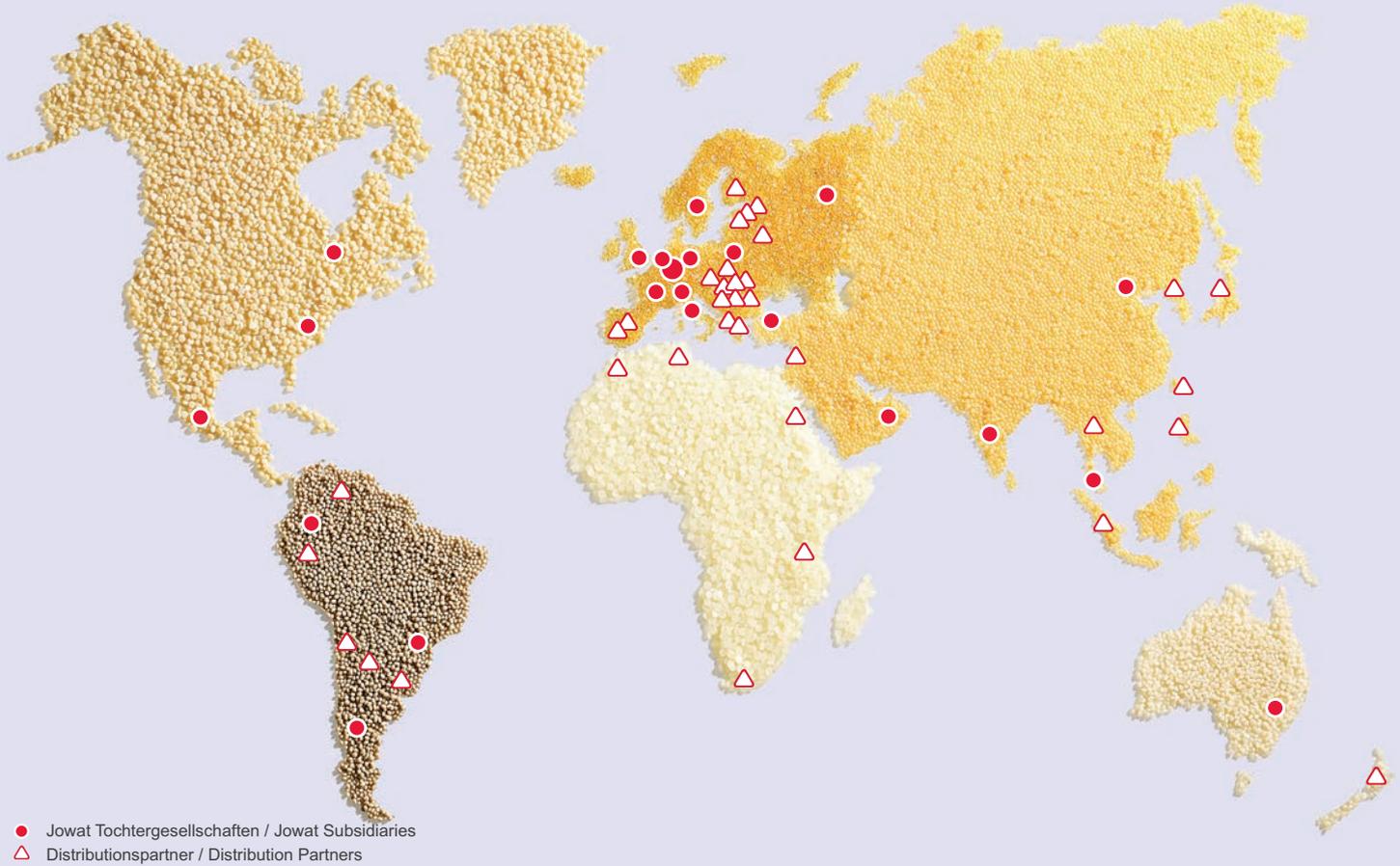
approx. 0,95 g/cm<sup>3</sup>

5 kg buckets with granulate  
20 kg bags  
220 g cartridges

# Notes



**Jowat | Ihr Partner in Sachen Kleben**  
**Jowat | Your Partner in bonding**



**Jowat – Kleben erster Klasse**  
**Jowat – first class bonding**

Ihr Händler vor Ort:

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