Union Camp CHEMICAL DIVISION

technical service bulletin

July 24, 1968

Formula 6-14

Product: Hot melt adhesive for furniture

Typical Use: Bonding wood-to-wood, wood-to-coreboard

Formula: Wt. %	Material	Supplier Code
10	Paraflint SH (Fischer-Tropsch wax)	1
13	Aroclor 1254 (chlorinated polyphenyl)	2
12	Aroclor 5460 (" ")	2
30	Elvax 150 (E/VA copolymer)	3
0.2	Butylated hydroxytoluene (antioxidant)	4
35	UNIREZ 9002 (modified phenolic resin)	5

Procedure: Melt wax and Aroclor plasticizers to about 375°F. Mix in BHT. Add Elvax in small portions and mix until each is completely dissolved. Stir in UNIREZ 9002 while reducing temperature to about 350°F. Hold at 350°F. until well blended.

Properties:

Ring & Ball softening point	- 228°F.
Brookfield viscosity (Model LVT No. 3 spindle, 12 rpm)	- 5700 cps.
Color, 25% in toluene at 70°C., ASTM D1544	- 6+
Oven peel temperature*	- 160°F.

Supplier Code:

1. Moore & Munger, Inc.
2. Monsanto Chemical Co.
3. E. I. duPont de Nemours & Co.
4. Eastman Chemical Products, Inc.
5. Union Camp Corp., Chemical Division

* Temperature at which kraft-to-kraft bond fails when loaded at 160 g/inch bond width

DSW 586726

The formulae and statements herein are accurate to the best of our knowledge. However, since application in the user's plant is under conditions beyond our control, suggestions and recommendations are made without warranty or guarantee of any kind. Nothing contained herein shall be construed as a recommendation to use any product or process in conflict with existing patents covering any material or its use.

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