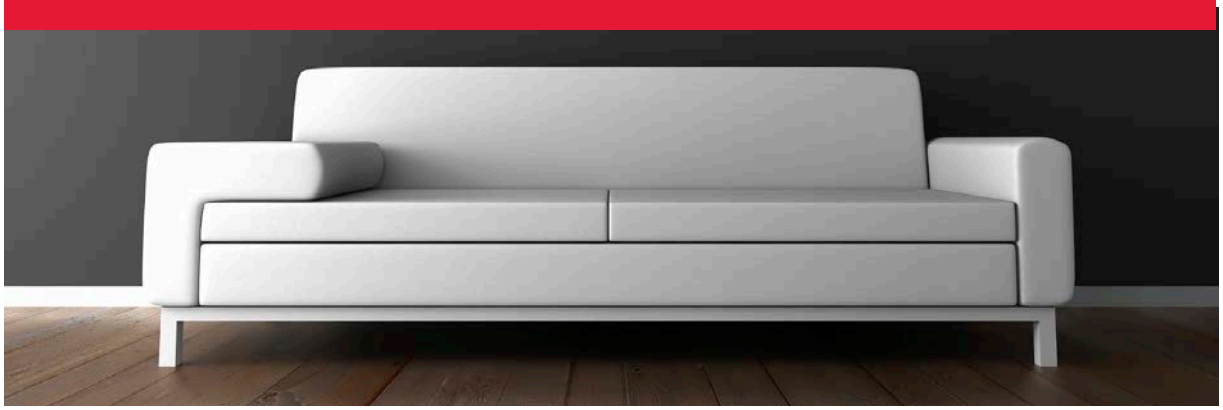
Upholstery

- Increased efficiency from single part to serial production
- Reduced solvent emissions
- Improved occupational safety and environmental compatibility

Jowatac® 471.54
Jowatac-HighSolid® 471.64
Jowatac® Super-HighSolid 476.74
Jowatac-HighSolid® 482.64

Jowat Adhesives

Upholstered furniture - Modern adhesive systems for established processes



The manufacture of upholstered furniture is characterised by a huge diversity of processed materials. Apart from cold and preformed foams, textiles, leather, wood or wood-based substrates, various plastics and many other materials are used. Frequently, the operations are manual and the process times vary widely. The combination of a long open time, good adhesion to the various substrates, and high green strength, represent a great challenge to adhesives technology.

For decades, the solvent-based **Jowatac®** adhesives have been established in the upholstery and foam cutting industry and have constantly been adapted to the respective requirements.

The adhesives are usually applied by spray gun. The solvents in these cases serve as processing aides which evaporate during spray application and afterwards. Solvent-based adhesives facilitate fast application and assembly processes due to high green strength, especially in high-tension bonding, short pressing times with little pressure and a fast build-up of cohesion, and are therefore the basis for efficient, labor intensive manufacturing.

In order to meet the increasingly more stringent environmental and safety standards, Jowat SE had already developed solvent-based adhesives over 25 years ago that offered a lower solvent percentage and a much higher solids content. Apart from lower solvent emissions, solvent-based adhesives with a higher solids content offer a cost advantage due to higher yield and therefore significantly reduced material costs per part.

Solvent-based adhesives have for decades now been providing a major input into resource conservation and environmental protection, and facilitate sustainable and environmentally compatible upholstery furniture.

Thanks to its good adhesive properties, combined with easy processing performance and a high heat resistance, **Jowatac® 471.54** has become established as a general-purpose “all-rounder” with an average solids content (approx. 50 %).

Jowatac-HighSolid® 471.64 is an adhesive creating a soft seam; it has universal adhesion characteristics, and performs excellently in spray application while the solids content is also higher.

Numerous customers use **Jowatac-HighSolid® 482.64** for superior products with high requirements regarding heat resistance, adhesion on difficult to bond substrates, and special high-tension bonds. The increased aging resistance meets high expectations.

Jowatac® Super HighSolid® 476.74 has a very acceptable processing performance in spite of the very high solids content, and according to an expertise by the RW TÜV Essen, the fire danger can be virtually eliminated when the adhesive is processed according to the instructions (expertise available upon request).

Solvent-based adhesives offer considerable advantages: in health and safety in the workplace, sustainability, processing and last but not least in efficiency compared to CR-dispersion adhesives. Additionally, Jowat also supplies special hot melt adhesives that are mainly used in mattresses manufacture. The widely varying processes in the manufacture of upholstery furniture due to different materials, constructions and the manual application and assembly process require an adapted production process with harmonized process times for the use of hot melt adhesives.

Application Information

Various adhesives are used, depending on application, purpose and application technology. Jowatac® solvent-based adhesives serve all applications in upholstered furniture manufacture worldwide.

Jowatac® 471.54

general applications, high initial strength

Solid content	[%]	approx. 51
Application		one- or two-sided
Open time	[min]	1-sided: ≤ 7, 2-sided: ≤ 25
Sprayability		very good
Heat resistance		very good

Jowatac-HighSolid® 471.64

general applications, soft seam

Solid content	[%]	approx. 63
Viscosity	[mPas]	approx. 800
Application		one- or two-sided
Open time	[min]	1-sided: ≤ 7, 2-sided: ≤ 25
Sprayability		good
Heat resistance		good

Jowatac® Super HighSolid 476.74

general applications, very high solids content, good spraying properties due to relatively low viscosity, low adhesive consumption, suitable for mattress manufacturing

Solids content	[%]	approx. 74
Viscosity	[mPas]	approx. 1,900
Application		one- or two-sided
Open time	[min]	1-sided: ≤ 7, 2-sided: ≤ 20
Sprayability		good*
Heat resistance		good

*processing with increased material pressure, e.g. 3 - 5 bar

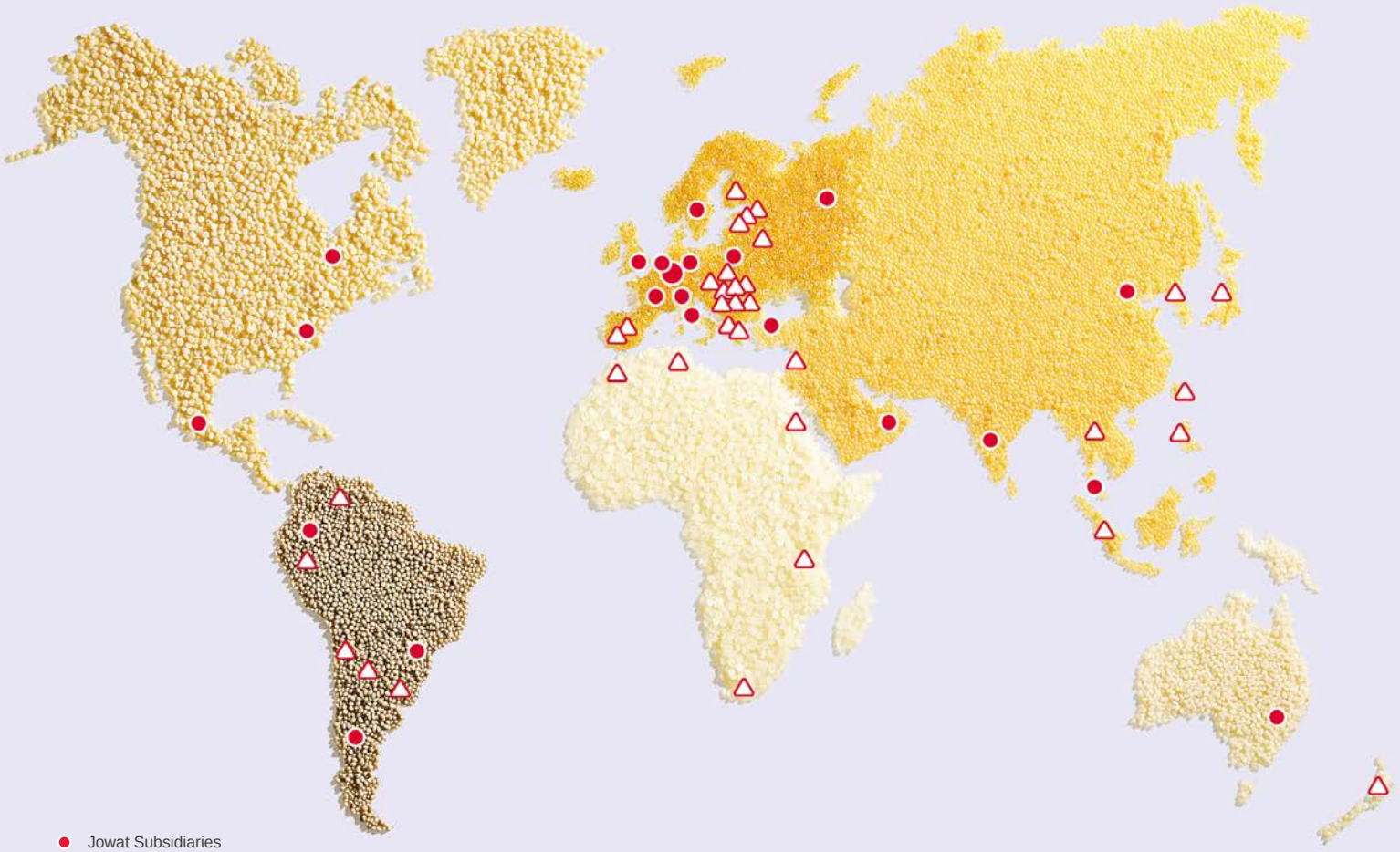
Jowatac-HighSolid® 482.64

soft seam, high green strength for high-tension bonding, wide range of adhesion, general applications

Solids content	[%]	approx. 60
Viscosity	[mPas]	approx. 500
Application		two-sided
Open time	[min]	≤ 20
Sprayability		good
Heat resistance		very good

Note: The products listed only represent a limited selection of the available product portfolio. Our service and consultation team from Sales and Product Marketing will be pleased to provide specific information, to select the product suitable for your process.

Jowat | Your Partner in bonding



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