



TECHNICAL DATA SHEET

HOT MELT ADHESIVE

7825

TRANSPARENT

Fields of application:

Edging of sheet material with:

- ABS, PMMA, PVC and PP edges (with suitable bonding agent)
- Paper-edges
- Veneer and solid wood edges

Properties of the bonds:

- Heat resistance approx. 100°C according to the edge (the bond withstands temperatures up to 120°C in a drying tunnel for a short period)
- Cold resistance according to the Edge down to approx. -30°C
- Good resistance to water (important when staining or bleaching veneer edges)
- Good ageing resistance

Adhesive properties:

Base: EVA copolymer

Specific gravity: approx. 0.96 g/cm³

Viscosity Brookfield HBTD Sp.

27/10 rpm:wrz. 27/10 obr/min:

at 200°C approx. 36,000 mPa s

Melting point according to DIN 53 735

(MF1150/2.16):

Approx.. 105 g/10 minutes

Softening point (ring + ball) DIN 1995:

Approx.. 101°C

Application temperature:

Above 200°C

For solid edges or difficult plastic edges up to 230°C. (short period only)
Low temperatures can cause faulty bonding – ensure that the temperature is correctly set

Available as: granules

Colour: Transparent yellowish

Labelling: in accordance with EU guidelines - not compulsory

When hotmelt adhesives are melted and applied, vapours are set free and an unpleasant odour can occur even if the recommended working temperatures has been observed. Moreover, if the prescribed working temperature is exceeded over a long period, harmful decomposition products can develop. Precautions should be taken to eliminate the vapours, e.g. by using a suitable ventilation system

Feed rate:

- 14-35 m/min, Different speeds are possible depending on installation equipment

Processing:

The substrates for edge bonding have to be processed at exact tight angles and should be free from dust. Boards and edges have to be conditioned to room temperature. The most favourable moisture content of the wood is 8-10%. Room temperature should not be lower than 18°C. Draughts have to be avoided

Melting time: 2-5 min

When processing wood types which are difficult to bond, the working temperature can be briefly raised to 230°C
Temperature control is particularly important when bonding solid wood edges. For long and thick items, work within the higher temperature range. Lower temperatures lessen the wetting of the edge. The amount of adhesive and pressure applied should be set so that the beads applied are squeezed to form an adhesive layer all-over the surface to be bond and the adhesive pearls slightly at the edge. This can be checked best with a transparent test edge

Further processing:

The finished material can be processed further immediately following bonding (Sawed, milled, planted, etc.
Because the characteristics of edging materials can vary, individual testing is essential!





schilsner

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Storage:

Hot melt adhesive 7825 can be stored for about 2 years in a dry and cool place

Disposal of adhesive and packaging waste:

- by key 080410

Our packaging is made from recyclable material

Carefully emptied and cleaned packaging can be reused

Cleaning:

Absorfen Strong is the best product for removing soiling from veneering

Pack size:

20.0 kg net bag

