

TECHNOMELT PUR HKP 29 ME

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PRODUCT DESCRIPTION

TECHNOMELT PUR HKP 29 ME provides the following product characteristics:

Technology	PUR
Product Type	Hotmelt
Application	Edgebanding Straightline
Appearance	Cartridge

Application Areas

- Edgebanding as from feedrates of 15 m/min
- Edging material: solid wood, veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*
- In case of thick edges pre-tests should be carried out for suitability

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

Product Properties

- MicroEmission (ME) contains less than 0,1% isocyanate monomer
- MicroEmission (ME) reduces isocyanate vapors by up to 90%
- High initial strength
- Chemical cross-linking within few days
- High final bond strength
- Very high heat resistance (> 150 °C/> 302 °F) and cold flexibility
- Excellent moisture resistance
- Produces tight joints

Technical Data

TECHNOMELT PUR HKP 29 ME:

Softening Point, Ring & Ball, °C	~85
Viscosity, Brookfield - , 150 °C, mPa.s	~60,000
Heat Resistance, °C Tested with 0.6 mm oak veneer using the Henkel method of increasing temperature.	>150
Curing Time to final strength, days (depending on substrate)	2 to 5

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **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 Conditions

Recommended working temperature:	
in the melting container, °C	130 to 150
at the application roller, °C	130 to 150
Recommended room temperature, °C	18 to 35
Recommended humidity, %:	30 to 60

Cleaning

Flushing the system with TECHNOMELT PUR CLEANER 4 periodically or prior to changing to an alternative reactive hot melt will reduce internal build-up of adhesive residue. Application devices such as wheels and rolls that expose reactive adhesive to the air should be thoroughly flushed at the end of a production run or at anytime when there is build-up and gelling. We recommend for the cleaning of the application equipments TECHNOMELT PUR CLEANER ME or TECHNOMELT PUR CLEANER ALL-IN-1. When working with the cleaning agents safety instructions must be considered. Follow also strictly the instructions of the machine manufacturer.

Safety

The product contains remaining quantities of monomer diphenylmethanediisocyanate (MDI), which, within the range of the recommended working temperature, has a detectable vapour pressure. Aside hazardous decomposition products may be formed in the application unit. To secure that the MAK of the MDI (0,005 ppm) is under-run, measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment, (MAK=TLV: threshold limit value for workplace concentration). In case of skin contact with the hotmelt, do not try to remove the adhesive from the skin by force. Consult medical assistance. Observe the material safety data sheet.



STORAGE

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

Reference 0.1

Shelf life

Shelf-life (in unopened original packaging), months 9

Classification

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

Hazardous Information
Transport Regulations
Safety Regulations

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Henkel AG & Co. KGaA
 73438 Bopfinger, Germany
 Phone: +49-7362-81-0

Henkel Corporation
 Bridgewater, NJ 08807, USA
 Phone: +1-908-685-7000

Henkel (China) Co.Ltd.
 201203 Shanghai, China
 Phone: +86-21-2891-8000

For more information contact us on www.henkel.com