

Technical data sheet

B71452 – cartridges **B91452 – hobbocks**
B91452F – barrels

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HOT MELT

Part numbers: B71452 – cartridges
B91452 – hobbocks, barrels

APPLICATORS: HB 700-series
HB Bulk Systems
HB Drum loader

APPLICATIONS

For bondings demanding high standards of temperature reaction with glass, ceramics, metal, textiles and plastics (in this case with not pretreated PP, special in automotive industry).

PROPERTIES

This one-component adhesive is free of solvents, hardens with humidity, has a high heat resistance and a good flexibility at low temperature. The chemical cross linkage reaction happens by groups of Silan.

DESCRIPTION

Type : Hot melt adhesive based on polyolefine

Colour : Light-brown

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. 130 °C Ring and ball (in the state of material as supplied)

Heat resistance : approx. 175 °C (WPS 68, shearload 100 g/cm²) after finished reaction

Viscosity : approx. 5000 mPas at 180 °C (Brookfield)

Specific gravity : approx. 0,875 g/cm³

Solids content : 100%

Working temperature : 180 °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. 120 s, depending on insulating effect of materials to be bonded and on application method and kind of material (see above open time).

Size : Aluminium cartridges - dia. approx. 47 mm, length approx. 215 mm
Hobbocks

PACKAGING

Cartridges - content approx. 260 g, 35 pieces/pack
Hobbocks - 1.5-kg-barrel in 15-kg-pack,
15-kg-barrel, 150-kg-barrel

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

STORAGE

Dry storage under indoor conditions and when stored in the original packing. Expiration date is marked on the cartridges and barrels.

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. The final strength of the bonding is reached after 10 to 14 days. As reactive polyolefine hot melts do react with humidity it is recommended to drive bulk systems with a cover of nitrogen.

SPECIAL NOTES

The safety and operating instructions for the applicator must be observed! Attention: Hot! The molten adhesive, the preheated cartridge and the nozzle of the gun can reach temperatures which may cause skin burns if accidentally touched. In such cases sub-merge 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.

CLEANING

After working end the applicators have to be cleaned:
HB Bulk Systems with cleaner 91233 oder 1735 / 1735R
HB 700 K with cleaner 71233R

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.