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## Everad® HKE 1953.1

Hotmelt adhesive in granulates for edge banding (automatic edge banding machines)

### Description

Everad® HKE 1953.1 is a solid hot-melt adhesive in granulates to bond flat or profiled edges (PVC, ABS polyester and melamine).

Characterized by medium-high viscosity, high yield value on various type of edges and a short open time.

**Packaging:**

Paper bags of 25 kg.

**Basis:**

EVA.

### Suggested usage

Everad® HKE 1953.1 is used for automatic edge banding machines.

Before any industrial use, to ensure itself by tests which the product corresponds well to the desired use.

### Processing

**Usage advice:**

Frequently check the temperature of the glue on the rollers. Temperature below the recommended value for applications cause a decrease in open time with consequent defective gluing results: at higher temperatures the adhesive may decompose with the detriment of color, viscosity and adhesiveness. When gluing cold or damp surfaces, gluing defects may occur due to the reduction in open time.

This glue is designed to be used on manual and slow edge banding machines.

Occasionally, unsatisfactory gluing results may be due to the type of edge or to the presence of release agents on the materials/panels; a preliminary test is therefore recommended.

Should such problem occur, it is advisable to use a suitable preparatory product.

**Processing:**

Acclimatize all materials before application of the adhesive.

Apply adhesive regularly on the side of the panel. For difficult to bond substrates, we recommend to apply before gluing to apply Everad® HPR Primaire Chants.

The information is based on tests at a wood humidity of 8-12%, an air relative humidity of 65% measured at 20 °C. Values may vary depending on material and working conditions.

**Application method:**

Automatic edge banding machines.

**Melting time:**

Approx. 20 minutes depending type of machine.

**Ideal operating speed:**

Approx. 10-50 m/min.

**Break of work:**

In case of break of work, it is suggested to reduce of 30-40°C the temperature in tray to avoid a degradation of the performance of the product.

**Application temperature:**

180-190 °C in the tank.

200-220°C by rollers.

### Chemical and physical properties

**Aspect:**

Granulates.

**Solid content:**

100%.

**Color :**

Beige.

**Melt index:**

ca. 145-175 g/10 min.

Viscosité mesurée après fabrication. Les valeurs peuvent subir des fluctuations à la hausse ou à la baisse lors du stockage du produit.

**Softening point (Ring and Ball) :**

ca. 103 °C.

**VOC content:**

0%

**Flammability:**

Non-flammable.

**Frost resistance:**

frost resistant.

### Film properties

**Colour:**

Beige

**Heat resistance:**

Approx. 85°C

### Clean-up

With Everad® HNE D-Col 12.

### Working safety

Please follow instructions on the safety data sheet.

There is no legal requirement of precautionary measures. To avoid the risk of allergy, it is advisable to work with gloves or protect hands with barrier cream.

### Storage

Cool (under 30 °C) and dry in unopened original packaging 12 months after production.

### Guarantee

We guarantee the consistency and faultless quality of this product, manufactured in accordance with ISO quality standards, which has been developed on the basis of our long-standing experience with the recommended applications under the specified conditions. Material, processing, and application conditions may significantly influence product properties. Pre-application tests by the user are therefore essential. For non-specified applications or deviations in application conditions, we recommend that our technical support service be consulted first. Our general sales and delivery terms and conditions shall apply.