

TECHNICAL SHEET

DUDITERM 550/15

A solid, hot-melt adhesive on EVA base, Duditerm 550/15 is characterized by medium-low viscosity and high thermal resistance. It has high adhesive properties, that make it suitable for bonding edges of various materials on beading lines and in soft-forming processes.

CHARACTERISTICS

Solid adhesive on synthetic resin base

- Form		granulated
- Color		natural
- RVF mod. Brookfield viscosity at 200°C (with Thermosel at 2 rpm)	mPa.s	70.000 ± 10.000
- Softening point (Ring and Ball)	°C	102 ± 5

CONDITIONS FOR USE

- Material moisture	%	8 - 10
- Relative humidity	%	65 - 75
- Ambient and material temperature	°C	> 15
- Temperature of product in tank	°C	170 - 190
- Temperature on the spreading roller	°C	200 - 220
- Feed speed	m/min	> 15
- Pressure on edges	kg/cm ²	3 - 5
- Spreading	g/m ²	200 - 300

APPLICATIONS

Duditerm 550/15 is used on automatic beading machines for bonding edges of different materials (PVC, ABS, polyesther, melaminic papers, melaminic laminate, veneers, heartwood) where easy application shall be combined with good thermal resistance.

USEFUL RECOMMENDATIONS

DURANTE & VIVAN S.P.A.
33080 Ghirano Di Prata (Pn) Italy
Via G. Garibaldi, 23 - Tel. +39 0434 605211
info@durante-vivan.com - www.durante-vivan.com

Ufficio Vendite Italia Tel. +39 0434 605220 - Fax +39 0434 605209
Ufficio Vendite Estero Tel. +39 0434 605242 - Fax +39 0434 605205
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- 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 550/15 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 550/15 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 16°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 15 m/min to avoid an excessive Duditerm 550/15 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 edge, etc.
- For "difficult" edges, such as roughly rubbed melaminic laminates, with glassine traces, etc., it is recommended to use a primer in order to improve the adhesion:
- During intervals (break for lunch, long waiting times) it is recommended to reduce the temperature of Duditerm 550/15 in the tank by 30 to 40 °C to maintain the product characteristics unchanged.
- The melting cups should be always kept clean from incrustations 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 550/15 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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