



DORUS HKP 20

June 2011

PRODUCT DESCRIPTION

DORUS HKP 20 provides the following product characteristics:

Technology	EVA
Product Type	Hotmelt Cartridge for HolzHer Edgebander unfilled
Application	Edgebanding
Appearance	Cartridges Transparent

Application Areas

- Edgebanding in HolzHer cartridge equipment as from feedrates of 10 m/min
- Edging material: solid wood, veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*
- Particularly suitable for solid wood

* Suitability depends on the individual characteristics of the edging material and how it is primed.

Product Properties

- Universal hotmelt adhesive
- Fast melting
- Very good wetting
- High glue mileage
- Produces tight joints virtually not visible
- High final bond strength
- Very high heat resistance

Technical Data

DORUS HKP 20:

Softening Point, Ring & Ball, °C	~110
Viscosity, Brookfield - 200 °C, mPa.s	~75,000
Heat Resistance, °C	~90
Tested with 0.6 mm oak veneer using the DORUS method of increasing temperature.	

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use

Working Temperature

Recommended working temperature:
at the application nozzle, °C 200 to 220
Particular in case of long and thick panels a higher processing temperature should be chosen. Sufficient high pressure is to be applied to press the edging material into the hotmelt beads and to obtain an even hotmelt film. If possible, use only straight edges, never twisted or strongly bowed ones. If slightly bowed, insert into magazine so that concave side faces panel. Thin coating with primer e.g. DORUS ND 183/1 may improve the adhesion of difficult-to-bond edges.

Material and room temperature, °C	≥18
Material moisture, %	8 to 12
Heating time, minutes	2 to 4

Safety

Hotmelt adhesives give off vapours even when the specified working temperature is not exceeded. The smells emitted may often cause irritation. When the specified temperatures are considerably exceeded over a longer period of time, there is the additional danger of decomposition products being given off. Therefore measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment.

STORAGE

Store in the original tightly closed packaging in a cool, dry place.

Shelf life

Shelf-life (in unopened original packaging), years 2

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

ADDITIONAL INFORMATION

Disclaimer:

The Information provided herein, especially recommendations for the usage and the application of our products, is based upon our knowledge and experience. Due to different materials 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 regard to the required processes and applications. We do not accept any liability with regard to the above information or with regard to any verbal recommendation, except for cases where we are liable of gross negligence or false intention. This datasheet replaces all former versions.

Reference 0.0