

## Technical data sheet BÜHNEN C0874

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### HOTMELT

Part numbers: C20874 / C20874S - Sticks  
C40874 / C40874S - 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 hotmelt adhesive has been certified according to UL94V-2. The raw material components are registered in FDA-regulations 175.105 for the packing of food.

### DESCRIPTION

Type: Hotmelt adhesive based on polyamide

Colour: C20874/C40874: yellow  
C20874S/C40874S: black

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. 155°C Ring and Ball

Heat resistance: approx. 135°C (WPS68, shear-load 100g/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 sec. depending on material and quantity of adhesive applied (bead application, dia. approx. 3mm, 180°C, beech material (4mm thickness)).

Setting time: approx. 10 sec. depending on insulation effect of materials to be bonded and on application method and kind of material (see above open time).

### SIZE

Sticks (C20874) – dia. approx. 11.3mm, length approx. 200 mm  
Granular (C40874) – loose charged

### PACKAGING

Sticks (C20874) – approx. 200g aluminum bags per 6kg box  
Granular (C40874) – 20kg per bag

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

### STORAGE

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 (122 °F) for about 48 hours in an oven. In molten state polyamides tend to oxidize in contact with atmospheric oxygen (dark color 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.

Slight variation in the color 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. It is recommended to exhaust the hot melt fumes, especially when using a working temperature of more than 200 °C.

### DISCLAIMER

Our processing data sheets contain only non-binding notices as part of a recommendation. The information and technical data contained herein do not constitute an assurance of quality. Any liability for the content of the data sheet is therefore excluded to the extent permitted by law; wilful or negligent infringement of contractual obligations are excluded from this. As the supplier of the adhesive, we can certainly guarantee a consistent adhesive quality, which we would be happy to document in the form of a specific test report.

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.