



TDS

Model Number : K-804

Type	EVA Hot Melt Adhesive for Edge Banding	
Model Number	K-804	
Composition	Ethylene-Vinyl Acetate (EVA), rosin ester, petroleum resin, inorganic fillers	
Appearance	Off white oval-shaped solid granules	
Packaging	Net weight 25kg per bag, packaged in PP woven bag	
Technical Parameters	Brookfield Viscosity (cps)	180°C: 60,000-65,000 200°C: 40,000-45,000
	Density (g/cm ³)	approx. 1.40
	Softening Point (°C)	95±2
	Application Roller Temperature (°C)	170-210
Operating Temperature	Feed speed (m/min)	15-40
	Pressure (kg/cm ²)	3-5
Characteristics	Fast curing, good initial tack, no adhesive thread, cold and heat resistance, excellent solvent resistance, good peel strength.	
Cleaning	Remove uncured adhesive with a scraper, followed by adding paraffin wax to melt and clean.	
Storage	Shelf life of at least 18 months if stored in a cool and dry place.	

Risk Warning:

If the operating temperature exceeds the specified maximum limit for an extended period, the hot melt adhesive may decompose and produce harmful substances. Good ventilation can eliminate the odor released by the hot melt adhesive. For high-temperature operations, take proper protective measures.

Scope of Use:

Suitable for fully automatic edge banding machines. Application: PVC, melamine papers, veneer, thin wood flakes.

Application Guidelines:

1. Compatible equipment: Fully automatic edge banding machines.
2. Compatible substrates: Particleboard, plywood, Medium-Density Fiberboard (MDF), eco-friendly board etc.
3. Primarily used for thickened panels in wood door manufacturing and other thickened panels, and especially for the equipment which has poor heating performance conditions.
4. When performing edge banding on thick panels, set the equipment temperature to 200-205°C, and apply adequate adhesive thickness to make sure strong bonding.

