

# Product Data Sheet

## Protak 3465

### General Description

Protak 3465 is a high heat resistant hot melt adhesive for edgebanding, suitable for straight edging and solid wood lippings. The product is a high quality adhesive with excellent working properties.

### Applications

Protak 3465 is characterised by a medium viscosity and high hot tack and has been developed for bonding solid lippings of differing materials such as wood, PVC and other plastic edging .Protak 3465 is also recommended as a general purpose hot melt for bonding plastic laminate, wood veneer and melamine edges.

### Technical Data

Chemical Base	EVA Copolymer
Form	Pellets (Prills)
Viscosity at 220° C and 2.5 RPM (Brookfield RVT and Thermosel) mPas	32,500-60,000
Melting Point (Ring and Ball ASTM A28)	94-106°C

### Application Data

#### Packaging

20 kg Sack

#### Storage Temperature

Store in clean dry place at temperatures between 5°C and 30°C

#### Application Temperature

Adhesive Temperature Roller: 200-220°C  
Adhesive Temperature Tank: 170-190° C

#### Storage Life

Up to 5 Years sealed

#### Glue Spread

180 – 250 g/m<sup>2</sup>

#### Pressure On Rollers

0.4-0.8 N/ mm<sup>2</sup>

#### Optimum Track Speed

20-60 m/min

#### Humidity of Materials

8 – 12%

### Substrate Preparation

Ensure there is no dust on the edges - dust can cause defects in gluing as well as imperfect adhesion. The use of a primer will improve adhesion on difficult edges such as solid wood lippings. However, before applying the hot melt ensure that all the solvent in the primer is first flashed off.

### **Application**

Protak 3465 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 track speed should not normally be lower than 18m/min as low speeds may cause bonding problems due to the cooling of the adhesive. It is therefore recommended that if slower speeds are required, use a heavier glue spread to increase the open time. However see below:

At track speeds lower than 20m/min, the adhesive temperature should be at the higher level recommended above. With speeds as low as 10 - 14 m/min, Protak 3465 can be used with the aid of other external heating sources, such as hot air blowers aimed directly at the glue line, before pressure is applied. As an alternative for slower feed speeds, see other products in our range, such as Protak 351.

For higher speeds than the optimum speed above, and in particular feed speeds of - 60-80 m/min, we suggest that the temperature on the glue roller and in the hot melt pot, is increased by 4 - 6°C to facilitate quick melting.

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.

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.

### **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 3465 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 3465 Material Health & Safety Data Sheets for safety regulation information.**

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