



HELMITHERM

HOT MELT ADHESIVES FOR PROFILE WRAPPING AND EDGEBANDING APPLICATIONS

PRODUCT	430 431 432 433	480 482	480C 482C	493	494	495	495C	496C	406	439	499 Hot melt cleaner
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Base	EVA	EVA	EVA	EVA	EVA	Thermoplastic Resins	EVA	EVA	EVA	EVA	EVA
Color	White Black Natural Brown	White Natural	White Natural	Clear	Off-White	Light Amber	Clear	Off-White	Light Amber	Light Amber	Clear
Form	Pellets	Pellets	Cartridges	Pellets	Pellets	Pellets	Cartridges	Cartridges	Pellets	Pellets	Pellets
Specific gravity	1.4	1.2	1.2	0.96	0.96	0.99	0.96	0.96	0.98	1.2	0.90
Softening point (°C) ASTM E-28	100-115	98-112	98-112	125-145	125-145	135	125-145	125-145	85-95	85-101	90
Heat resistance (°C) WPS 68	70	70-75	70-75	105-125	105-125	130	80-85	80-85	85	70	-
Melt viscosity cP @ 200 °C approx.	120,000	40,000	40,000	76,000	76,000	35,000	35,000	35,000	35,000 @150 °C	106,000 @150 °C	3,000 @190 °C
Application temp. (°C) (°F)	175-215 347-419	180-200 356-392	180-200 356-392	175-200 347-392	175-200 347-392	175-200 347 392	175-200 347-392	175-200 347-392	140-190 284-374	140-160 284-320	120-130 248-266

A P P L I C A T I O N	EDGEBANDING												
	Solid wood edges	*	**	**	***	***	***	***	***	***	--	***	--
	Veneer	***	***	***	***	***	***	***	***	***	***	***	--
	Primed PVC	***	***	***	***	***	***	***	***	***	***	**	--
	HPL	*	**	**	***	**	***	***	**	***	--	--	--
	Contour edgebanders	--	--	--	--	--	--	--	--	***	***	***	--
	Precoating	--	***	--	--	--	--	--	--	--	***	***	--
	PROFILE WRAPPING												
	Veneer	--	***	**	**	**	***	--	--	**	**	**	--
	Paper foils	--	***	--	--	--	**	--	--	***	**	**	--
	Vinyl foil	--	***	--	--	--	*	--	--	*	**	**	--
	Melamine paper	--	***	--	--	--	**	--	--	**	**	**	--

*** Excellent

** Very Good

* Good

-- Not Suitable