



DANMELTTHANE® PES-680-G

DESCRIPTION

DANMELTTHANE® PES-680-G is a saturated copolyester adhesive. It is specially used for the bonding of filters. DANMELTTHANE® PES-680-G distinguishes itself by a high melting point and an optimal melting viscosity for the bonding of filters. Films of DANMELTTHANE® PES-680-G are very flexible and extremely break resistant. When cutting the bonded filter elements, the tools are not being contaminated by the glue line of DANMELTTHANE® PES-680-G.

PRODUCT CHARACTERISTIC

| | Values | Method |
|---|-----------------------------------|----------------|
| Type | Saturated thermoplastic polyester | |
| Aspect/supply form | Granulate | |
| Melting viscosity | 25.000 - 35.000 mPa.s. at 232 °C | BROOKFIELD RVT |
| Melting point | 210 – 220 °C | |
| Processing temperature | 220 – 240 °C | |
| Specific weight | 1,20 g/cm ³ | |
| Open time | Up to 10 seconds | |
| Polymerisation temperature during the at process of filter production | Maximum of 185 °C | |

APPLICATION

DANMELTTHANE® PES-680-G makes it possible to do the folding and the joining of filter web papers before and/or after the impregnation with phenol resin and/or the polymerisation. The polymerisation temperature is supposed to be between 170 °C and 180 °C. DANMELTTHANE® PES-680-G is qualified for the filter bonding of automobile, air, industrial, household, protection, dirt, dust and medical filters.

PROCESSING

DANMELTTHANE® PES-680-G can be processed without any problems known to us on all common melting devices and melting extruders. The stability of DANMELTTHANE® PES-680-G in the melt is excellent. There is no danger of an oxidative damage by oxygen if the usual processing time and processing temperature are adhered to.

COMPATIBILITY

DANMELTTHANE® PES-680-G can be mixed with any common polyester hot melt adhesive of the DANMELTTHANE® PES-line and in any proportion. Under certain conditions, blends with thermoplastic polyurethane and polycaprolactone raw materials (PEARLSTICK®) are possible. We recommend to make tests in advance.



STORAGE

If correctly stored in a dry place at room temperature and in its original packing, this product can be stored 6 months at least. A humid product can lead to embrittlement of the adhesive film during the later adhesive processing.

PRODUCT SAFETY

Under normal hygienic working conditions, DANMELTTHANE® PES-680-G is a largely non dangerous material. Please note that polyester granulates might cause an electrostatic spark emission. If larger quantities of DANMELTTHANE PES®-680-G are processed in the hot melt, a good extraction of the melt fumes must be ensured.

* For further data, please refer to our Safety Data Sheet

PHYSIOLOGICAL CHARACTERISTICS

According to recommendations of the BGA (Bundesgesundheitsamt) and FDA (FOOD and DRUG ADMINISTRATION) DANMELTTHANE® PES-680-G may be used for the bonding of food wrappings. It is important to observe the conditions mentioned in the recommendations.

PACKAGING

25 kg multi foil paper bags on 500 kg or 1.000 kg pallets.



DANQUINSA
GMBH

STÖRRENSTR.30
72135 DETTENHAUSEN
GERMANY

: +49 (0)7157 5225-0

: +49 (0)7157 5225-22

: info@danquinsa.com

WWW.DANQUINSA.COM

Post office box 147
72133 DETTENHAUSEN
GERMANY

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