

## Technical data sheet

**A11325.1-slugs A21325.1 – sticks**  
**A31325.1-sticks A41325.1 – granular**

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### HOT MELT

Part numbers: A11325.1-slugs  
A21325.1-sticks  
A31325.1-sticks  
A41325.1-granular

**APPLICATORS:** HB 180 serie, HB 190 serie  
HB 220, HB230-E, HB 325, HB 350  
HB 700-serie, bulk systems

### APPLICATIONS

Universally suitable hot melt for industry and workshops, installation work and producing permanent bonds such as for household and hobby.

### PROPERTIES

The hot melt is elastic and has a good adhesion to materials such as wood, wood materials, leather, paper, cardboards, glass, ceramics, fabrics, metals and plastics such as Melamin, ABS, PS, rigid PVC, PC, PMMA and PETP.

### DESCRIPTION

Type : Hot melt adhesive based on ethylene vinyl acetate copolymer

Colour : Yellow

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. 10 °C (Ring & Ball)

Heat resistance : approx. 65 °C (WPS 68, shearload 100 g/cm<sup>2</sup>)

Viscosity : approx. 3000 mPas at 180 °C (Brookfield)

Specific gravity : approx. 0.980 g/cm<sup>3</sup>

Solids content : 100%

Working temperature : 160-200 °C

Open time : approx. 40 s, depending on material and quantity of adhesive applied (strip shaped application, dia. 3 mm, 180 °C (356 °F), material strip (thickness 4 mm)).

Setting time : approx. 20s, depending on insulating effect of materials to be bonded and on application method and kind of material (see above open time).

Size : Slugs- dia.approx. 43mm  
sticks - dia. approx. 11.3 mm and approx. 18 mm  
Granular-20 kg sack

### PACKAGING

Slugs - 10 kg carton  
Sticks - 10 kg carton  
Granular in 20kg 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 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 1325.1 a slight quantity of acetic 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, and our subsidiaries, ensure you of reliable service.