

# Edgebanding

- Modern adhesive systems of the latest generation
- Furniture edges with “zero bondline“
- Hot melt adhesives for the current technologies



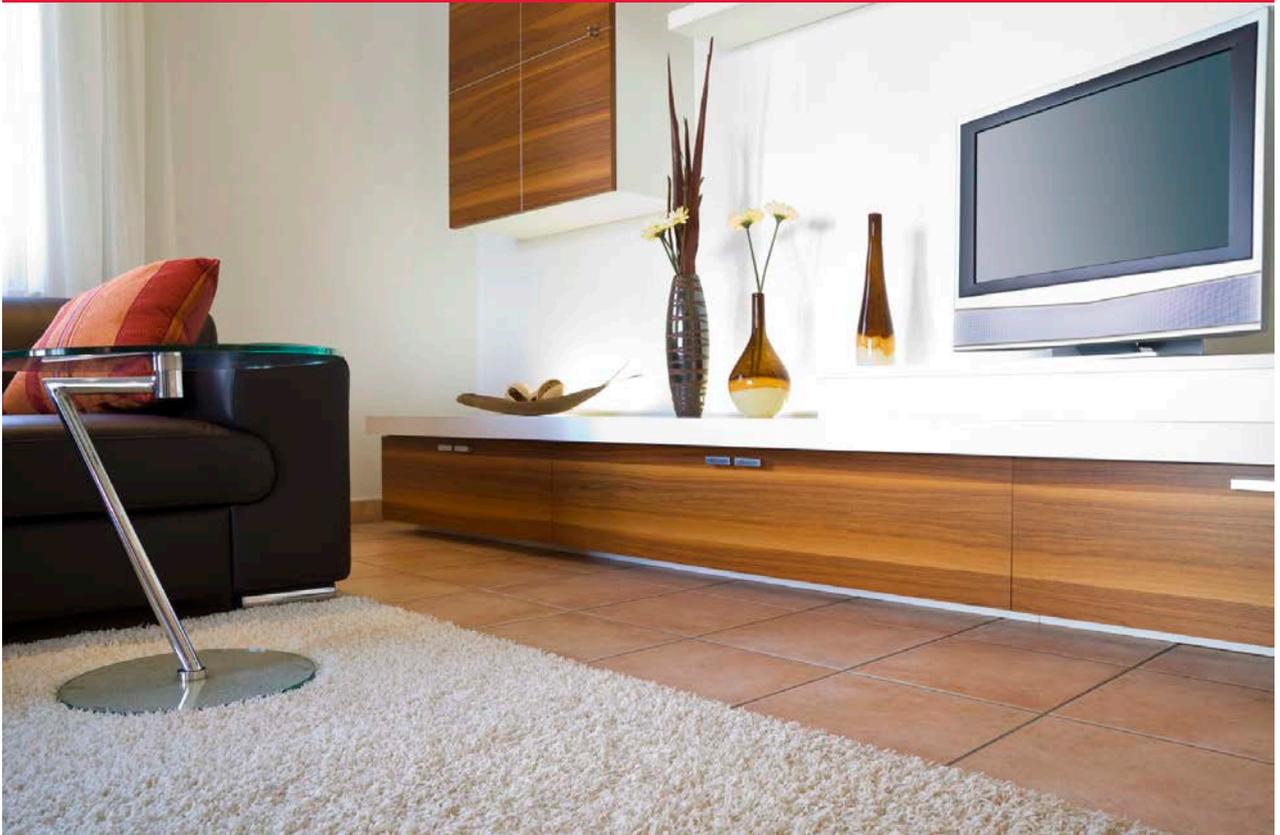
**Jowatherm® 280.50**

**Jowatherm® 284.70**

**Jowat-Toptherm® 237.10**

**Jowatherm-Reaktant® 608.00**

## Edgebanding with hot melt adhesives



For decades, edgebanding of wood-based panels with a variety of edgebands has been an established practice in the furniture industry. The quality demands concerning visual appeal, the technological progress in engineering, and also the almost unlimited diversity of materials to be processed - all of these factors represent special challenges for the adhesive technology. In modern, high-quality furniture manufacture, the quality of the edgebanding is increasingly becoming a key criterion for evaluating the quality of the entire furniture item. The end customer demands a glueline that is hardly visible and perfect.

Not least of all due to the development of ultramodern manufacturing methods, like laser or HotAir technologies, the industry has been talking about the so-called "zero bondline" for a long time.

Jowat has met these challenges and offers modern and innovative solutions and they all lead to the "zero bondline". A milestone was the development of unfilled EVA hot melt adhesives for edgebanding, and this makes **Jowatherm® 280.30** a real standard classic. A modern improvement of the recent gene-

ration is **Jowatherm® 280.50**, which has become established due to the excellent adhesion properties and the very wide processing window as very tolerant allrounder. Higher demands with regard to heat resistance can be met using hot melts based on polyolefin polymer.

**Jowat-Toptherm® 237.10** meets exactly this requirement, but can still be processed just like a conventional hot melt based on EVA. Due to the excellent adhesion characteristics, **Jowat-Toptherm®** hot melt adhesives are suitable for all standard edgeband materials, like resinated paper, veneer, and - with a respective primer precoating - also for plastic edgebands. The highest heat and moisture resistance levels can only be achieved by using hot melt adhesives based on polyurethane. **Jowatherm-Reaktant® 608.00** is a fast-setting PUR edgebanding hot melt with high initial strength, a good elasticity at low temperatures, and also a good solvent resistance. The chemical crosslinking takes place within a few days, depending on the moisture content of the materials and the humidity in the ambient air.

## Jowatherm® 280.50

Allrounder for straight edges, soft forming and BAZ. For bonding of e.g. edges of laminates, resinated decor paper, solid wood, veneer, and thermoplastics.

Polymer basis		EVA
Viscosity at 200 °C	[mPas]	approx. 80,000
Density	[g/cm³]	approx. 1.1
Processing temp.	[°C]	180 - 200
Feed speed	[m/min]	10 - 75
Softening range (Kofler bench)	[°C]	approx. 95
Supply form		granulate

Available colours: Light beige, white, colourless opaque

## Jowatherm® 284.70

Standard type for straight edges. For bonding of e.g. resinated decor paper, veneer, and thermoplastics.

Polymer basis		EVA
Viscosity at 200 °C	[mPas]	approx. 75,000
Density	[g/cm³]	approx. 1.5
Processing temp.	[°C]	180 - 200
Feed speed	[m/min]	20 - 60
Softening range (Kofler bench)	[°C]	approx. 90
Supply form		granulate

Available colours: Light beige, white, brown, black

## Jowat-Toptherm® 237.10

Allrounder for straight edges and BAZ. For bonding of e.g. edges of laminates, resinated decor paper, solid wood, veneer, and thermoplastics.

Polymer basis		PO
Viscosity at 200 °C	[mPas]	approx. 85,000
Density	[g/cm³]	approx. 1.1
Processing temp.	[°C]	180 - 200
Feed speed	[m/min]	15 - 80
Softening range (Kofler bench)	[°C]	approx. 130
Supply form		granulate

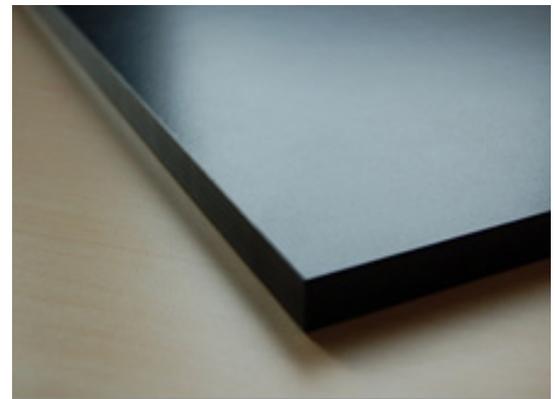
## Jowatherm-Reaktant® 608.00

For bonding of e.g. edgebands of laminates, resinated decor paper, solid wood, veneer, and thermoplastics.

Polymer basis		PUR
Viscosity at 120 °C	[mPas]	approx. 75,000
Density	[g/cm³]	approx. 1.1
Processing temp.	[°C]	110 - 130
Feed speed	[m/min]	10 - 40

Supply form: special moisture-proof packaging units

Available colours: white, colourless opaque



# Jowat | Ihr Partner in Sachen Kleben

# Jowat | Your Partner in bonding



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## Jowat – Kleben erster Klasse

## Jowat – first class bonding

[www.jowat.com](http://www.jowat.com)



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