

TECHNICAL DATA SHEET

TECHNOMELT DORUS HKP 20

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Product Description

TECHNOMELT DORUS HKP 20 is a universal EVA hot-melt adhesive supplied in cartridges for HolzHer edge banding machines.

Applications

- Edge banding speed with HolzHer cartridge: up to 10 m/min.
- Suitable for solid wood, veneer, melamine, polyester, HPL, PVC, ABS and PP edge bands. Suitability depends on substrate characteristics and primer.

Key Properties

- Universal hot-melt adhesive
- Fast melting
- Excellent cross-linking
- High coverage
- Nearly invisible glue line
- High final bond strength
- High heat resistance

Technical Properties

Softening point (Ring & Ball): approx. 110 °C

Viscosity (Brookfield, 200 °C): approx. 75,000 mPa·s

Heat resistance: approx. 90 °C (tested on 0.6 mm oak veneer using the DORUS test method).

Application Instructions

Read the Safety Data Sheet before use. Recommended application temperature at the nozzle: **200–220 °C**. Use the higher temperature for long or thick panels. Apply sufficient pressure to obtain a uniform adhesive film. Intended primarily for straight edges. If edge bands exhibit slight curvature, position the concave side toward the panel. For difficult substrates, use a suitable primer such as DORUS 183/1.

General Conditions

Material and ambient temperature: ≥ 18 °C

Material moisture: 8–12%

Heating time: 2–4 minutes

Safety

Operating above the recommended temperature may generate hazardous decomposition products and irritating vapours. Ensure effective ventilation and extraction.

Storage

Minimum shelf life: 2 years when stored in a cool, dry place.

Product Information

Technology: EVA

Product type: Hot-melt adhesive cartridges for HolzHer edge banders

Application: Edge banding

Appearance: Transparent cartridges

Disclaimer

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