

## PUR hot melt adhesive

# 609.45

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

**Application:** For flat lamination and the manufacture of sandwich elements and for wrapping wood and plastic profiles with non-transparent foils and with decor papers. Also for assembly operations in the woodworking and furniture industries.

**Characteristics/ Directions for Use:** Processing with special equipment from moisture-proof sealed containers. Application by slot nozzles. Plastic profiles have to be primed with the corresponding Jowat® primer.

**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/m<sup>2</sup> has to be observed (see test report TÜV Nord, No. SN08/6102.1).**

Processing temperature [°C]:	100 – 130	(depending on application)
Appearance:	light yellow translucent	
Density at 20 °C [g/cm <sup>3</sup> ]:	approx. 1.1 ± 0.1	(Jowat test method)
Softening range [°C]:	approx. 60 ± 5	(Kofler bench)
Open time at 120 °C [s]:	approx. 60 ± 15	(Jowat test method)
Reaction time [d]:	approx. 2 – 5	(dep. on ambient conditions)

Our Application Technology Department and our Application Specialists will provide technical data to assist you in your choice of an appropriate adhesive for your requirements. Please observe the information in the section “Remarks”.

**Specification:** Viscosity at 120 °C [mPas]: 31,000 ± 11,000  
(Brookfield, Thermosel, spindle 28, 10 rpm)



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**06/18** All data indicated are characteristics represented as average values. Our technical data sheets are periodically revised to represent the latest state of technology. This edition is replacing and superseding all previous ones, and is valid on the date of compilation.  
**Please refer to the last page of this technical data sheet for additional information.**

**Jowat**   
Klebstoffe

- 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 930.74 (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:** The product should remain stored in properly closed original containers, cool and dry (15 – 25 °C). For best-before date, please see container label. Protect from moisture.
- Packaging:** Information about moisture-proof containers and packaging units is available upon request.
- Remarks:** **For further information concerning safety, handling, transport and disposal, please refer to the Safety Data Sheet.**  
The information on this data sheet is based on test results from our laboratories as well as on reported experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding upon Jowat, nor should it be relied upon in lieu of your own required testing. The information given in this leaflet does not represent a performance guarantee. Unless otherwise agreed with our customers, the values stated in the section “Specification” shall be regarded as the product properties finally agreed. No liability may be derived from the information contained herein nor from the information provided 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.

Our information is based on test results from our laboratories as well as on experience gained in the field by our customers. This advice, however, cannot cover all eventualities for each specific application and as such is not binding for us. Please, contact our technical service department in each case to find out what the actual technical state of development for the respective product is, and request the latest data sheet. Any use of our product without this precautionary measure would be your sole responsibility.

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.