

# **ROMABOND<sup>®</sup>**

## **INDUSTRIAL ADHESIVES** *PROFESSIONAL BONDING SOLUTIONS*



**ROMABOND<sup>®</sup>**



[www.romabond.com](http://www.romabond.com)



## → INDUSTRIAL ADHESIVES

Roma has been selling furniture adhesives since the first day it was founded. Starting only with edgebanding and laminate adhesives in the early years, Roma today has expanded its adhesive portfolio to cater all the requirements of the furniture industry.

The adhesive preferences of the manufacturer has a direct impact on product quality and cost of the final furniture. Being well aware of this reality, Roma evaluated our business partners' machinery and needs, determined the best suited products and made them available for the industry. Additionally, with the vision of making a difference in a highly competitive market, Roma is providing comprehensive solutions with a wide range of adhesive products, application trainings and after sales technical support services.

For industrial adhesives, Roma is addressing the market's requirements with two different brands on three main categories:

- EVA-Based Adhesives
- Water-Based Adhesives
- Solvent-Based Adhesives



**ROMABOND**<sup>®</sup>

ROMABOND has derived from our vision to meet the requirements of our industry and has been an essential brand since the first day Roma Plastik was established. Today ROMABOND Industrial Adhesives offer a comprehensive product portfolio specialized on diverse bonding applications and in widespread use in the furniture industry.



**mak**<sup>®</sup>  
by HB Fuller

MAK is an exclusive brand of H.B. Fuller. The USA based company was founded by Harvey Fuller in 1887 and today is a global leader in adhesive technology. By embracing solution oriented and innovative thinking as its core value, H.B. Fuller has paved the way for adhesives to improve products and lives across the globe.

## → EVA-BASED ADHESIVES (HOT-MELT)

Hot-melt adhesives are used for bonding all kinds of PVC, ABS, PMMA, Melamine and Veneer edgebands to carrier materials like chipboards, MFC or MDF panels.

### Adhesives for Straight Edgebanding



#### MAKTHERM 07

High viscosity adhesive producing good results under all weather conditions and suitable for straight edgebanding. The glue line is minimized on high speed edgebanding machines.

##### Technical Specifications:

- Glue pot-Roller temperature: 190-210 °C
- Feed speed: minimum 20 m/min.
- Application amount: 250-300 g/m<sup>2</sup>
- Colour: natural, white
- Packaging: 25 kg



#### MAKTHERM 07 LS

Recommended for straight edgebanding on low speed machinery. Produces good results under all weather conditions.

##### Technical Specifications:

- Glue pot-Roller temperature: 190-210 °C
- Feed speed: minimum 12 m/min.
- Application amount: 250-300 g/m<sup>2</sup>
- Colour: natural
- Packaging: 25 kg



#### MAKTHERM 26

A very strong adhesive with low amount of fillers. Shows high performance mainly on MDF and veneer applications, recommended for straight edgebanding.

##### Technical Specifications:

- Glue pot-Roller temperature: 180-200 °C
- Feed speed: minimum 10 m/min.
- Application amount: 120-170 g/m<sup>2</sup>
- Colour: transparent
- Packaging: 20 kg

#### MAKTHERM 50 (Cartridge Adhesive)

Recommended for straight edgebanding with Holz-Her branded machines only.

##### Technical Specifications:

- Glue pot-Roller temperature: 170-190 °C
- Feed speed: minimum 15 m/min.
- Application amount: 250-300 g/m<sup>2</sup>
- Colour: natural
- Packaging: 15 kg

## Adhesives for Straight Edgebanding



### MAK THERM 85

Recommended for soft-forming applications. Has strong bonding characteristics under all weather conditions.

#### Technical Specifications:

- Glue pot-Roller temperature: 190-210 °C
- Feed speed: minimum 20 m/min.
- Application amount: 250-300 g/m<sup>2</sup>
- Colour: natural
- Packaging: 25 kg



### MAK THERM 5724

A very strong adhesive with low amount of fillers. Recommended for both straight and curved edgebanding, especially for 1.00 mm and thicker edgebands.

#### Technical Specifications:

- Glue pot-Roller temperature: 190-210 °C
- Feed speed: minimum 10 m/min.
- Application amount: 150-200 g/m<sup>2</sup>
- Colour: transparent
- Packaging: 20 kg



### ROMABOND 1001

A competitively priced basic adhesive recommended for all straight edgebanding applications.

#### Technical Specifications:

- Glue pot-Roller temperature: 180-200 °C
- Feed speed: minimum 10 m/min.
- Application amount: 300-350 g/m<sup>2</sup>
- Colour: natural, black, brown, white
- Packaging: 25 kg



### ROMABOND 1002

Recommended for straight edgebanding on both high and low speed machinery. Produces good results under all weather conditions.

#### Technical Specifications:

- Glue pot-Roller temperature: 180-200 °C
- Feed speed: minimum 10 m/min.
- Application amount: 250-300 g/m<sup>2</sup>
- Colour: natural, black, brown, white
- Packaging: 25 kg



### ROMABOND 1003

A general purpose adhesive with very strong bonding characteristics and recommended for straight edgebanding. Produces good results under all weather conditions.

#### Technical Specifications:

- Glue pot-Roller temperature: 180-200 °C
- Feed speed: minimum 10 m/min.
- Application amount: 250-300 g/m<sup>2</sup>
- Colour: natural, black, brown, white
- Packaging: 25 kg



### ROMABOND 1034

A strong adhesive, recommended for all types of edgebanding applications on high speed machinery.

#### Technical Specifications:

- Glue pot-Roller temperature: 180-200 °C
- Feed speed: minimum 15 m/min.
- Application amount: 200-250 g/m<sup>2</sup>
- Colour: natural
- Packaging: 25 kg



### ROMABOND 1051

A strong adhesive with polyolefin base, recommended for all types of edgebanding applications on high speed machinery.

#### Technical Specifications:

- Glue pot-Roller temperature: 180-200 °C
- Feed speed: minimum 15 m/min.
- Application amount: 200-250 g/m<sup>2</sup>
- Colour: natural
- Packaging: 25 kg



### ROMABOND 1052

A very strong adhesive with low amount of fillers. Recommended for both straight and curved edges, especially for 1.00 mm and thicker edgebanding applications.

#### Technical Specifications:

- Glue pot-Roller temperature: 180-200 °C
- Feed speed: minimum 15 m/min.
- Application amount: 150-200 g/m<sup>2</sup>
- Colour: transparent
- Packaging: 20 kg

## Adhesives for Curved Edgebanding



### MAK THERM 5707

Recommended for bonding curved edges, mainly for low speed, hand-operated machinery.

#### Technical Specifications:

- Glue pot-Roller temperature: 150-170 °C
- Feed speed: minimum 5 m/min.
- Application amount: 300-350 g/m<sup>2</sup>
- Colour: natural
- Packaging: 25 kg



### MAK THERM 5724

A very strong adhesive with low amount of fillers. Recommended for both straight and curved edgebanding, especially for 1.00 mm and thicker edgebands.

#### Technical Specifications:

- Glue pot-Roller temperature: 190-210 °C
- Feed speed: minimum 10 m/min.
- Application amount: 150-200 g/m<sup>2</sup>
- Colour: transparent
- Packaging: 20 kg



### ROMABOND 1004

Recommended for bonding curved edges, especially 0.40 mm edgebands.

#### Technical Specifications:

- Glue pot-Roller temperature: 120-150 °C
- Feed speed: minimum 5 m/min.
- Application amount: 300-350 g/m<sup>2</sup>
- Colour: natural
- Packaging: 20 kg



### ROMABOND 1052

A very strong adhesive with low amount of fillers. Recommended for both straight and curved edges, especially for 1.00 mm and thicker edgebanding applications.

#### Technical Specifications:

- Glue pot-Roller temperature: 180-200 °C
- Feed speed: minimum 15 m/min.
- Application amount: 150-200 g/m<sup>2</sup>
- Colour: transparent
- Packaging: 20 kg

## Adhesives for Wrapping Foils & Sills



### MAKTHERM 62

A polyolefin based adhesive with no fillers. Recommended for profile wrapping machines, bonding PP, laminate and veneers. Endures high temperatures, solvent-based paints and varnishes.

#### Technical Specifications:

- Glue pot-Roller temperature: 160-210 °C
- Feed speed: minimum 15 m/min.
- Application amount: 60-150 g/m<sup>2</sup>
- Colour: transparent
- Packaging: 20 kg

### MAKTHERM 26

Shows high performance on sill applications. Please see details on page 3.



### ROMABOND 1051

A strong adhesive with polyolefin base. Shows high performance on sills. Recommended for all types of edgebanding applications on high speed machinery.

#### Technical Specifications:

- Glue pot-Roller temperature: 180-200 °C
- Feed speed: minimum 15 m/min.
- Application amount: 200-250 g/m<sup>2</sup>
- Colour: natural
- Packaging: 25 kg

## Eva-Based Adhesives: Application and Storage Suggestions

#### Ambient Temperature:

*Problems with Hot-melt adhesives are generally experienced in cold weather. As the ambient temperature drops, the performance of the adhesive starts to decrease. When the temperature goes below 0 °C, the performance of the adhesive deteriorates dramatically. In order to overcome this problem, it is suggested that;*

- A heater fan is placed to the feeding point of the edgebanding machine.
- Edgebands and boards are kept in a warmer storage area.
- The temperature in the edgebanding machines' glue pot and rollers are increased by another 15-20 °C.

*The suggestions mentioned above do not guarantee 100% positive results. The main goal is to provide 20 °C ambient temperature at the working environment. Adhesives' viscosity starts to decrease as the ambient temperature rises to 30 °C or above. As a practical solution, it is recommended to cool the pot and the roller down by 10-15 °C. As a result, the ideal viscosity of the adhesive can be restored during the application.*

#### Glue Pot Temperature:

*The desired level of bonding cannot be achieved if the adhesive doesn't adequately melt. The main reason for this problem is the malfunctioning of the heaters in the glue pot. In such a case, the actual temperature is far lower than the temperature read on the glue pot's thermostats. To be certain, it is recommended to measure the temperature of the adhesive inside the pot with a separate thermometer. Faulty heaters should be replaced with new ones to overcome the problem.*

#### Shelf Life:

*Hot-melt adhesives have a 12 months shelf life. Under the right storage conditions, this period can be extended up to 3-4 years.*

## → WATER-BASED ADHESIVES

### Wood Bonding & Press Adhesives



#### MAKCOL 3M / HARDENER 3

D3 norm adhesive, used for bonding outdoor wooden materials like windows or garden furnitures. To reach the norm D4, Hardener 3 has to be added at a 5% ratio. Bonded parts are water and moisture resistant.

##### Packaging Details:

- Packaging: Makcol 3M - 20 kg / Hardener 3 - 1 kg



#### ROMABOND 120 (Laminate Surface Adhesive)

Water-based adhesive with strong bonding characteristics and used for bonding laminates on carrier materials like chipboards, MFC or MDF panels. Applied by a hand roller or rolling cylinder. Can be used on cold and hot presses. Recommended pressing time is 3 minutes at a temperature of 80 °C. It is possible to prolong the pressing time by lowering the temperature.

##### Packaging Details:

- Packaging: 30 kg



#### ROMABOND 220 (Solid Wood Adhesive)

Solid wood adhesive, used for applications like bonding of veneer, MFC, MDF and other wood products. Bonding time is long but once cured, the pieces have high resistance to impact, high temperature etc. and will not unseal. Can be used on both cold and hot presses.

##### Packaging Details:

- Colour: white, pink
- Packaging: 30 kg



#### ROMABOND 420 (Montage Adhesive)

D2 norm, strong and fast drying adhesive which turns transparent after curing. Perfect results are obtained bonding all kinds of wooden materials, carrier materials like chipboards, MFC and MDF to each other or other wooden pieces.

##### Packaging Details:

- Packaging: 10 kg, 30 kg and 50 kg





### ROMABOND 853

D3 norm adhesive, used for bonding outdoor wooden materials like windows or garden furnitures. To reach the norm D4, Hardener 3 has to be added at a 5% ratio. Bonded parts are water and moisture resistant.

#### Packaging Details:

- Packaging: Romabond 853 - 30 kg / Hardener 3 - 1 kg

### Water-Based Adhesives: Application and Storage Suggestions

- Storing the adhesives in extreme high or low temperatures is not recommended.
- For optimal storage, maintain products at a temperature between 15 °C to 20 °C, in a dry place, on pallets and away from direct sunlight.
- Adhesive containers should be kept closed when not actually in use.
- In case of high viscosity, water can be added to dilute the adhesives based on the usage purposes. Note that adding water will lessen the bonding strength.
- Water-based adhesives have a 6 months shelf life. Under the right storage conditions, this period can be extended up to 12 months.

## Membrane Press Adhesive



### ROMABOND PLUS

Single-component adhesive. Suitable for bonding PVC foils on MDF panels, mainly for membrane and vacuum press applications. Applied with a spray gun onto the MDF.

#### Packaging Details:

- Packaging: 25 kg

## Natural Veneer Adhesive - Powder Urea



### AKZO NOBEL 1312

Urea based, E1 norm adhesive in powder form. Suitable for pressing natural veneer onto chipboards or MDF panels. The solution should be prepared by mixing 2 kg adhesive with 1 liter of water.

#### Packaging Details:

- Packaging: 25 kg

## 10 → SOLVENT-BASED ADHESIVES

### Laminate Adhesives



#### **ALFAPREN SC 5106 (Contact Adhesive)**

Solvent-based adhesive, used for bonding laminates during post-forming applications. Drying time is between 5-20 minutes depending on the ambient temperature. Should be used with a spray gun having a nozzle diameter of 1.80 mm.

#### **Packaging Details:**

- Colour: red, transparent
- Packaging: 25 l and 200 l



#### **EUROBOND (Contact Adhesive)**

Heat-resistant, solvent-based contact adhesive that can be applied with a spray gun. Suitable for the bonding of decorative plastic laminates on boards or metals as well as bonding of kitchen and bathroom worktops. Can be used for veneer bonding and is ideal for post-forming applications.

#### **Packaging Details:**

- Colour: red, transparent
- Packaging: 19 l



#### **ROMABOND 019 (Contact Adhesive)**

Heat-resistant, solvent-based contact adhesive that can be applied with a spray gun. Suitable for the bonding of decorative plastic laminates on boards or metals as well as bonding of kitchen and bathroom worktops. Can be used for veneer bonding and is ideal for post-forming applications.

#### **Packaging Details:**

- Colour: red, transparent
- Packaging: 19 l

## Profile Wrapping Adhesive



### ROMABOND 5416

A double-component adhesive, extensively used in profile wrapping on MDF. Hardener 5 has to be added at a 4% ratio before the application process.

#### Packaging Details:

- Packaging: Romabond 5416 - 25 kg / Hardener 5 - 1 kg

### Solvent-Based Adhesives: Application and Storage Suggestions

- Storing the adhesives in extreme high or low temperatures is not recommended.
- For optimal storage, maintain products at a temperature between 15 °C to 20 °C, on pallets.
- Adhesive containers should be kept firmly closed when not actually in use.
- It is recommended that contact adhesives are applied with a 1.80 mm glue gun.
- The adhesives should not be diluted with thinner.
- Solvent-based adhesives have a 6 months shelf life. Under the right storage conditions, this period can be extended up to 12 months.



Industrial Adhesives product range

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[www.egger.com](http://www.egger.com)

**EGGER Dekor A.Ş.**  
Gebze Plastikçiler OSB,  
41400 Gebze/Kocaeli,  
Turkey  
**T** +0262 648 45 00  
**F** +0262 648 45 01  
info-tr@egger.com

[www.romabant.com](http://www.romabant.com)