

Stick-Onn Hot Melt Adhesive (EVA Granules)

Wood-to-PVC Edge Banding — Manual, Automatic & Spring Pocket

01 PRODUCT DESCRIPTION

A full family of EVA hot melt granules for edge banding of wood to PVC. Ten grades across filled, semi-filled and unfilled types, tuned for manual machines, automatic throughfeed lines and nozzle-spray spring-pocket applications. Colour-matched granules give an invisible glue line against the edge band and substrate.

02 KEY FEATURES

- Instant bonding with strong edge holding
- Filled, semi-filled and unfilled grades
- Softening points from 70°C to 110°C
- Working temperatures from 130°C to 210°C
- Consistent granule quality, batch to batch
- Clean, solvent-free application

03 APPLICATIONS

Manual edge banding machines

Automatic throughfeed edge banders

Spring-pocket nozzle spray

Packaging

04 DIRECTIONS FOR USE

- 1 Select the grade to match your machine type, feed speed and edge band.
- 2 Load clean granules into a clean glue pot; set temperature within the grade's working range.
- 3 Do not exceed 210°C — overheating causes charring, stringing and loss of bond strength.
- 4 Keep panels and edge band at room temperature (above 18°C) to avoid premature set.

05 CLEANING

Purge the glue pot with fresh adhesive or a recommended cleaning granule at working temperature.

06 STORAGE

Store in original bags in a cool, dry place below 35°C, away from direct sunlight. Rotate stock first-in, first-out.

07 TYPICAL TECHNICAL DATA

Type	EVA hot melt granules
Application	Wood to PVC edge banding
Colours	Frosty White · Semi White · Fully White · Semi Yellow · Yellow · Matt Yellow
Softening point	70 – 110°C (grade dependent)
Working temperature	130 – 210°C (grade dependent)
Lines	Manual · Automatic throughfeed · Nozzle spray
Solid content	100% (solvent-free)
Shelf life	12 months from the date of manufacture in original packing.

Values are typical and indicative; not to be used as specification limits.

08 COMPATIBLE SUBSTRATES

Particle board

MDF

Plywood

PVC edge band

ABS edge band

Melamine edge tape

09 PACK SIZES

30 kg bag

10 HEALTH & SAFETY

Read the label and the Material Safety Data Sheet (MSDS) before use. Keep out of reach of children. MSDS available at www.stickonn.in/downloads.

Disclaimer: The information and recommendations in this data sheet are based on our tests and experience and are believed to be reliable. As conditions and methods of use are beyond our control, users should determine the suitability of the product for their purpose before full-scale use. Products are sold subject to the company's standard terms and conditions of sale. Specifications are subject to change without notice.