

# Hranitherm 1000.30

# Hranitherm 1000.31

Solid hot-melt EVA based adhesive supplied in cartridges

## WHERE IT IS USED

It is used for bonding edges made of PVC, ABS, laminates, polyester and synthetic resins. It is used for bonding edges made of ABS, PVC, laminates, polyester and synthetic resins.

## INSTRUCTION FOR USE

Frequently check the temperature of the glue. Temperatures below the recommended value for application cause a decrease in open time with consequent defective gluing results; at higher temperatures the adhesive may decompose with the detriment of colour, viscosity and adhesiveness. When gluing cold or damp surfaces, gluing defects may occur due to the reduction in open time. In case of break of work, it is suggested to reduce of 30 °C – 40 °C the temperature in tray to avoid a degradation of the performance of the product. Occasionally, unsatisfactory gluing results may be due to the type of edge or to the presence of release agents on the materials/panels; a preliminary test is therefore recommended.

## TECHNICAL DATA

Parameter	Value
Appearance	Cartridges, diameter 63 mm, length 26 mm
Colour	
1000.30	Transparent
1000.31	White
Viscosity (Brookfield at 200 °C)	60.000 – 85.000 mPas
Softening temperature (Ring and Ball)	105 – 115 °C
Density	1,0 g/cm <sup>3</sup>

## SUITABLE WORKING CONDITIONS

Parameter	Value
Room temperature	15 – 25 °C
Humidity of material to be bonded	8 – 10 %
Working temperature	190 – 210 °C
Pressure on pressure roller	3 – 5 kg/cm <sup>2</sup>

**CLEANING**

The working elements should be cleaned using spatula for example.

**SAFETY AND HEALTH PRECAUTIONS**

Even under normal conditions of use product may produce hazardous vapours which may cause a respiratory tract irritation. Provide adequate ventilation. Before use read the SDS of the product

**STORAGE**

Validity: 24 months in factory sealed containers (20 °C). Store the product in a cool and dry place.

**PACKAGING**

Information on request from your area sales manager eventually available on [www.hranipex.cz/en](http://www.hranipex.cz/en)

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The information contained in this leaflet and the suggestions on how to use our products correspond to the current state of our scientific and practical knowledge. However, there aren't any warranty or liability on the final result of the carried out work using our products due to the variability of the materials and application conditions that go beyond our control. We therefore recommend to carry preliminary tests out also in relation to the subsequent applications foreseen for the product and the operating conditions of the finished product. This revision annuls and replaces any other previous ones.