



## Technical Data Sheet of *SINOHESIVE® ME2539D*

### I Product description

- Adhesive type** *SINOHESIVE® ME2539D* is a kind of moisture curing reactive polyurethane hot melt adhesive, special designed for edge banding in woodworking industry.
- Application range**
- Edge Banding for wooden door, custom furniture, etc.
  - Suitable strips include veneer, splint, PVC strips, etc.; and suitable boards include plywood, particleboard, MDF, etc.
- Main Features** As a high-performance polyurethane adhesive *SINOHESIVE® ME2539D* has following main features:
- High initial strength: after coating and pressing, it can have high initial adhesive force immediately, so as to achieve reliable shaping without rebound.
  - It has the appropriate opening time: the bonding strength rises quickly, the waiting time is short, and the production efficiency is high.
  - Excellent weather and chemical resistance: the cured film has excellent heat resistance, cold resistance, water resistance and chemical resistance.
  - Excellent health and safety, No harmful substances.

Physical characteristics	<i>SINOHESIVE ME2539D</i>
Solid content	100%
Component	Polyurethane
Status @ 25°C	Grayish white solid
Viscosity @ 140°C	45,000 — 70,000 mPa.s
Recommended melt temperature	140—150°C
Recommended Coating temperature	130—150°C
Recommended Coating Weight	120—180 g/m <sup>2</sup>
Open time@ 25°C	About 10—20 sec.
Shelf life	(Unopened) 9 months
Package	Standard 5-gallon pail or 55-gallon drum

## II Operating guide

- Open for use**
- Uncover the lid of the drum or pail; straighten the inner foil bag, cut it along the lower edge of the horizontal sealing of the foil bag, then fold it to the outside of the drum or pail and fasten it with sealing tape. Place it under the heat platen of the unloader machine as soon as possible, and press the platen until the platen completely touches the upper surface of the glue, start to run the pump after the glue be melted by the heat platen, until no bubbles be pumped out.
- Preheat**
- The preheating temperature of the glue is recommended to be set between 140 and 150 °C. If the ambient temperature is low or the line speed is fast, set it higher. Otherwise, set it lower. Avoid excessive heating.
- Substrate pretreatment**
- The surface of the substrate used for the bonding part must be clean and dry, so as to ensure that the surface is free of contaminants.
  - Polyolefin materials must be corona treated or oxidatively pretreated. PVC and ABS materials must be pretreated with a suitable cleaning or primer.
  - If the surface temperature of the substrate is lower than 10 °C, it should be properly preheated to 15 °C.
- Operation**
- Melt temperature: 140—150 °C
  - Coating temperature: 130—150 °C
  - Coating Weight : 120—180 g/m<sup>2</sup>
  - Pressing pressure: 3—5 kg/cm<sup>2</sup>
  - Conveying speed: 14—30 m/min
  - After coating, shall not exceed the glue open time.
- Curing**
- In order to achieve full cure, the bonded product should be placed at a suitable temperature (15 °C - 25 °C) and humidity (45% - 85% relative humidity).
  - The curing process will vary with the thickness of the coating, the moisture content of the substrate, the permeability, the ambient temperature and humidity. It is usually fully cured after about 7 days.
- Clean**
- When stop production, it need to use high temperature butter or wax to seal the applicator; If the shutdown time is more than three days, then heat the old glue and clean out; If the machine is shut down for more than one week, it is recommended to use cleaner ZC9103 and ZC9105 to clean the hose and the applicator.



- Spilled and dripped glue should be cleaned with a rag dipped with organic solvent as early as possible before it is cooled and uncured; the glue after curing will be difficult to remove, and can be scraped off with a hard tool or immersed in solvent with strong causticity for a long time.

### **III Storage / Health & Safety /Transport**

#### **Storage**

- In the original container that is not opened, the temperature shall be between  $-30^{\circ}\text{C}$  and  $30^{\circ}\text{C}$ . The shelf life of *SINOHESSIVE*<sup>®</sup> ME2539D is 9 months.
- Once the original container is opened, the unused parts must be carefully sealed, protected by dry air or nitrogen, and used as soon as possible.

#### **Health & Safety**

- *SINOHESSIVE*<sup>®</sup> ME2539D is a polymer with a certain activity. It is recommended not to have long-term direct contact with the skin. In addition, since the polymer will crosslink with moisture in the air to cure, it should be cleaned prior to curing.

#### **Transport**

- Refer to the Material Safety Data Sheet (MSDS) for details.

### **IV Other**

#### **Disclaimer**

- The performance of the glue is a critical factor in the final performance of the product, but it is not the only factor. For example, the strength of the substrate, the moisture content, the grease on the surface, etc. can also affect the strength; the temperature and humidity in the curing environment, the water permeability and the gas permeability of the substrate can affect the curing speed and the appearance of the product. Since the above factors are beyond our control when using our glue products, we cannot guarantee the quality of bonding for each specific final product. We solemnly recommend that before batch production, please select the equipment, substrate and operators, and do tests with our glue products adequately, and determine the next action plan based on the test results, and then gradually enlarge the batch size.



**广东中粘新材料科技有限公司**

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**Technical Support**

- If you need to know more about this product or other products, process, new product development of our company, please contact our technical support team or business team in local.

**URL**

- [www.sino-adhesive.com](http://www.sino-adhesive.com)