

# PROTOSTIK 5400

EVA based hot melt adhesive for edgebanding, general use, with medium viscosity. Also suitable for soft-forming operations. For HPL, resinated papers, veneer, and plastic edges (ABS, PVC) on chipboard and MDF panels, when a good heat resistance is requested in combination with a fast melting, high adhesion and high cohesion.

## CHARACTERISTICS

### Sales specifications:

Viscosity at 200°C (UNI EN 12092) 120.000 ± 10.000 mPa s

### Other characteristics \*:

Base EVA  
Colour Natural, milky white, walnut  
Softening point (Ring & Ball) 85 – 102°C

\*no sales specifications

## DIRECTIONS FOR USE

Application temperature, tank 180 - 190°C  
Application temperature, roller 190 - 210°C  
Adhesive quantity  
(depending on the materials) 180 – 250 g/m<sup>2</sup>  
Feed speed 15 – 30 m/min  
Pressure on the rollers 3 – 5 kg/cm<sup>2</sup>  
Room and material temperatures 18 – 25°C  
Parts cleaning Solvente 4022

## RECOMMENDATIONS

- Regularly check the temperature of the glue in the melting tank and on the application rollers
- During breaks that last more than 30 minutes you must reduce the temperature in the melting pot by 30°C to avoid the thermal oxidation of the glue.
- Keep the melting tank full of glue and with the cover closed to avoid thermal oxidation and crust formation.
- Before starting the application, check for the complete melting of the glue
- Wrong application temperatures may result in a defective bonding.
- Check that the materials are dust-free to avoid defective bonding.
- Materials must be kept at a room temperature not below +15°C. Avoid draughts.
- Pressing rollers must be checked to ensure an effective contact between the surface to be bonded. The parts to be glued must be perfectly matching and smooth.
- Before starting a mass production with new materials, do preliminary trials to check the quality of the bonding.
- Heat resistance and cold resistance of the bonded part depends on the quality of the bonding, on the materials and on the application parameters. The operator must check all variables of the bonding process to reach the best performances.
- When bonded parts have to be painted, we suggest to apply a first coating and let it dry. Before running the process check that the painting cycle don't affect the quality of the bonding.

## STORAGE

Shelf life: 12 months

## PACKAGING

Bags, 25Kg.

COLLANTI CONCORDE acts under the ISO 9001 system.  
Materials and application conditions affect the final performances of our products.  
Preliminary trials are therefore recommended.

Issuing date: January 2019.  
Material Safety Data Sheet Available

All information and recommendations in this bulletin are based upon practical experience and they don't exempt our customers to make tests when they receive the goods. We can bring changes to our characteristic details of our products in according with the technical and productive development. All information in this bulletin request some tests, because there are many details which are not verifiable during the working from us, particularly when you use raw materials of other suppliers. Our suggestions don't exempt you to check and in any case to resolve the problem when there is a possible violation of patents of other suppliers.