

## 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/cm<sup>2</sup>)

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

Specific gravity : approx. 1.00 g/cm<sup>3</sup>

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. 10 s, depending on insula-  
ting 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.