

Technical data sheet

D51586 – blocks D51586-04 – blocks

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HOT MELT

Part number: D51586 – blocks
 D51586-04 blocks

APPLICATORS : HB Bulk Systems

APPLICATIONS

High-quality hot melt for fixing and assembly in many branches of industry, for example insulating materials, automotive, self adhesive articles and similars.

PROPERTIES

Hot melt 1138 is a pressure sensitive adhesive with an excellent tack and a high elasticity as well as a good flexibility at low temperature. This hot melt has an excellent bonding to many materials such as wood, paper, cardboards, fabrics, leather, metals, ceramics, glass and to many plastics such as Melamin, PE, PP, PVC, PC, PETP, PA, POM, SBR.

DESCRIPTION

Type : Hot melt adhesive based
 on Thermoplastic rubber

Colour : Yellowish transparent

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. 95 °C Ring and ball

Heat resistance : approx. 55 °C (WPS 68, shearload
 100 g/cm²)

Viscosity : approx. 16000 mPas at 160 °C
 (Brookfield)

Specific gravity : approx. 0.970 g/cm³

Solids content : 100%

Working temperature : 150-180 °C

Open time : Permanent tacky

Size : Blocks

When applying the hot melt by spray melt systems the value of the open time is reduced.

PACKAGING

1 kg-Blocks - in 12-kg-pack, 4 kg blocks in pack

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

STORAGE

Minimum two year 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 respectively spray a layer of sufficient thickness and join the parts together immediately. Short-time pressure will increase the bond strength.

This thermoplastic adhesive is stabilized against thermal and oxidizing decomposition. In case of unusual thermal stress, e. g. temperature exceeding 180 °C or long periods in molten state, the use of an inert-gas (nitrogen or carbon dioxide) is recommended.

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.

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.