

EVA hot melt adhesive

260.33

Application: Assembly hot melt adhesive for the manufacture of pocket innersprings.

Characteristics/ Low viscosity.
Directions Good resistance to oxidation and colour stability in the melt.
for Use: Minimal odour.
 Processing on fully and semi-automatic units with horizontal and vertical nozzle application systems.

Processing temperature [°C]:	140 – 170
Appearance:	light yellow
Softening range [°C]:	approx. 105 ± 5 (Kofler bench)
Density at 20 °C [g/cm³]:	approx. 0.95 ± 0.02 (Jowat test method)
Open time at 160 °C [s]:	approx. 5 ± 1 (Jowat test method)
Setting time at 160 °C [s]:	approx. 1.5 ± 0.5 (Jowat test method)

Measured on a hot melt bead, 3 – 4 mm Ø.

Our Application Technology Department and our Application Specialists will be pleased to assist you with the choice of a suitable adhesive for your requirements.

General bonding requirements: The properties of the substrates and the processing conditions will influence the processes of joining and bonding. Customer trials before use are therefore absolutely necessary to define stable process parameters. The materials to be bonded must be free of grease and dust and be dry. Minimum temperature of substrates and ambient air should not be below 18 °C. Avoid draught.

Specification: Viscosity at 160 °C [mPas]: 1,700 ± 400
 (Brookfield, Thermosel, spindle 27, 20 rpm)

Cleaning: Mechanical preliminary cleaning while hot (e.g. with a spatula). Remove any residues when cold with Jowat® Cleaner 402.40.

Safety instructions: When hot melt adhesives are melted, vapours may be set free and an unpleasant odour may occur, even if the specified processing temperature has been observed. Moreover, if the specified processing temperature is exceeded over a longer period, harmful decomposition products may develop. Suitable precautions should therefore be taken to eliminate the vapours (e.g. by using an extraction and ventilation system).

Storage: Cool and dry.
 Best-before date, please refer to label on the packaging unit.

Packaging: Types of packaging and units upon request.

Remarks: **For further information concerning safety, handling, transport and disposal, please refer to the Safety Data Sheet.**

Our information on this data sheet is based on test results from our laboratories as well as on experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding for us. The information given in this leaflet represents neither a performance guarantee nor a guarantee of properties, nature, condition, state or quality. No liability may be derived from these indications nor from the recommendations made by our free technical advisory service.

11/17 All data indicated are characteristics represented as average values. Our technical data sheets are constantly revised to represent the latest state of technology. This edition is replacing all previous ones, and is valid on the date of compilation.
 Please refer to the last page of this technical data sheet for additional information.

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 Klebstoffe

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Jowat Information

Gluing as one of the most efficient methods of bonding is constantly gaining importance and expanding into new areas of application. At the same time, the number of substrates to be bonded is also growing at an unprecedented rate. New methods and equipment to process adhesives are developed.

The in-house R & D departments of Jowat are responding with intensive efforts to keep pace with these constant changes. A highly qualified team of chemists and engineers is using the latest techniques and brightest ideas to provide the utmost in advice our customers and to make sure that they get the adhesive which meets their needs.

Our information is based on test results from our laboratories as well as on experience gained in the field by our customers. This advice, however, cannot cover all eventualities for each specific application and as such is not binding for us. Please, contact our technical service department in each case to find out what the actual technical state of development for the respective product is, and request the latest data sheet. Any use of our product without this precautionary measure would be your sole responsibility.

The processing company itself must therefore test the adhesives manufactured by us for suitability in each individual case. This applies to the first use of a sample as well as to modifications during an ongoing production.

We are therefore requesting all our new customers to test our adhesives for suitability on original parts at conditions equal to normal processing conditions. The bond has then to be subjected to the actual stress which it would undergo when in use and has to be assessed. This test is absolutely necessary.

Customers who undertake modifications during a running production are requested to pass this information on to us. Please notify us when machines are set to new parameters as well as when the substrates to be bonded are changed. Only then will Jowat be able to provide our most up-to-date information to the processor using our adhesives.

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