

Test Report AQUA-STOP-PEN



Nr.: _____

Person responsible: _____

Test lab: SURTECO Technical Centre

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Test description: Sealing of glue lines by the use of AQUA-STOP-PEN

Aims:

To protect furniture in moisture sensitive areas effectively, Döllken has launched on the market an innovative system solution – the AQUA-STOP-PEN. In this instance, the AQUA-STOP-PEN was tested in conjunction with conventional edgeband application to seal the joints.

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Production of test specimen

Machine Parameters:

Machine/Type: _____

Processing speed: v = _____ m/min

Adhesion:

Glue roller

- Ribbed applicator: 1,6 mm
 Ribbed applicator: 1,1 mm

Pressure setting

- 1x Main pressure roller
6x Secondary Pressure rollers

Infrared heater (3,2 kW)

- on
 off

Panel material:

MFC Chipboard

MDF

Hot melt adhesive:

Type: _____ Temperature: _____

Panel joint milling:

Capping saw:

Edgeband flush milling:

Glue joint-flat scraper unit:

Test procedure

1. Using the same production process and parameters, a Döllken edgeband was applied to six directly coated chipboards.
2. The joint area of three panels was sealed with AQUA-STOP-PEN and then dried at room temperature.
3. Afterwards, all six panels were put with the narrow surface into a water-filled container for 24 hours.
4. Subsequent evaluation of the results.

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Components without AQUA-STOP-PEN



- Even after a few hours in the water a considerable swelling in the joint area is recognisable.
- The panel is irreversibly damaged.

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Components with AQUA-STOP-PEN sealing



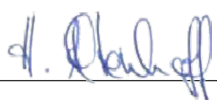
- After 24 hours in the water there was **no** noticeable swelling in the protected joint area.
- The furniture component remains **free** any damage.
- Further tests show that higher loads are possible.

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Final Assessment

- Components which were not sealed with the AQUA-STOP-PEN show along the entire longitudinal edge swelling of the panel thickness of approx. 2 mm.
- Components sealed **with** the AQUA-STOP-PEN show **no** swelling.
- Thus, the effectiveness of the AQUA-STOP-PEN even in extreme conditions was successfully demonstrated.
- The results depend on the manufacturing conditions of the panel components and the materials used.

The above demonstration and our application-technical advice in spoken and written are based on our experiences and are made to the best of our knowledge and belief, however, they must be regarded as non-binding information without guarantee. Otherwise, current general terms of business, delivery and payment of Döllken-Kunststoffverarbeitung GmbH apply.



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