

## Technical data sheet

**A10158.1 - slugs**      **A20158.1 - sticks**  
**A30158.1 - sticks**      **A40158.1 - granular**

BÜHNEN GmbH & Co. KG  
Hinterm Sielhof 25  
28277 Bremen · Germany

Telefon +49 (0)421 51 20 - 125  
Telefon +49 (0)421 51 20 - 260  
www.buehnen.de

### HOT MELT

**Part numbers:** A110158.1 - slugs  
A210158.1 - sticks  
A310158.1 - sticks  
A410158.1 - granular

**APPLICATORS:** HB 220, HB 230  
HB 320, HB 350,  
HB 700-serie  
HB Bulk Systems

### APPLICATIONS

Virtually universal hot melt for installation work and for producing permanent bonds in industry and work-shops.

### PROPERTIES

The hot melt has a good elasticity with an excellent flexibility at low temperature. It processes good bonding properties to many materials: Metals, wood, ceramics, fabrics, paper, cardboard products, plastics such as PS, ABS, rigid-PVC, acrylic, PC, leather. The raw material components are registered in FDA 175.105 for the packing of food.

### DESCRIPTION

**Type** : Hot melt adhesive based on ethylene vinyl acetate copolymer

**Colour** : white

**Composition** : The components of this hot melt adhesive are classified as completely harmless. There is thus no need for special labelling of this product in compliance with German regulations for dangerous materials.

### TECHNICAL DATA

**Softening point** : approx. 85 °C Ring and Ball

**Heat resistance** : approx. 60 °C (WPS 68, shearload 100 g/cm<sup>2</sup>)

**Viscosity** : approx. 10000 mPas at 180 °C (Brookfield)

**Specific gravity** : approx. 0.98 g/cm<sup>3</sup>

**Solids content** : 100%

**Working temperature** : 170-210 °C

**Open time** : approx. 50 s, depending on material and quantity of adhesive applied (strip shaped application, dia. 3 mm, 180 °C, material strip (thickness 4 mm).

**Setting time** : approx. 45 s, depending on insulating effect of materials to be bonded and on application method and kind of material (see above open time).

**Size** : sticks - dia. approx. 11.3 mm, length approx. 200 mm  
sticks - dia. approx. 18.3 mm, length approx. 300 mm  
granular - loose charged

When applying the hot melt by spray melt systems the value of the open time is reduced.

### PACKAGING

sticks (20158) - 5 x 2-kg in 10-kg-pack, sticks (30158) - 4 x 2.5 kg in 10-kg-pack, granular (40158) - 25-kg-sack

Slight variation in the colour of the adhesive is normal and should not be seen as a quality problem.

### STORAGE

Minimum two year shelf life under normal indoor conditions and when stored in the original packaging. Exposure to heat (direct sunlight) should be avoided at all costs to prevent possible damage, distortion or degradation of the adhesive.

### APPLICATION

The surfaces to be bonded must be free of dust, dirt, moisture, grease, release agents. Attention: Plastic- and paint-materials containing plasticizers may destroy bond strength.

Apply adhesive as a spot, continuous strip or bead respectively spray a layer of sufficient thickness and join the parts together immediately. Short-time pressure will increase the bond strength.

### SPECIAL NOTES

The safety and operating instructions for the applicator must be observed! Attention: Hot! The molten adhesive and the nozzle of the gun can reach temperatures which may cause skin burns if accidentally touched. In such cases submerge the affected area in cold water immediately. Do not try to remove the adhesive and seek proper medical attention.

Even when using the hot melt within the correct temperature range a slight fume is produced. If the working temperature is exceeded these fumes may result in the irritation of mucous-membranes in sensitive people. A preventive ventilation should exist.

With the vapor of the hot melt adhesive 0158 a slight quantity of acitic acid is released.

### REMARKS

The details in our instruction sheets and other publications are provided to the best of our knowledge. Their contents are not, however, legally binding. In all cases, we recommend that preliminary tests are carried out by the customer. In all other respects, our General Terms of Sale apply.

Professional advice and rapid response from our central office in Bremen ensure you of reliable service.