



# TECHNICAL DATASHEET

## Hot melt in granulate for edge bonding



**Products:**

<b>DANAFIX 866</b>	<b>DANAFIX 870</b>	<b>DANAFIX 875</b>
<b>DANAFIX 867</b>	<b>DANAFIX 871</b>	<b>DANAFIX 876</b>
<b>DANAFIX 868</b>	<b>DANAFIX 872</b>	<b>DANAFIX 877</b>

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**Product description and application:**

Hotmelts in granulate for edge bonding contain the series DANAFIX 860 and 870. The adhesives have good melting properties, good initial tack, minimal threading and are suitable for automatic edge bonding systems.

Most of the hotmelts are suitable for fast going production machinery with minimum machinery speed at 12-18 m/min. If slower application speed is needed DANAFIX 872 and 875 is recommended. The hotmelts has generally high heat resistance with softening points for most of them above 100 °C. DANAFIX 876 and 877 has the highest heat resistance. DANAFIX 868 has low heat of fusion, DANAFIX 870 is a transparent hotmelt without filler, DANAFIX 871 is a standard product in the colour nature, and DANAFIX 872 is especially suitable for complicated glue able materials. DANAFIX 876 and 877 differ only in colour.

**Application:**

**Materials:**

	866	867	868	870	871	872	875	876	877
Paper:.....	●	●	●	●	●	●	●	●	●
Polyester:.....	●	●	●	●	●	●	●	●	●
Melamine:.....	●	●	●	●	●	●	●	●	●
Pretreated PP:.....				●	●	●	●	●	●
Pretreated PVC:.....	●	●	●	●	●	●	●	●	●
Pretreated ABS:.....	●	●	●	●	●	●	●	●	●
Veneer:.....	●	●	●	●	●	●	●	●	●
Solid wood <sup>1</sup> :.....						●		●	●

1) Thickness max 15 mm.

**Item number (25 kg):**

866	867	868	870	871	872	875	876	877
631013	6502	6448	6337	6346	6290	6528	6339	6345

**Physical / chemical properties:**

	866	867	868	870	871	872	875	876	877
Type:.....	EVA copolymer								
Color:.....	Nature	White	Nature	Transp.	Nature	Nature	Nature	White	Nature
Melting point:.....	96-106°C	106-112°C	98-108°C	104-114°C	99-109°C	Ca. 105°C	80-90°C	108-118°C	108-118°C
Viscosity <sup>1</sup> :.....	70.000-100.000 cP	70.000-95.000 cP	60.000-80.000 cP	55.000-75.000 cP	88.000-146.000 cP	50.000 cP	35.000-80.000 cP	70.000-100.000 cP	70.000-100.000 cP
Machinery speed:.....	Min. 12 m/min	Min. 15 m/min	Min. 12 m/min	Min. 15 m/min	Min. 12 m/min	Min. 5 m/min	Min. 2 m/min	Min. 18 m/min	Min. 18 m/min
Storage:.....	Min. 2 years stored cold in original unsealed packaging.								

1) Measured at 150°C for DANAFIX 875 and 200°C for the rest.

## Direction for use:

**Preparation:** The substrates have to go well together, be clean and dry, free of dust, oil and other loose particles. Boards and edges have to be conditioned to room temperature. Room temperature should not be lower than 18°C. Draughts have to be avoided. The most favorable moisture content of the wood is 8-10%.

**Application:** The adhesive is applied with standard hot melt equipment e.g. nozzle or roller. Always follow the instructions from the equipment supplier.

**Application temperature:**

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190-210 °C	190-210 °C	170-200 °C	180-210 °C	180-210 °C	160-180 °C	130-160 °C	190-220 °C	190-220 °C

The temperature should be checked directly at the application system. Too low temperature will result in bad adherence and too high temperature will destroy the hot melt. If the application system is not operation for a period of time the temperature must be set to 160 °C.

**Amount of glue:** The amount of glue must be adjusted so that the full width of the joint contains glue. Transparent edges can be used for checking the glue spreading.  
The following amount of glue will normally be sufficient:

866	867	868	870	871	872	875	876	877
300-350 g/m <sup>2</sup>	250-300 g/m <sup>2</sup>	150-250 g/m <sup>2</sup>	180-250 g/m <sup>2</sup>	180-250 g/m <sup>2</sup>	200-250 g/m <sup>2</sup>	180-250 g/m <sup>2</sup>	180-250 g/m <sup>2</sup>	180-250 g/m <sup>2</sup>

**Cleaning:** The hot melt equipment is cleaned with DANAFIX 918 and the tools with DANAFIX 919.

**Storage:** Cold and dry in original sealed packaging (max. 25 °C).

## Safety:

**Hazard Symbols:** None

**Risk and safety phrases:** None

For further information concerning safety, refer to Safety Data Sheet.

## Further information:

**DANA LIM offers a range of adhesives for professionals:**

100-series: Upholstering adhesives

200-series: Flooring adhesives

300-series: Wall adhesives

400-series: Wood adhesives

500-series: Sealants & PU-foams

600-series: Building-additives, fillers etc.

700-series: Paper-, packaging- and newspaper adhesives

**800-series: Hot melt**

900-series: Cleaning-, release agents and hardeners.

**In the 800-series Hot melts DANA LIM offers:**

810-serien: Hot melt sticks

840-serien: Hot melt in cartridges for edge bonding

850-serien: Hot melt for assembling

860-serien: Hot melt for profile wrapping

**870-serien: Hot melt in granulate for edge bonding**

880-serien: Hot melt for packaging closing

890-serien: Pressure sensitive hot melt

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