

Protak 3308

General Description

This is an unfilled medium viscosity adhesive for soft forming and edgebanding where difficult substrates are used, e.g. PVC, HPL, Solid Wood etc. Protak 3308 is ideal for use on machining centres such as the Baz machine..

Applications

Protak 3308 being unfilled enables the coating weight to be substantially reduced leading to a significant increase in mileage with no sacrifice in performance.

It has a very high tack adhesive providing excellent adhesion to difficult substrates such as primed PVC and high pressure laminates.

Technical Data

Chemical Base	EVA Copolymer
Form	Pellets (Prills)
Packaging	20kg Sack
Storage Life	The product should be stored in a cool dry place for up to 5 years
Viscosity at 220°C and 2.5 RPM (Brookfield RVT and Thermosel) mPas	37,000 +/- 1000
Melting Point (Ring and Ball ASTM A28)	100°C typical value
Colour	Clear in a thin film

Application Data

Viscosity at suggested application temperature	68000cP at 200°C (typical value)
Adhesive open time	Medium/Long
Adhesive molten tack	Very High
Methods of Application	Roller - Suggested application temperature is 180°C to 200°C Slot coater/nozzle (Depending upon substrates to be bonded).

Substrate Preparation

Ensure there is no dust on the edges - dust can cause defects in gluing as well as imperfect adhesion.

Application

Protak 3308 must be spread in a uniform and continuous coat, with a glue thickness that is suitable for the materials to be bonded. Porous substrates require a higher glue coat, whilst thin edging material requires a lower coat to avoid telegraphing problems on the surface to the edge.

To avoid irregular glue spread, and consequently bonding defects, regular checks should be made to ensure the glue roller is perfectly parallel with the panel edge. The quantity of the glue spread will regulate the open time of the adhesive - the higher the spread of the glue the longer the open time, and vice versa.

Different edging materials perform in different ways. Before changing materials it is recommended that the adhesion be carefully checked. The heat resistance of the bonded material is strongly influenced by the characteristics of the edging material itself.

If the edgebander is stopped temporarily, reduce the temperature in the hot melt pot by approx. 30-40°C to avoid oxidation problems and the formation of a crust on the surface of the glue.

Heat Resistance

Protak hot melt adhesives offer good heat resistance. However, many factors can effect this, so tests should be carried out to determine the heat resistance and, in each case to satisfy yourself as to its suitability.

Equipment Maintenance

Adhesive tanks and applicators should be thoroughly cleaned from time to time to prevent the build up around these areas. This build up could result in hot spots, or inaccurate temperature readouts. The tank will contain residue at the end of working, which needs to be removed regularly. The tank sides should also be cleaned to remove any encrustations, which may affect the transfer of heat.

Health and Safety Information

Protak 3308 is not required to be marked hazardous. However, even at correct working temperatures, vapours are released which can cause unpleasant odours. If the given working temperatures are exceeded for a long period of time, the fumes released may irritate the respiratory system and extraction should be used. In addition the adhesive will begin to degrade and cease to be effective.

Please consult the Protak 3308 Material Health and Safety Data Sheets for statutory regulation information.

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