

Technical data sheet C30893 - sticks C40893 - granular

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HOT MELT

Part numbers: C30893 - sticks
C40893 - granular

APPLICATORS : HB 320, HB 350
HB 700-series
HB Bulk Systems

APPLICATIONS

The hot melt is a special development for bonding tiles on show boards.

PROPERTIES

The hot melt has a good adhesion to the back of tiles and to wood, paper, PVC. Can be pressed easily out of the pneumatic system under working temperature. The hot melt has a good flexibility at low temperature. The hot melt is applied as spots on the tile and then bonded on the show board. Via the dimensions of the spots the applicator is able to control the period of time, in which an adjustment of the tiles can take place on the show board.

The raw material components are registered in FDA-regulations 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. 135 °C Ring and ball
Heat resistance : approx. 100 °C (212 °F) (WPS 68, shearload 100 g/cm²)
Viscosity : approx. 4000 mPas at 190 °C (Brookfield)
Specific gravity : approx. 1.00 g/cm³
Solids content : 100%
Working temperature : 200-210 °C
Open time : approx. 60 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. 60 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. 18.3 mm, length approx. 300 mm
granular - loose charged

PACKAGING

Sticks - 400 g Alu-bag in 6-kg-pack, granular - 20-kg-pack

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 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 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 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 ensure you of reliable service.