Technical data sheet
B10669.1 – slugs B50669.1 – block

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HOT MELT

Part numbers: B10669.1 – slugs
B50669.1– block

APPLICATORS: HB 700-series
HB Bulk Systems

APPLICATIONS

Good properties for installation bonding and producing permanent bondings in industry and work-shop.

PROPERTIES

The hot melt has a low viscosity with a high softening point and shows a good adhesion to many materials, such as paper, cardboard, wood, glass, ceramic, fabrics, leather, metals and plastics as melamin, ABS, PS, PE, PP, PVC, PC, PETP, PA, POM, PMMA and PU-foam.

DESCRIPTION

Type	: Hot melt adhesive based on polyolefine
Colour	: beige
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. 125 °C Ring and ball
Heat resistance	: approx. 70 °C (WPS 68, shearload 100 g/cm2)
Viscosity	: approx. 1000 mPas at 180 °C (Brookfield)
Specific gravity	: approx. 0.98 g/cm³
Solids content	: 100%
Working temperature	: 160-190 °C
Open time	: approx. 60 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. 45 s, 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. 42 mm, length approx. 50 mm blocks

PACKAGING

Slugs - in 10-kg-pack
Blocks - 10-kg-pack

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.

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.