

Technical Specifications

Tece Hot Melt 2042 (THM 2042)

1. Product name:

Tece Hot Melt 2042 (THM 2042)
Hot Melt for Edgebanding machines.

2. Supplier

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3. Description

Tece Hot Melt 2042 (THM 2042) is thermoplastic synthetic resin adhesive based on EVA-elastomers. THM 2042 is used on automatic edgebanding application machines. The adhesive melts and flows very well offering a medium heat resistance and very good adhesive properties. Though the adhesion properties are well accepted during the application, THM 2042 contains some amount of calcite filler to be more economical.

THM 2042 is suitable for the application of the following edgebanding:

- Plastic edgebanding preheated with a good primer
- Melamine edgebanding
- Veneers edgebanding with fleece or without fleece

4. Specifications:

Color: It can be **white, natural wood color, black** or **another other color** requested by the customer.

Machinery: This hot melt has been used on many kinds of curved edgebanding machines. From Homag to SCM, Biesse, from Turanlar to other brands in the world. All results have been satisfactory as long as the application method is right.

View: Solid round pellets

4. Instructions for Use

- Environment Temperature: 15 - 22 °C
- Panel Temperature: > 15 °C
- Humidity in Product: 8 -10 %
- Humidity in the Air: 65-75 %
- Amount to be Applied: 170 – 285 gr /m2
- Temperature of Tank: 180 -200 °C
- Roller Temperature: 190 -210 °C
- Application Speed: 12 -30 meter / min
- Application Pressure: 3-5 Kg. / cm²

5. Recommendations

- The application surface must be cleaned from dust, dirt and grease. Undesired dust and grease prevent to achieve a successful result of endurance and a strong bonding. The pressure must be applied homogenously to all edges of the panel. The temperature of the adhesive tank must be controlled often to make sure that it is in the right range.
- The temperature of the application surface and environment must be higher than 15°C.
- Otherwise, successful results may not be achieved due to faster drying time.
- Adhesive tank should be cleaned often.
- In case of having a break, adhesive temperature must be kept at 100-110C to keep performance higher.
- The bonded material's resistance against to heat is directly proportional to twisting, shortening, elongation of the edgbanding.
- The remained hot melt in the tank should not heated and cooled too many times. Other the EVA glue loses its adhesion properties.

6. Packaging

24 kg in plastic buckets.

7. Storage

Dry and cool area, it can be stored for 12 months period.

8. Caution

Even if the recommended working temperatures are observed, hot melt adhesives will give off fumes often causing unpleasant odors. To avoid that danger, measures should be taken to remove the vapors by some sort of air exhausters.

9. Technical Services

In case you need any technical support, please contact TECE at

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