

## Technical data sheet BÜHNEN D1628.1

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### HOTMELT

Part numbers: D51628.2 – Meltpack  
D61628.2 – Small pillows

### BÜHNEN APPLICATORS

Pneumatic glue applicators  
HB Bulk Systems

### APPLICATIONS

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

### PROPERTIES

Pressure sensitive adhesive with an excellent tack and a strong initial adhesion. 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 melamine, PE, PP, PVC, PC, PETP, PA, POM.

### DESCRIPTION

Type: Hotmelt adhesive based on thermoplastic rubber

Colour: yellow

Classification: The components of this hotmelt adhesive are classified as completely harmless. There is thus no need for special labelling of this product in compliance with EU regulations for dangerous materials.

### TECHNICAL DATA

Softening Point: approx. 91°C Ring and Ball

Viscosity: approx. 5600 mPas at 177°C (Brookfield)

Specific gravity: approx. 0.96 g/cm<sup>3</sup>

Working temperature: 160-170°C

Open time: permanently tacky

### SIZE

Meltpack (D51628.2) - ca. 700 gr  
Small pillows (D61628.2)

### PACKAGING

Meltpack (D51628.2) - 18kg/box; 648 kg per pallet  
Small pillows (D61628.2) – 14kg per box; 504kg per pallet

### STORAGE

Two years shelf life after production 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.

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.

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

### 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. Preventive ventilation should exist.

### DISCLAIMER

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The information contained in this processing data sheet therefore also does not justify any assumption of liability with respect to the product being suitable for the relevant application. It is therefore essential that the user tests the adhesive we provide with the original parts intended for application, taking into consideration the relevant production and use conditions. This also applies in the event of changes made as part of an ongoing processing or production procedure. Our General Terms and Conditions of Business also apply.