



**Jowat**  
GREEN ADHESIVES



# Jowatherm-Reaktant® MR 604.90



**PUR hot melt adhesive with hazard-free labelling\*  
for window profile wrapping**

**Can be used in combination with the primers  
Jowat® 406.78/84/89**

**Approved according to RAL-GZ 716**

(\*according to EU regulation 1272/2008 and EU directive 2008/58/EC)





**Jowatherm-Reaktant® MR 604.90** is a PUR hot melt adhesive with hazard-free labelling for wrapping window profiles. The product is certified according to RAL-GZ 716 and impresses due to outstanding hydrolysis stability and high initial strength, especially on profiles with sharp contours. **Jowatherm-Reaktant® MR 604.90** can be used in combination with the NEP-free, VOC-reduced primer **Jowat® 406.84**, with the primer **Jowat® 406.78** (based on MEK) or with the primer **Jowat® 406.89** (based on MC). These product combinations facilitate the bonding of over 95 % of PVC- and PMMA- (with primer) based decor foils established on the market.

Within only 24 hours after laminating, the adhesive reaches high peel and foil tear resistances in roll peel

tests according to EN 1372\*.

**Jowatherm-Reaktant® MR 604.90** can be processed on all wrapping machines established on the market and with the common processing parameters.

**Jowatherm-Reaktant® MR 604.90** is also an adhesive of great versatility with regard to feed speeds. It provides maximum flexibility in fast (up to 40 m/min) as well as in slow (from 6 m/min) processes.

Contract laminators benefit from the possibility to remove all adhesive / the entire foil from unprimed profiles when the machine is set up or in case of frequent profile changes. This reduces material waste and promotes sustainability.

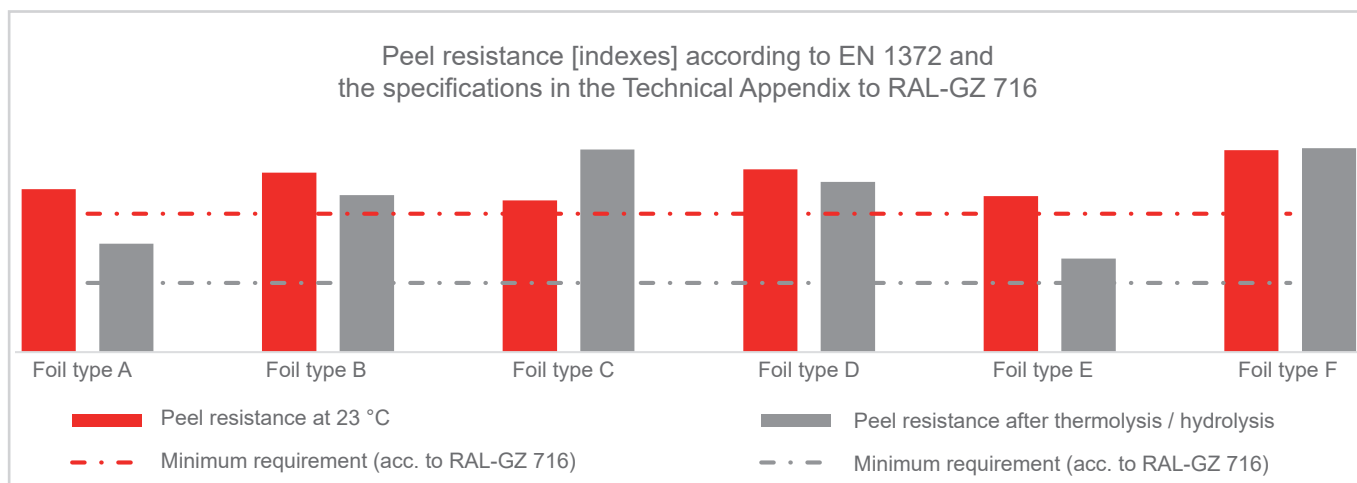
\*If the process parameters indicated in the technical guideline "Reliable lamination of window profiles" by the Gütegemeinschaft Kunststoff-Fensterprofilsysteme e.V. are met.

## Jowatherm-Reaktant® MR 604.90

Polymer basis		polyurethane
Processing temperature	[°C]	120 – 140
Viscosity at 140 °C	[mPas]	32,500 ± 7,500
Open time at 140 °C	[s]	30 ± 10

### Monomer-reduced PUR hot melt adhesives (MR)

One-component, moisture-curing PUR hot melt adhesives have been an established technology in plastic window profile wrapping applications for decades. The conventional PUR hot melt adhesives generally contain residual monomers (usually diphenylmethane-4-4'-diisocyanate, MDI) in the order of approx. 2 %. Since 2012, products with a free monomeric isocyanate content of 0.1 % and more must be labelled with the GHS pictogram No. 8 (health hazard) and with the corresponding safety information (H and P statements). Adhesives with a free monomeric isocyanate content of less than 0.1 % are not subject to hazard labelling requirements.



The information given in this leaflet is based on test results from our laboratories as well as on experience gained in the field, and does in no way constitute any guarantee of properties. Due to the wide range of different applications, substrates, and processing methods beyond our control, no liability may be derived from these indications nor from the information provided by our free technical advisory service. Before processing, please request the corresponding data sheet and observe the information in it! Customer trials under everyday conditions, testing for suitability at normal processing conditions, and appropriate fit-for-purpose testing are absolutely necessary. For the specifications as well as further information, please refer to the latest technical data sheets.