



A Brand like a friend

Henkel KGaA, Standort Bopfingen, 73438 Bopfingen, Deutschland

TO WHOM IT MAY CONCERN

Datum / Date 19 October 2007
Ihre Nachricht /
Your message

Abteilung / Dept. PD/TCS (CY/KW)

Telefon / Phone +49 7362 81 - 191 / Katrin Weinsteiger
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E-Mail / E-mail katrin.weinsteiger@henkel.com

Certificate

Dear Sirs

We supply you with the following

DORUS HKP 21, HKP 25, DORUS KS 201/4, KS 205,
KS 208/2, KS 217, KS 224/2, KS 351, Q 654

We herewith confirm:

1. The above-mentioned products meet the requirements of the valid German and European Union legal position, in particular also the "Directive 2002/95/EC of the European Parliament...."
2. During manufacture of the above-mentioned products, no substances with carcinogenic, teratogenic or mutagenic potential of categories 1 and/or 2 are added. According to the available information we have from the raw material suppliers, they are not present in the original substances used.



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www.dorus.com
www.henkel-technologies.com

Bankverbindungen
Commerzbank AG, Düsseldorf
Konto 1 109 222, BLZ 300 400 00
BIC/SWIFT COBADE33, IBAN
DE08 3004 0000 0110 9222 00

Deutsche Bank AG, Düsseldorf
Konto 2 272 408, BLZ 300 700 10
BIC/SWIFT DEUTDE33, IBAN
DE32 3007 0010 0227 2409 00

Dresdner Bank AG, Düsseldorf
Konto 2 114 562, BLZ 300 800 00
BIC/SWIFT DRESDEFF300, IBAN
DE34 3008 0000 0211 4562 00

USt-IdNr. DE 119 429 301

Kommanditgesellschaft auf Aktien
Sitz Düsseldorf

Handelsregister
AG Düsseldorf HRB 4724

Aufsichtsratsvorsitzender
Dipl.-Ing. Albrecht Woeste

Geschäftsführung
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Dr. Jochen Krautter
(als persönlich haftende
Gesellschafter)

Alois Linder, Kasper Rorsted,
Dr. Friedrich Stara,
Dr. Lothar Steinebach,
Hans Van Bylen



A Brand like a friend

Seite 2 / 2

Moreover, none of these substances are ingredients in the formulation. According to the available information we have from the raw material suppliers, these substances are neither contained in the original substances nor have we added them:

Formaldehyde

Asbestos

Heavy metals such as lead, cadmium, chrome, cobalt, nickel, antimony, arsenic, barium, mercury

Pesticides (DDT and other things) or pyrethroides (in particular permethrin)

Wood preservatives, fungicides, insecticides (in particular lindane)

Flame-proofing agents

Halogenated hydrocarbons and other halogenated compounds

Dioxins and furans

B/T/X aromatic substances

PVC

Yours sincerely

Henkel KGaA



Claudia Yaacoub

Manager Product Development & Applied Technology
EVA and PO Adhesives



Katrin Weinstelger

Export Asia / America



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Alois Lindor, Kasper Rorsted,
Dr. Friedrich Stern,
Dr. Lothar Steinbach,
Hans Van Bylen

AQUENCE DD 060

Known as Dorus DD 060
March 2013

PRODUCT DESCRIPTION

AQUENCE DD 060 provides the following product characteristics:

Technology	PVA Dispersion
Product Type	Dowel Glue
Application	Assembly
Appearance	white transparent after drying

Application Areas

- For automatic knot plugging and dowel insertion
- Suited for pumps with compression ratio of 2 to 1

Product Properties

- Low viscosity
- Good spraying properties
- Long open time
- Fast setting
- Gives transparent, tough-elastic glue joint
- Highest bonding strength with wood and furniture gluing
- Easy cleaning

Technical Data

AQUENCE DD 060:

Minimum film formation temperature, °C (MFFT) DIN 53787	~+3
Viscosity, Brookfield - RVT, 2/20/20, mPa.s ISO 2555	300 to 350
pH value (20 °C) ISO 976	7 to 10

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use

The working temperature of the workpiece and glue should be at least + 10°C.

Surfaces to be bonded must be clean and close fitting

The glue is supplied ready for use. If required, it can be thinned with water up to 3 %.

Cleaning

Equipment used to apply the glue may be cleaned easily using cold or luke-warm water before the adhesive has dried hard. Hard dried glue remnants have to be removed mechanically.

STORAGE

Store in the original tightly closed container in a cool, dry place away from frost.

Stir well before use.

Storage life up to 12 months.

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

ADDITIONAL INFORMATION

Disclaimer

Note:

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TECHNOMELT DORUS HKP 20

Known as Dorus HKP 20

April 2013

PRODUCT DESCRIPTION

TECHNOMELT DORUS HKP 20 provides the following product characteristics:

Technology	EVA
Product Type	Hotmelt Cartridge for HolzHer Edgebander unfilled
Application	Edgebanding
Appearance	Cartridges Transparent

Application Areas

- Edgebanding in HolzHer cartridge equipment as from feedrates of 10 m/min
- Edging material: solid wood, veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*
- Particularly suitable for solid wood

* Suitability depends on the individual characteristics of the edging material and how it is primed.

Product Properties

- Universal hotmelt adhesive
- Fast melting
- Very good wetting
- High glue mileage
- Produces tight joints virtually not visible
- High final bond strength
- Very high heat resistance

Technical Data

TECHNOMELT DORUS HKP 20:

Softening Point, Ring & Ball, °C	~110
Viscosity, Brookfield - 200 °C, mPa.s	~75,000
Heat Resistance, °C	~90
Tested with mm oak veneer using the Henkel method of increasing temperature.	

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use

Working Temperature

Recommended working temperature:
at the application nozzle, °C 200 to 220

Particular in case of long and thick panels a higher processing temperature should be chosen. Sufficient high pressure is to be applied to press the edging material into the hotmelt beads and to obtain an even hotmelt film. If possible, use only straight edges, never twisted or strongly bowed ones. If slightly bowed, insert into magazine so that concave side faces panel. Thin coating with primer e.g. TECHNOMELT PRIMER 183/1 may improve the adhesion of difficult-to-bond edges.

Material and room temperature, °C	≥18
Material moisture, %	8 to 12
Heating time, minutes	2 to 4

Safety

Hotmelt adhesives give off vapours even when the specified working temperature is not exceeded. The smells emitted may often cause irritation. When the specified temperatures are considerably exceeded over a longer period of time, there is the additional danger of decomposition products being given off. Therefore measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment.

STORAGE

Store in the original tightly closed packaging in a cool, dry place.

Shelf life

Shelf-life (in unopened original packaging), years 2

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

ADDITIONAL INFORMATION

Disclaimer

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TECHNOMELT DORUS HKP 21

Known as Dorus HKP 21

April 2013

PRODUCT DESCRIPTION

TECHNOMELT DORUS HKP 21 provides the following product characteristics:

Technology	EVA
Product Type	Hotmelt
Application	Edgebanding
Appearance	Cartridges Natural White Brown Black

Application Areas

- Edgebanding in HolzHer cartridge equipment as from feedrates of 10 m/min
- Edging material: solid wood, veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*

* Suitability depends on the individual characteristics of the edging material and how it is primed.

Product Properties

- Universal hotmelt adhesive
- Fast melting
- Very good wetting

Technical Data

TECHNOMELT DORUS HKP 21:	
Softening Point, Ring & Ball, °C	~108
Viscosity, Brookfield - 200 °C, mPa.s	~87,500
Heat Resistance, °C	~90
Tested with mm oak veneer using the Henkel method of increasing temperature.	

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use

Working Temperature

Recommended working temperature:
at the application nozzle, °C 200 to 220

Particular in case of long and thick panels a higher processing temperature should be chosen. Sufficient high pressure is to be applied to press the edging material into the hotmelt beads and to obtain an even hotmelt film. If possible, use only straight edges, never twisted or strongly bowed ones. If slightly bowed, insert into magazine so that concave side faces panel. Thin coating with primer e.g. TECHNOMELT PRIMER 183/1 may improve the adhesion of difficult-to-bond edges.

Material and room temperature, °C	≥18
Material moisture, %	8 to 12
Heating time, minutes	2 to 4

Safety

Hotmelt adhesives give off vapours even when the specified working temperature is not exceeded. The smells emitted may often cause irritation. When the specified temperatures are considerably exceeded over a longer period of time, there is the additional danger of decomposition products being given off. Therefore measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment.

STORAGE

Store in the original tightly closed packaging in a cool, dry place.

Shelf life

Shelf-life (in unopened original packaging), years 2

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

ADDITIONAL INFORMATION**Disclaimer****Note:**

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TECHNOMELT DORUS HKP 25

Known as Dorus HKP 25

April 2013

PRODUCT DESCRIPTION

TECHNOMELT DORUS HKP 25 provides the following product characteristics:

Technology	EVA
Product Type	Hotmelt
Application	Edgebanding
Appearance	Cartridges Natural White Brown Black

Application Areas

- Edgebanding in HolzHer cartridge equipment as from feedrates of 10 m/min
- Edging material: solid wood, veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*

* Suitability depends on the individual characteristics of the edging material and how it is primed.

Product Properties

- Universal hotmelt adhesive
- Fast melting
- Very good wetting

Technical Data

TECHNOMELT DORUS HKP 25:

Softening Point, Ring & Ball, °C	~108
Viscosity, Brookfield - 200 °C, mPa.s	~55,000
Heat Resistance, °C Tested with mm oak veneer using the Henkel method of increasing temperature.	~90

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use

Working Temperature

Recommended working temperature:
at the application nozzle, °C 200 to 220

Particular in case of long and thick panels a higher processing temperature should be chosen. Sufficient high pressure is to be applied to press the edging material into the hotmelt beads and to obtain an even hotmelt film. If possible, use only straight edges, never twisted or strongly bowed ones. If slightly bowed, insert into magazine so that concave side faces panel. Thin coating with primer e.g. TECHNOMELT PRIMER 183/1 may improve the adhesion of difficult-to-bond edges.

Material and room temperature, °C	≥18
Material moisture, %	8 to 12
Heating time, minutes	2 to 4

Safety

Hotmelt adhesives give off vapours even when the specified working temperature is not exceeded. The smells emitted may often cause irritation. When the specified temperatures are considerably exceeded over a longer period of time, there is the additional danger of decomposition products being given off. Therefore measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment.

STORAGE

Store in the original tightly closed packaging in a cool, dry place.

Shelf life

Shelf-life (in unopened original packaging), years 2

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

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TECHNOMELT KS 201/4

Known as DORUS KS 201/4

April 2013

PRODUCT DESCRIPTION

TECHNOMELT KS 201/4 provides the following product characteristics:

Technology	EVA
Product Type	Hotmelt
Application	Edgebanding
Appearance	Granules Natural White

Application Areas

- Edgebanding as from feedrates of 18 m/min
- Edging material: solid wood, veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*
- Softforming even with difficult-to-bond profiles

* Suitability depends on the individual characteristics of the edging material and how it is primed.

Product Properties

- High viscosity
- Universal hotmelt adhesive
- Very clean working
- Very good wetting
- High adhesion force
- Produces tight joints
- Very high heat resistance
- High glue mileage
- Fast melting, particularly suitable for broad edges and high feedrates

Technical Data

TECHNOMELT KS 201/4:

Softening Point, Ring & Ball, °C	~148
Viscosity, Brookfield - 180 °C, mPa.s	~350,000
Viscosity, Brookfield - 200 °C, mPa.s	~150,000
Heat Resistance, °C	~110
Tested with 0.6 mm oak veneer using the Henkel method of increasing temperature	

DIRECTIONS OF USE

Preliminary Statement

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Instructions for Use

Working Temperature

Recommended working temperature:	
in the melting container, °C	210 to 220
at the application roller, °C	215 to 235

Safety

Hotmelt adhesives give off vapours even when the specified working temperature is not exceeded. The smells emitted may often cause irritation. When the specified temperatures are considerably exceeded over a longer period of time, there is the additional danger of decomposition products being given off. Therefore measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment.

STORAGE

Store in the original tightly closed container in a cool, dry place.

Shelf life

Shelf-life (in unopened original packaging), years 2

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

ADDITIONAL INFORMATION

Disclaimer

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TECHNOMELT KS 205

Known as Dorus KS 205

April 2013

PRODUCT DESCRIPTION

TECHNOMELT KS 205 provides the following product characteristics:

Technology	EVA
Product Type	Hotmelt
Application	Edgebanding
Appearance	Granules Natural White Brown

Application Areas

- Edgebanding as from feedrates of 15 m/min
- Edging material: solid wood, veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*

* Suitability depends on the individual characteristics of the edging material and how it is primed.

Product Properties

- High viscosity
- Universal hotmelt adhesive
- Clean running
- Very good wetting
- Very suitable for thick primed ABS and PVC edges (> 2 mm)
- High final bond strength
- High heat resistance
- High glue mileage

Technical Data

TECHNOMELT KS 205:

Softening Point, Ring & Ball, °C	~120
Viscosity, Brookfield - 180 °C,	~311,000
Viscosity, Brookfield - 200 °C, mPa.s	~155,000
Heat Resistance, °C	~90
Tested with mm oak veneer using the Henkel method of increasing temperature	

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use

Working Temperature

Recommended working temperature:	
in the melting container, °C	200 to 220
at the application roller, °C	~220

Safety

Hotmelt adhesives give off vapours even when the specified working temperature is not exceeded. The smells emitted may often cause irritation. When the specified temperatures are considerably exceeded over a longer period of time, there is the additional danger of decomposition products being given off. Therefore measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment.

STORAGE

Store in the original tightly closed container in a cool, dry place.

Shelf life

Shelf-life (in unopened original packaging), years 2

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

ADDITIONAL INFORMATION

Disclaimer

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TECHNOMELT KS 208/2

Known as DORUS KS 208/2

April 2013

PRODUCT DESCRIPTION

TECHNOMELT KS 208/2 provides the following product characteristics:

Technology	EVA
Product Type	Hotmelt
Application	Edgebanding
Appearance	Granules Natural White Brown Black

Application Areas

- Edgebanding as from feedrates of 15 m/min
- Edging material: veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*, up to approx. 2 mm thickness*

* Suitability depends on the individual characteristics of the edging material and how it is primed.

Product Properties

- Medium viscosity
- Very clean working
- Produces tight joints
- High final bond strength
- High heat resistance

Technical Data

TECHNOMELT KS 208/2:

Softening Point, Ring & Ball, °C ~110

Viscosity, Brookfield - 180 °C, mPa.s ~190,000

Viscosity, Brookfield - 200 °C, mPa.s ~100,000

Heat Resistance, °C ~90

Tested with 0.6 mm oak veneer using the Henkel method of increasing temperature

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use

Working Temperature

Recommended working temperature:
in the melting container, °C 180 to 200
at the application roller, °C ~200

Safety

Hotmelt adhesives give off vapours even when the specified working temperature is not exceeded. The smells emitted may often cause irritation. When the specified temperatures are considerably exceeded over a longer period of time, there is the additional danger of decomposition products being given off. Therefore measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment.

STORAGE

Store in the original tightly closed container in a cool, dry place.

Shelf life

Shelf-life (in unopened original packaging), years 2

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

ADDITIONAL INFORMATION

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TECHNOMELT DORUS KS 217

Known as DORUS KS 217

June 2013

PRODUCT DESCRIPTION

TECHNOMELT DORUS KS 217 provides the following product characteristics:

Technology	EVA
Product Type	Hotmelt
Application	Edgebanding
Appearance	Granules Natural White Brown

Application Areas

- Edgebanding as from feedrates of 12 m/min
- Edging material: solid wood, veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*
- Particularly suitable for solid wood

* Suitability depends on the individual characteristics of the edging material and how it is primed.

Product Properties

- Low viscosity
- Universal hotmelt adhesive
- Very good wetting
- Produces tight joints
- High final bond strength
- High heat resistance
- Can be veneered over
- High glue mileage

Technical Data

TECHNOMELT DORUS KS 217:

Softening Point, Ring & Ball, °C	~105
Viscosity, Brookfield - 180 °C, mPa.s	~100,000
Viscosity, Brookfield - 200 °C, mPa.s	~55,000
Heat Resistance, °C	~90
Tested with 0.6 mm oak veneer using the Henkel method of increasing temperature	

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use

Working Temperature

Recommended working temperature:	
in the melting container, °C	180 to 200
at the application roller, °C	190 to 200

Safety

Hotmelt adhesives give off vapours even when the specified working temperature is not exceeded. The smells emitted may often cause irritation. When the specified temperatures are considerably exceeded over a longer period of time, there is the additional danger of decomposition products being given off. Therefore measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment.

STORAGE

Store in the original tightly closed container in a cool, dry place.

Shelf life

Shelf-life (in unopened original packaging), years 2

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

ADDITIONAL INFORMATION

Disclaimer

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TECHNOMELT KS 224/2

Known as DORUS KS 224/2

August 2013

PRODUCT DESCRIPTION

TECHNOMELT KS 224/2 provides the following product characteristics:

Technology	EVA
Product Type	Hotmelt
Application	Edgebanding
Appearance	Granules natural

Application Areas

- Edgebanding as from feedrates of 10 m/min on throughfeed machines
- Specifically designed for manually operated edgebanders, as from feedrates of 3 m/min
- Edgebanding by applying the adhesive directly to the edging material
- Edging material: veneer, melamine, polyester, PVC*, ABS*, PP* up to approx. 1 mm thickness*

* Suitability depends on the individual characteristics of the edging material and how it is primed.

Product Properties

- Low viscosity
- Low coat weight for flat lamination
- Fast melting
- Very good wetting
- High glue mileage

Technical Data

TECHNOMELT KS 224/2:

Softening Point, Ring & Ball, °C	~85
Viscosity, Brookfield - , 140 °C, mPa.s	~85,000
Viscosity, Brookfield - , 180 °C, mPa.s	~17,000
Heat Resistance, °C	~75
Tested with 0.6 mm oak veneer using the Henkel method of increasing temperature.	

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use

Working Temperature

Recommended working temperature:	
in the melting container, °C	120 to 140
at the application roller, °C	120 to 140

Safety

Hotmelt adhesives give off vapours even when the specified working temperature is not exceeded. The smells emitted may often cause irritation. When the specified temperatures are considerably exceeded over a longer period of time, there is the additional danger of decomposition products being given off. Therefore measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment.

STORAGE

Store in the original tightly closed packaging in a cool, dry place.

Shelf life

Shelf-life (in unopened original packaging), years 2

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

ADDITIONAL INFORMATION

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TECHNOMELT DORUS KS 351

Known as DORUS KS 351
June 2013

PRODUCT DESCRIPTION

TECHNOMELT DORUS KS 351 provides the following product characteristics:

Technology	EVA
Product Type	Unfilled Hotmelt
Application	Edgebanding
Appearance	Granules Transparent White

Application Areas

- Edgebanding as from feedrates of 12 m/min throughfeed machines
- Edging material: solid wood, veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*
- Softforming even with difficult-to-bond profiles
- Suitable for processing centres (BAZ) with direct application

* Suitability depends on the individual characteristics of the edging material and how it is primed.

Product Properties

- Medium viscosity
- Universal hotmelt adhesive
- Very good thermal resistance
- Produces tight joints virtually not visible
- Very high heat resistance
- High glue mileage
- Very good wetting
- Permits smooth surfaces even with very flexible edging materials
- High final bond strength

Technical Data

TECHNOMELT DORUS KS 351:

Softening Point, Ring & Ball, °C	~110
Viscosity, Brookfield - 180 °C, mPa.s	~140,000
Viscosity, Brookfield - 200 °C, mPa.s	~75,000
Heat Resistance, °C	~90
Tested with 0.6 mm oak veneer using the Henkel method of increasing temperature	

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use

Working Temperature

Recommended working temperature:	
in the melting container, °C	180 to 200
at the application roller, °C	190 to 200

Safety

Hotmelt adhesives give off vapours even when the specified working temperature is not exceeded. The smells emitted may often cause irritation. When the specified temperatures are considerably exceeded over a longer period of time, there is the additional danger of decomposition products being given off. Therefore measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment.

STORAGE

Store in the original tightly closed container in a cool, dry place.

Shelf life

Shelf-life (in unopened original packaging), years 2

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

ADDITIONAL INFORMATION

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TECHNOMELT PRIMER 183/1

Known as Dorus ND 183/1
April 2013

PRODUCT DESCRIPTION

TECHNOMELT PRIMER 183/1 provides the following product characteristics:

Technology	Dispersion
Product Type	Primer
Application	Pre-treatment of Edgebanding Material Sprayable
Appearance	PE canisters light

Application Areas

- Solid wood and veneer strips, even of exotic and resin-containing woods
- Laminates like CPL and HPL after pre-testing the suitability
- Not suited for ABS, PVC, etc.

Product Properties

- Low viscosity
- Waterborne, solvent-free synthetic dispersion
- Improves the adhesion to difficult-to-bond woods and laminates significantly

Technical Data

TECHNOMELT PRIMER 183/1:

Viscosity, Brookfield - RVT, 1/20/20, mPas 15 to 20
ISO 2555

pH value 8 to 9.2
(20 °C)
ISO 976

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use

Drying time, hours: ≥1

Application

Application Device:

sponge
brush
spraying gun

Application Weight

Application amount, wet glue: 20 to 30 g/m²

Processing

The primer should be coated as evenly and thinly as possible. Too much primer does not strengthen the bond, but weakens the adhesion and heat resistance.

Attention: Edges primed with TECHNOMELT PRIMER 183/1 can only be edgebanded with EVA hotmelts. Polyolefin and PUR-based hotmelts are not suited.

Cleaning

Equipment used to apply the glue may be cleaned easily using cold or luke-warm water before the adhesive has dried hard. Hard dried glue remnants have to be removed mechanically.

STORAGE

Store in the original tightly closed container in a cool, dry place away from frost.

Stir well before use.

Storage life is up to 9 months.

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

ADDITIONAL INFORMATION**Disclaimer****Note:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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