

## Technical data sheet C20572 - sticks

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### HOT MELT

Part numbers: C20572 - sticks

**APPLICATORS :** HB 220, HB230-E

### APPLICATIONS

Electrical lines, electronic, circuit boards.

### PROPERTIES

Good low temperature flexibility. Very good adhesion to wood, paper, cardboard products, leather, PVC, PC and PU-foam.

The hot melt adhesive has been certified according to UL94V-0 (2).

The raw material components are registered in FDA-regulations 175.105 for the packing of food.

### DESCRIPTION

Type	: Hot melt adhesive based on polyamide
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. 145 °C Ring and ball
Heat resistance	: approx. 120 °C (WPS 68, shearload 100 g/cm <sup>2</sup> )
Viscosity	: approx. 5000 mPas at 210 °C (Brookfield)
Specific gravity	: approx. 1.00 g/cm <sup>3</sup>
Solids content	: 100%
Working temperature	: 180-210 °C
Open time	: approx. 30 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. 30 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

### PACKAGING

Sticks - approx. 200 g alu-bags in 6-kg-pack (13 pounds)

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

### STORAGE

Minimum 18 month 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.

Polyamides are in balance with the atmospheric humidity. The absorbed humidity results in foaming (steam generation) by melting the polyamides. We recommend closing the packaging properly after use. If necessary the hot melt can be dried by heating to approx. 50 °C (122 °F) for about 48 hours in an oven.

In molten state polyamides tend to oxidize in contact with atmospheric oxygen (dark colour and in extreme cases film formation/skinning).

This oxidation can be prevented by using dry inert-gas (nitrogen) to cover the molten adhesive in bulk tank or by operating HB 500 / 600 pneumatic systems with inert-gas.

### 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. It is recommended to exhaust the hot melt fumes, especially when using a working temperature of more than 200 °C.

### 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.