



packaging **case-carton-sealing**

# hot melt adhesives

for **end-of-line**  
**packaging** applications

**Experience performance** from  
our **hot melt adhesives** for '**end  
of line**' packaging application

○ waxes adhesives coatings

 **paramelt**  
experience. performance.

PRODUCT CHARACTERISTICS	EVA- BASED	EBA- BASED	METALLOCENE
	Wetting	■	■
Thermal Stability	■	■	■
Consumption	■	■	■
Polymer Compatibility	■	■	■
Gap Filling Properties	■	■	■
Hot Tack	■	■	■
Specific Adhesion	■	■	■
Low Temp Flexibility	■	■	■
Heat Resistance	■	■	■

PRODUCT SELECTION FIRST CHOICE	PLASTOMELT 9473	PLASTOMELT 320	EXCELTA 844
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APPLICATION REQUIREMENTS			
Deep Freeze	Plastomelt 9066	Plastomelt 323	All Exceltas
Adhesion Boost	Plastomelt 8684	All EBA-grades	Excelta 860/861/864
Heat Resistance	Plastomelt 9511/9457	Plastomelt 320/340	Excelta 804 plus
Sift Proof Applications	Plastomelt 9799	Plastomelt 322	Excelta LM 2/861
Low Odour	Plastomelt 8453	Plastomelt 300	All Exceltas

MACHINE REQUIREMENTS			
Long Open Time	Plastomelt 8684	Plastomelt 323	Excelta 860/864
Fast Setting	Plastomelt 9511/9457	Plastomelt 320/340	Excelta 844/804
Low Viscosity	Plastomelt 9799	Plastomelt 322	Excelta LM 2/861
Low Application Temperature	Plastomelt 9799	Plastomelt 322	Excelta LM 2/861
High Hot Tack	Plastomelt 9511/9457	Plastomelt 320/340	Excelta 804/804 plus/860/864

PLASTOMELT EVA-BASED							
Product	Brief description	Viscosity @ 160°C (mPa.s)	Softening Point Mettler	Open time	Setting speed	Colour	Application Temperature (°C)
8453	Lowest viscosity white EVA packaging hot melt for folding boxes, (wrap-around) cases and cartons.	1050	95-105	short	short	white	140-175
9679	Medium viscosity white EVA packaging hot melt for folding boxes, (wrap-around) cases and cartons.	1250	105-115	short	fast	white	150-180
9473	Standard grade for folding boxes, cases and cartons.	1250	105-115	medium	fast	light yellow	150-180
9511	Medium viscosity grade for fruit trays, cases and cartons. High hot tack.	1500	110-120	short	fast	light yellow	150-175
8684	Medium viscosity grade for cases and cartons and corrugated fruit trays, longer open time.	1500	107-117	short/medium	fast	light yellow	150-170
9799	Low viscous standard packaging grade with good freeze-stability and good adhesion on coated substrates.	900	102-112	medium	medium	light yellow	150-180
9066	Standard grade for deepfreeze, also suitable for folding boxes, cases and cartons, good on coated substrates.	1250	76-86	medium	medium	light yellow	150-180
9457	Highest viscosity grade for cases and cartons and (heavy) corrugated fruit trays.	1850	105-115	short	fast	light amber	165-180

PLASTOMELT EBA-BASED							
Product	Brief description	Viscosity @ 160°C (mPa.s)	Softening Point Mettler	Open time	Setting speed	Colour	Application Temperature (°C)
300	White, standard packaging hot melt for folding boxes, (wrap-around) cases and cartons.	1550	110-120	short	fast	white	150-180
320	Standard grade for folding boxes, (wrap-around) cases and cartons.	1600	107-117	short	fast	light yellow	150-180
321	Low viscous grade for light trays, cases and cartons.	1250	104-114	short	fast	light yellow	150-180
322	Low viscous packaging grade with good freeze-stability and good adhesion on coated substrates.	1000	90-100	short	fast	light yellow	150-180
323	Most flexible deepfreeze-grade. Also suitable for folding boxes, cases and cartons, good on coated substrates.	1350	79-89	medium	fast	light yellow	150-180
340	High viscosity grade for cases and cartons and heavy corrugated fruit trays.	2050	108-118	short	fast	light amber	165-180

EXCELTA METALLOCENE							
Product	Brief description	Viscosity @ 160°C (mPa.s)	Softening Point Mettler	Open time	Setting speed	Colour	Application Temperature (°C)
844	Medium viscosity grade for various packaging applications.	1400	110-120	short	fast	white	160-185
804	High viscosity grade. Recommended for tray forming.	2700	105-115	short	fast	white	160-185
804 plus	Higher heat resistance than standard 804.	2700	110-120	short	fast	white	170-185
831	Deep/Blast freeze.	1200	105-115	short	fast	white	160-185
LM 2	Low Melt standard grade.	1800 (130°C)	88-98	medium	fast	white	120-160
860	High hot tack.	2550	105-115	long	fast	white	160-190
861	Low viscosity grade, adhesion boost.	650	105-115	medium	fast	white	130-180
864	Hot tack, adhesion boost.	2000	107-117	medium	fast	off-white	150-180



## We are **Paramelt**

Founded in 1898, Paramelt has over 125 years of experience and today is a global producer of wax blends, adhesives and specialty dispersions. Operating from production sites in The Netherlands, United Kingdom, the USA and China we work together in a team of about 500 employees around the world. In most of our core applications Paramelt is the acknowledged market leader.

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