

## BETAMELT HOTMELT 511

### 1. PRODUCT DESCRIPTION

**Trade Name:** Betamelt Hotmelt 511

**Product Description:** EVA based Hotmelt Adhesive

### 2. TECHNICAL DATA

**Physical State:** Solid

**Color:** Natural, milky white or walnut

**Odor:** Slight

**Viskozity:** 105.000 ±10.000 mPa.s (Brookfield)

**Softening Point:** 108±3 °C (ASTM D36/DIN 52 011 Ring and Ball)

**Decomposition Temperature:** >250°C

**Solubility in Water:** Insoluble

### 3. APPLICATIONS

It is used on automatic beading machines for bonding edges of different materials (PVC, ABS, polyester, melaminic laminate, acrylic, melaminic papers, veneering and heartwood), in all the cases, where high efficiency as well as a really neutral and scantily visible glueing line are required.

### 4. METHOD OF APPLICATION

**Heat in tank:** 160 - 180 °C

**Heat in roller:** 190 - 210 °C

**Humidity in material:** 8 - 10 %

**Application speed:** 10 - 35 m/min

**Application pressure:** 3 - 5 kg/cm<sup>2</sup>

Application surface must be cleaned from dust and dirt.

Edge band and roller have to be min 16°C before applying.

Machine application speed should not be under 18 m/min.

When you have a break, drop tank heat to 30-40°C for keeping adhesives properties.

## 5. PACKAGING

In 20 kg plastic bucket or 25 kg Kraft bag.

## 6. STORAGE

Keep away from sunlight and store between 5-25°C. If stored in proper conditions shelf life is 18 months.

## 7. WARNINGS/ SAFETY PRECAUTIONS

Hot glues does not cause health problems in application but in higher temperatures they may cause burns.

Wear protective clothing and gloves while working. Keep children away.

Consult Material Safety Data Sheet for further information.