

Technical data sheet

C20874 / C20874 S - sticks C40874 / C40874 S - granular

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HOT MELT

Part numbers: C20874 / C20874 S - sticks
C40874 / C40874 S - granular

APPLICATORS : HB 220, HB 230-E
HB 700-series
HB Bulk Systems

APPLICATIONS

Electric industry: Filling of electric units. Cable passages.
Forming plugs. Electronic industry: Protecting of units and
spool varnished wires.

PROPERTIES

Good resistance to PVC-softening agents, good heat resistance,
good cold flexibility. Adhesion: Excellent adhesion to wood,
paper, leather, ABS, PVC, PC and PU foam. The hot melt adhesi-
ve has been certified according to UL94V-2.

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

DESCRIPTION

Type : Hot melt adhesive based on
polyamide

Colour
C20874 /C40874 : yellow
C20874 S/C40874 S : black

Composition : The components of this hot melt
adhesive are classified as complete-
ly harmless. There is thus no need
for special labelling of this product
in compliance with German regulati-
ons for dangerous materials.

TECHNICAL DATA

Softening point : approx. 155 °C Ring and ball

Heat resistance : approx. 135 °C (WPS 68, shearload
100 g/cm²)

Viscosity : approx. 3500 mPas at 200 °C
(Brookfield)

Specific gravity : approx. 1.00 g/cm³

Solids content : 100%

Working temperature : 180-210 °C

Open time : approx. 15 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. 7 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
granular - loose charged

PACKAGING

Sticks - approx. 200 g alu-bags in 6-kg-pack
Granular - in 20-kg-sack

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 pos-
sible 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 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 (nitro-
gen) to cover the molten adhesive in bulk tank or by operating
HB 700 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 mu-
cous-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 ensure you of reliable service.