

## TECHNICAL SHEET

### DUDITERM 549/15

A solid, hot-melt adhesive on EVA base, Duditerm 549 is characterized by medium-low viscosity, high heat resistance and excellent adhesive properties. As a consequence, it is particularly suitable for bonding edges of different materials by edgebonding machines and soft-forming.

### CHARACTERISTICS

Solid adhesive on synthetic resin base

- Form		granulated
- Color		natural, walnut and white
- RVF mod. Brookfield viscosity at 200°C with Thermosel (at 2 rpm)	mPa.s	70,000 ± 10,000
	mPa.s.	80,000 ± 10,000 white
- Softening point (Ring and Ball ASTM D36/DIN 52 011)	°C	105 ± 3
- Specific weight	g/cm <sup>3</sup>	1,33 ± 0,03

### CONDITIONS FOR USE

- Material moisture	%	8 - 10
- Relative humidity	%	65 - 75
- Ambient and material temperature	°C	> 15
- Temperature of product in tank	°C	180 - 200
- Temperature on the spreading roller	°C	210 - 230
- Feed speed	m/min	≥ 30
- Pressure on edges	kg/cm <sup>2</sup>	3 - 5
- Spreading	g/m <sup>2</sup>	180 - 250

### APPLICATIONS

Duditerm 549 is used on automatic edgebonding machines for bonding edges of different materials (PVC, ABS, polyesther, melaminic laminate, melaminic papers, veneers and solid lippings) when good heat resistance and high feed speed are required (30-40 m/min). Thanks to the high and quick adhesive properties it is also suitable for soft-forming.

## USEFUL RECOMMENDATIONS

- The edges to be glued should be perfectly clean. The presence of dust may cause glueing problems due to a poor adhesion. Supports should be properly dimensioned and squared to avoid places of possible insufficient pressure.
- The temperature of Duditerm 549 in tank and on the spreading roller should be frequently controlled by means of a temperature comparator so as to obviate any possible error by the remote thermometers and thermostats, which are installed on the beading machines and may give not reliable values.
- Duditerm 549 should be spread evenly and regularly. The quantity to be spread varies in dependance of the types of edge and support. A poor quantity may cause ineffective edge fixing, whereas an excess of product makes the glueing line visible and may cause machine and material soiling.
- The materials to be glued (edges and supports) should be conditioned at a min. temperature of at least 15°C to avoid that the melted glueing product, coming into contact with the the cold material, may cool too rapidly, which would reduce the surface wetting and cause therefore glueing defects.
- Feed speed should not be lower than 18 m/min to avoid an excessive Duditerm 549 cooling before pressing. Should it be necessary to work at lower feed speeds, do not forget to compensate the loss of waiting time (by applying hot-air jets, by increasing temperature on the spreading roller, by pre-heating support and edges, etc.)
- For 'difficult' edges, such as roughly rubbed melaminic laminates, with glassine traces, etc., it is recommended to use our "Preparatore 2000", which improves the glueing condition.
- During intervals (break for lunch, long waiting times) it is recommended to reduce the temperature of Duditerm 549 in the tank by 30 °C to 40 °C to maintain the product characteristics unchanged.
- It is recommended to keep the melting tanks clean from incrustations so as to facilitate the product melting.
- The adhesion characteristics of the edges are not the same for all the material lots. It is therefore recommended to verify them at the beginning of each new lot by means of preliminary tests.
- Resistance to high and low temperature depends not only on the glueing quality, but also on the material glued, on edge tendency to bend, to lengthen or to shrink and on the time the glued edges are subjected to the operating temperature.
- Shelf life of Duditerm 549 in cool dry room: at least 12 months.

## PACKAGING

25 kg bags.

The contents of this technical sheet is purely of general nature and is not subject to any guarantee. Therefore, the above recommendations should be adapted to the materials used and to the specific environmental conditions.

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