

ROMABOND 1002 New

Technical Data Sheet

CHARACTERISTICS AND APPLICATIONS

ROMABOND 1002 New is a hot-melt adhesive developed for use on automatic and semi-automatic edge banding machines for gluing wood veneer, melamine, PVC and ABS edges. It has medium open time, high heat resistance and relatively low viscosity. It provides good adhesion due to good flow and wetting characteristics. **ROMABOND 1002 New** solidifies rapidly right after the application which prevents staining on edge bands and accumulation on cutter blades. It is suitable for adhering edge bands with different widths from 0,40 mm to 2,00 mm.

TECHNICAL PROPERTIES

Characteristics	Test Method	Value
Base		EVA Copolymer
Viscosity(Brookfield HB;190°C)	ASTM D 3226	83000±10000 mPa.s
Softening point	ASTM E 28	Approx. 107 °C

INSTRUCTIONS FOR USE

The machine should be adjusted according to the recommendations of the machine manufacturers.

ROMABOND 1002 New can be processed in usual way. Good results are obtained under the following conditions:

Characteristics	Value
Room and materials temperature	18 - 20 °C
Wood moisture	% 8 - 10
Temperature at the applicator	190 - 220 °C
Application amount	150-250 g/m ²
Feed speed	9-22 m/min

Edges strips can have very different adhesion properties, even if the base material is the same. For this reason, it is advisable to make trials if the edges of an unknown type in order to test the suitability of the adhesive. The recommendations given by the edgeband manufacturers should be followed.

During long stops the adhesive temperature should be decreased to 30-40 °C to avoid degradation of the characteristics.

Application pressure should be right and must be evenly distributed during bonding. Inadequate pressure may cause defects in bonding.

Check the temperature of the spreading roller frequently and make sure that the temperature corresponds to the value on the machine thermometer. Fluctuations in application temperature, which can be either lower or higher, may affect bonding.

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CLEANING

All residual encrustations of adhesive must be completely cleaned from the melting tank from time to time as they conduct heat poorly and cause a lowering of the adhesive temperature. The cleaning period should be long for low-filled adhesives and shorter for long-filled adhesives.

STORAGE AND PACKAGING

ROMABOND 1002 New, is packed in 25 kg kraft bags. Store in dry and cool place preferably between 15°C to 25°C. Always store on pallets. In these conditions the adhesive can be conserved for at least 12 months without changing its properties.

HAZARDOUS INFORMATION

At the recommended working temperature the hot-melt will give off fumes, which can irritate the respiratory organs. If the working temperature is exceeded over a long period, harmful decomposition products will form. In any case an appropriate exhausting system shall be installed in the working area.

All the information in this technical datasheet is given in good faith and is the result of our own experience and tests and can only be considered as a guideline for operation. Roma Plastik is guarantee the constant quality of our products but we cannot be held responsible for the results obtained in their use, since the conditions of work are beyond our control. We recommend that tests should be made to determine the suitability of the product for a specific purpose before the production is started.