



TECHNICAL DATA SHEET

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Kimbond 2444

Woodworking Hot Melt Adhesive

Product Description

Kimbond 2444 is a light yellow colored, unfilled; EVA based woodworking hot melt adhesive. It's recommended for edgebanding of different edges such as plastics materials (like PVC, ABS, PP, polyester and etc.), melamine paper and wood veneer. Kimbond 2444 features transparent and neutral appearance, so it's especially used in edgebanding process when there is a continues change of edgeband colors. It can also be used in softforming applications of bent or shaped profiles.

General Properties

Type	• Woodworking hot melt adhesive
Appearance	• Transparent light yellow
Forms	• Pellets
Features	• High adhesion • Very high hot tack • High heat stability • Very good remelting properties • Long open time • Non surface soiling and non-stringing
Uses	• Automatic edgebanding
Odor	• Slight resinous molten
Packaging	• 25 Kg PE Bag

Physical Properties	Nominal Value Unit	Test Method
Viscosity @ 200 °C	40,000-60,000 cP	ASTM D3236
Ring & Ball Softening Point	80-95 °C	ASTM E28
Open Time @ 200 °C	40-60 sec	ASTM D4497
Specific Gravity	0.9±0.05 gr/cm ³	ASTM D792
Tensile lap shear strength	≥3 MPa	ISO 4587
Working speed	20-30 m/min	-
Heat Stability	High	ASTM D4499

Storage and Handling

Kimbond 2444 should be stored in a cool dry place between 5-30°C, away from sources of heat and direct sunlight. Keep product and hot melt units covered to avoid contamination. It must be stored away from any solvents or chemicals. Do not mix with other adhesives.

Safety and Health

Kimbond 2444 is solid at room temperature, so it's not dangerous for handing at these conditions. When it's molten, for protection from burns, wear gloves and a long sleeved shirt during operation. For eyes protection, wear safety glasses. If the burns were occurred, first flush the affected area with large amount of cold water, do not remove adhesive, and then seek for medication immediately.

Shelf life

Best used within 24 months from date of manufacture when stored under the above conditions.

Operating Conditions

The recommended running temperature range is 190-210 °C (370-410°F). Kimbond 2444 is used in automatic edgebanding machines with roller and spray nozzle applicators with low to medium speed running, as well as, applied by machines for precoating edges. The substrates have to be processed at exactly right angles and must be dry and free from dust or other foreign matter. The cleaning up methods are using of heat, scraper, mineral oil or paraffin.

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