

TECHNOMELT KS 654

Known as DORUS Q 654

April 2013

PRODUCT DESCRIPTION

TECHNOMELT KS 654 provides the following product characteristics:

Technology	EVA
Product Type	Hotmelt
Application	Edgebanding
Appearance	Granules Natural

Application Areas

- Edgebanding as from feedrates of 15 m/min
- Edging material: veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*
- Suitable for processing centres (BAZ) with direct application
- Softforming

* Suitability depends on the individual characteristics of the edging material and how it is primed.

Product Properties

- High viscosity
- Slightly filled
- Fast melting
- High glue mileage
- Very high heat resistance
- Clean running
- Produces tight joints virtually not visible
- Permits smooth surfaces even with very flexible edging materials
- Very good wetting

Technical Data

TECHNOMELT KS 654:

Softening Point, Ring & Ball, °C	~115
Viscosity, Brookfield - 180 °C, mPa.s	~280,000
Viscosity, Brookfield - 200 °C, mPa.s	~140,000
Heat Resistance, °C	~95
Tested with 0.6 mm oak veneer using the Henkel method of increasing temperature	

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use

Working Temperature

Recommended working temperature:	
in the melting container, °C	190 to 210
at the application nozzle / roller, °C	190 to 210

Safety

Hotmelt adhesives give off vapours even when the specified working temperature is not exceeded. The smells emitted may often cause irritation. When the specified temperatures are considerably exceeded over a longer period of time, there is the additional danger of decomposition products being given off. Therefore measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment.

STORAGE

Store in the original tightly closed container in a cool, dry place.

Shelf life

Shelf-life (in unopened original packaging), years 2

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

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