

Technical data sheet BÜHNEN B1452.1

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HOTMELT

Part numbers: B71452.1 - cartridges
B91452.1 - hobbock
B91452.1F - barrel

APPLICATORS

HB 700 K
HB Bulk Systems
HB Drum loader

APPLICATIONS

For bondings demanding high standards of temperature reaction with glass, ceramics, metal, textiles and plastics (in this case with not pretreated PP, special in automotive industry).

PROPERTIES

This one-component adhesive is free of solvents, hardens with humidity, has a high heat resistance and a good 'exibility at low temperature. The chemical cross linkage reaction happens by groups of Silan.

DESCRIPTION

Type: Hotmelt adhesive based on polyolefine

Colour: light-brown

Composition: 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 German regulations for dangerous materials.

TECHNICAL DATA

Softening Point: approx. 130°C Ring and Ball

Viscosity: approx. 5200 mPas at 180°C (Brookfield)

Specific gravity: approx. 0,875 g/cm³

Working temperature: 180°C

Open time: long depending on material and quantity of adhesive applied (bead application, dia. approx. 3mm, 180°C, beech material (4mm thickness).

Setting time: medium depending on insulation effect of materials to be bonded and on application method and kind of material (see above open time).

SIZE

Aluminum cartridges (B71452.1) - dia. approx. 47 mm
Hobbocks (B91452.1) . dia. approx. 125mm

PACKAGING

Aluminum cartridges (B71452.1). content approx. 260g, 35 pcs. per box
Hobbocks (B91452.1) . 6 x 1,5kg hobbock per 9kg box

When applying the hotmelt adhesive via spray-melt-systems, the value of the open time is reduced.

STORAGE

Dry storage under indoor conditions and store in the original packing. Storage life is 12 months after delivery date.

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. The ,nal strength of the bonding is reached after 10 to 14 days. As reactive polyole, ne hot melts do react with humidity it is recommended to drive bulk systems with a cover of nitrogen.

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.

CLEANING

After working end the applicators have to be cleaned:
HB Bulk Systems with flushing agent F91735R / F91735
HB 700 K with flushing agent F71233R

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.