

PUR hot melt adhesive

Low flame-spread characteristics according to IMO Resolution A.1/3.18 e

Application: For flat lamination and for the manufacture of sandwich elements, also for assembly applications in the woodworking industry.

Characteristics/ Directions for Use: Adhesive with long open time and high initial tack.
Processing with special equipment from moisture-proof sealed containers.

For the manufacture of structural parts that have to meet IMO Resolution A.1/3.18 e “low flame-spread” characteristics, the maximum adhesive application amount of 100 g/m² has to be observed (see test report TÜV Nord, No. SN08/6102.1).

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| Processing temperature [°C]: | 120 – 140 | (depending on application) |
| Appearance: | colourless, slightly turbid | |
| Density at 23 °C [g/cm ³]: | approx. 1.1 ± 0.1 | (Jowat test method) |
| Softening range [°C]: | approx. 70 ± 5 | (Kofler bench) |
| Open time at 120 °C [min]: | approx. 6 ± 1 | (Jowat test method) |
| Reaction time [d]: | approx. 2 – 5 | (dep. on ambient conditions) |

The properties of the substrates and the processing conditions will influence the processes of joining and bonding. Customer trials before use are therefore recommended.

Specification: Viscosity at 120 °C [mPas]: 33,000 ± 7,000
(Brookfield, Thermosel, spindle 28, 5 rpm)

Cleaning: Flush out PUR melt remnants from roller applicator units with Jowat® Cleaner 930.20 or 930.23 (if necessary, repeat procedure several times).
For other applicator systems and for melt units, we recommend to use the Jowat® Flushing Agent 930.34 (red). Crosslinked, solid material has to be dissolved with Jowat® Cleaner 930.60 (please test for suitability before use).
For more information, please refer to the “PUR hot melt Manual” under the heading “Maintenance and Cleaning” (available upon request).

Storage: In original sealed containers, cool and dry (15 – 25 °C).
Best-before date, please refer to label on the packaging unit.

Packaging: Moisture-proof sealed containers. Types of packaging and units upon request.

Remarks: **For further information concerning safety, handling, transport and disposal, please refer to the Safety Data Sheet.**

Our information on this data sheet is based on test results from our laboratories as well as on experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding for us. The information given in this leaflet represents neither a performance guarantee nor a guarantee of properties, nature, condition, state or quality. No liability may be derived from these indications nor from the recommendations made by our free technical advisory service.



Jowat Information

Gluing as one of the most efficient methods of bonding is constantly gaining importance and expanding into new areas of application. At the same time, the number of substrates to be bonded is also growing at an unprecedented rate. New methods and equipment to process adhesives are developed.

The in-house R & D departments of Jowat are responding with intensive efforts to keep pace with these constant changes. A highly qualified team of chemists and engineers is using the latest techniques and brightest ideas to provide the utmost in advice our customers and to make sure that they get the adhesive which meets their needs.

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The processing company itself must therefore test the adhesives manufactured by us for suitability in each individual case. This applies to the first use of a sample as well as to modifications during an ongoing production.

We are therefore requesting all our new customers to test our adhesives for suitability on original parts at conditions equal to normal processing conditions. The bond has then to be subjected to the actual stress which it would undergo when in use and has to be assessed. This test is absolutely necessary.

Customers who undertake modifications during a running production are requested to pass this information on to us. Please notify us when machines are set to new parameters as well as when the substrates to be bonded are changed. Only then will Jowat be able to provide our most up-to-date information to the processor using our adhesives.

The information given in this leaflet is based on practical experience and on results of tests in our laboratory, and does in no way constitute any guarantee of properties. No liability may be derived from these indications nor from the recommendations made by our technical advisory service.