



Using PUR Hot Melt in the Holz-Her GluJet Jowatherm-Reaktant® 608.00/01

The **Holz-Her GluJet nozzle** will successfully run moisture-curing **PUR hot melt adhesives** without additional equipment. PUR hot melt has superior bond qualities over other adhesive types.

Considerations for the successful use of Jowatherm-Reaktant® 608.00/01 PUR adhesive:

PUR hot melt has a well-defined life span during which curing takes place. It is important that the 608.00/01 adhesive be completely used up within **8 hours**, once opened. To avoid glue station problems caused by premature curing of the hot melt, it is critical to keep accurate track of this time window.

! Important ! – Avoid exposing the PUR hot melt to humidity. Only open the PUR can just before use and remove the liner / foil bag. Do not open more than one can at a time or stage the open adhesive cartridges at the work place. When the adhesive is exposed to humidity for an extended period of time, premature crosslinking / pre-curing may take place in the outer layer of the adhesive. This will produce an invisible fine skin in the exposed areas which cannot be melted again. Compromised PUR hot melt adhesive will lead to clogging of the **Holz-Her GluJet** application system, to inconsistent glue lines and increased downtime. Consult technical and safety documentation for more details.

Planning of batch sizes will allow optimal yield of the hot melt cartridges and reduce waste. The daily production schedule must include the necessary purging, corresponding to the adhesive type. Production planning must also specify proper maintenance and care of the adhesive application unit.

ATTENTION

When using PUR hot melt adhesives, the application system must be fully cleaned when changing the adhesive type as well as for long periods of standstill, and the slot on the nozzle must be purged. Use the corresponding purging / flushing agent Jowat 930.94 in cartridge or pellet form and observe the processing and safety specifications.

The use of purging agents will prevent curing of the adhesive in the adhesive system and nozzle.

See back of this page for important use instructions.

INSTRUCTIONS FOR HOLZ-HER GluJet

The following is an important guide. Check machine manual for specific details.

Changing from EVA to PUR:

Start with the adhesive temperature between **180° – 210°C** and remove EVA adhesive cartridge **OR** purge until empty.

Set both temperatures to correct application setting for the cleaner/deactivator. **Insert a cleaner/deactivator cartridge** and purge the glue chamber for a few seconds until the cleaner/deactivator is hitting the waffle. Drop the temperature #1 to the recommended operating temperature as specified by the adhesive manufacturer for PUR. Change the air pressure setting between 1 bar and 3 bar. Flush first at 20 mm height until purge starts to come out about 50%. Set both temperatures to correct application setting for PUR. Set the nozzle to 40 mm and flush a bit more until purge is showing 75%, then at 60 mm until purge is showing 100%. The system is now ready for PUR.

Open a cartridge of PUR and insert into the glue chamber. **Start the timer! (8hrs)**. Set temperature #1 to the recommended PUR setting and reduce the air pressure setting to between 1 bar and 3 bar. Purge first at 20 mm height until PUR starts to come out about 50%. Now set both temperatures to correct PUR application setting. Set the nozzle to 40 mm and purge a bit more until new adhesive is showing 75%, then at 60 mm until new PUR adhesive is showing 100%. This will do a thorough change-over. Run adhesive test to confirm settings.

***NOTE:** PUR is processed at an operating temperature **~120 -140° C**, with 1-3 bars of pushing pressure (versus ~200° C and 3-5 bar for EVA).

At end of day:

Once production is finished running, use cleaner/deactivator to flush the **GluJet** of PUR. Do not try to remove the remainder of PUR, purge it out. Insert a **cleaner/deactivator cartridge**. Set both temperatures to correct application setting for the cleaner/deactivator. Flush the glue chamber for a few seconds until the purge is hitting the waffle. Flush first at 20 mm height until purge starts to come out about 50%. Set the nozzle to 40 mm and flush a bit more until purge is showing 75%, then at 60 mm until purge is showing 100% and the machine says the chamber is empty. This will do a thorough unit flush.

Brush off the nozzle face. Rub this same cleaner/deactivator on the nozzle face and slot. This will protect the outside of the adhesive nozzle.

On the next machine startup, the machine is ready to use either EVA or PUR adhesive after setting the appropriate temperature and pressure settings, flushing, and running the glue test to confirm settings.

Changing from PUR to EVA:

Purge the remainder of PUR out of the adhesive system, insert a **cleaner/deactivator cartridge** and purge the glue chamber (See end of day procedure above). Fill the glue chamber with EVA. Set temperature #1 to adhesive manufacturer's recommendation for EVA and change the air pressure setting to between 5 bar and 6 bar. Start the purge until it reaches the waffle. Purge first at 20 mm height until EVA starts to come out about 75%, then set the temperature #2 to correct EVA temperature. Set nozzle to 40 mm and purge a bit more until 85%, then at 60mm until new adhesive is showing 100%. This will do a thorough change-over. Run adhesive test to confirm settings.

*Upon setup and training of the adhesive unit, the technician will set the machine parameters to meet the specifications of the PUR adhesive.

***Machine warranty may be void if not complying with these PUR adhesive instructions, and not following the mandated cleaning procedures.**

Customer Signature / Date X _____

Technician Signature X _____
