

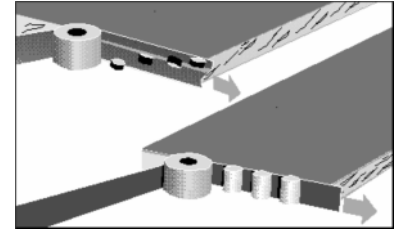


Technical Information

Purmelt RS G 270/7



PUR Hotmelt Adhesive for Edgebanding Straightline and Softforming



Characteristics

- High initial strength
- Chemical cross-linking within few days
- Very high heat resistance (> 150 °C/> 302 °F) and cold flexibility
- Excellent water resistance
- Produces tight joints
- Clean working
- Particularly suitable for nozzle application

Fields of application

- Edging material: solid wood, veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*
**Suitability depends on the individual characteristics of the edging material and how it is primed. In case of thick edges pre-tests should be carried out for suitability.*

Technical data

Softening point (Kofler):	approx. 68 °C (154 °F)
Viscosity (Brookfield):	approx. 30 000 mPa·s / 150 °C (302 °F)
Curing time to final strength:	2 - 5 days
Heat resistance:	> 150 °C (302 °F)

tested with 0.6 mm oak veneer using the DORUS method of increasing temperature

Instructions for use

Recommended working temperature	
in the melting container:	120 - 140 °C (248 - 284 °F)
at the application roller:	120 - 140 °C (248 - 284 °F)

Since the product will cure when it is exposed to moisture, storage and application must be done under dry conditions. For this reason, the product is delivered in airtight containers. Open package has to be processed within one day.

Please pay attention to reverse side!

Cleaning

Flushing the system with *Purmelt Cleaner 4* periodically or prior to changing to an alternative reactive hot melt will reduce internal build-up of adhesive residue. Application devices such as wheels and rolls that expose reactive adhesive to the air should be thoroughly flushed at the end of a production run or at anytime when there is build-up and gelling. Cured PUR hot melt can only be removed by softening with an appropriate solvent such as N-ethyl-pyrrolidone (NEP) and then using a non-abrasive scraper. Strictly follow the instructions of the machine manufacturer.

Delivery form

Granules

Storage

Store in a cool, dry place in the unopened original container for up to 9 months.

Labelling

The safety datasheet should be respected!

Safety

The product contains diphenylmethanediisocyanate. Even if the product is applied within the range of the recommended working temperature, the diisocyanate has a detectable vapour pressure. When the recommended working temperature is considerably exceeded, hazardous decomposition products may be formed in the application unit. Therefore, measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment. In case of skin contact with the hotmelt, do not try to remove the adhesive from the skin by force. Consult a doctor. Observe the material safety data sheet.

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The information provided herein, especially recommendations for the usage and applications of our products, is based on our knowledge and experience. Due to different material used as well as to varying working conditions beyond our control we strictly recommend to carry out intensive trials to test the suitability of our products with regards to the required process and applications. We do not accept any liability with regards to the above information or with regard to any verbal recommendation, except for cases where we are liable of gross negligence or false intention.



Technical Information

Recommendations for Working with Purmelt Granules



1. Quickmelter Technology

For example change over from:

DORUS KS 217 – Purmelt RS G 270/7 – DORUS KS 217

Situation:

DORUS KS 217 is in the melting pot and pre-melter.

Melting pot temperature 190 °C, pre-melter temperature 180 °C

Change over from DORUS KS 217 to Purmelt RS G 270/7:

DORUS KS 217 has to be emptied out completely from the melting pot, best by processing. Purmelt granules can then be placed into the melting pot. Remaining DORUS KS 217 is removed from the melting pot.

The working temperature has to be decreased to 145 - 155 °C.

Change over from Purmelt RS G 270/7 to DORUS KS 217 :

Purmelt has to be emptied out completely from the melting pot, best by processing. DORUS KS 217 can then be placed into the melting pot. Afterwards the temperature has to be **increased to 190 °C** in order to continue processing with DORUS KS 217.

Advice:

We recommend not to work with the “Quickmelt” system but to use the open melting pot. A fast and smooth cleaning with Purmelt Cleaner 4 is then possible.

2. Extruder Technology

*Alternately processing of EVA hotmelt (e.g. DORUS Q 819)
and Purmelt granules (e.g. Purmelt QR G 6205)*

Situation:

DORUS Q 819 is in the melting pot / roller and extruder.

Melting pot temperature 180 °C, extruder temperature 180 °C at heating radiator.

Change over from DORUS Q 819 to Purmelt QR G 6205:

DORUS Q 819 has to be emptied out completely from the extruder and melting pot / roller, best by processing.

Purmelt QR G 6205 can then be placed into the funnel of the extruder.

At first, the temperature of the extruder has to be kept at 180 °C, in order to flush out the remaining Q 819.

Afterwards the temperature of the extruder has to be **decreased to 130 °C**.

The adhesive mixture of DORUS Q 819 and Purmelt QR G 6205 has to be removed from the melting pot / roller.

As soon as clean film on the roller is seen, the temperature should be reduced to 150 °C at melting pot and roller.

Change over from Purmelt QR G 6205 to DORUS Q 819:

Purmelt QR G 6205 has to be emptied out completely from the extruder and melting pot / roller, best by processing. DORUS Q 819 can then be placed into the funnel of the extruder.

The temperature of the extruder should then be **increased to 180 °C**.

The adhesive mixture of DORUS Q 819 and Purmelt QR G 6205 has to be removed from the melting pot / roller.

As soon as clean film on the roller is seen, the temperature should be increased to 180 °C at melting pot and roller.

3. Cleaning of the pre-melter / extruder

If the pre-melter / extruder is no longer used after the processing with Purmelt, Purmelt Cleaner 4 (500 g) has to be flushed at 130°C. In order to avoid curing of Purmelt residues in the pre-melter / extruder, it is recommended that the pre-melter has to be flushed through once per week with approx. 500g Purmelt Cleaner 4. This prevention measurement keeps the pre-melter permanently operative.

Storage

Once opened (Packaging) the Purmelt Granules has to be processed within 24h.

This also applies for granules left in the the funnel above the melting zone.

The storage can be extended up to 3 - 4 days when the pre-melter / extruder funnel is equipped with a "Dry" gas blanket bleed system.

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