

DIRECTA

ESSENTIALS FOR INDUSTRY

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TECHNICAL DATA SHEET

PRODUCT: 9399712300

Our Ref: Hot Melt Glue Sticks - Long Open Time - (Clear)

GENERAL DESCRIPTION:

An economical clear general-purpose adhesive with good adhesion to many surfaces. It has a high viscosity, which makes it suitable for porous substrates, such as fabrics and foams.

This adhesive has excellent filling and low sag properties.

TECHNICAL CHARACTERISTICS:

Adhesive type: Synthetic polymer based hotmelt

Colour: Clear/transparent (many colours also available)

Molten tack: Medium

Diameter (Nominal)	12mm	15mm	43mm
Length (Nominal)	300mm	300mm	43mm
Carton Quantity	5 kilos	5 kilos	10 kilos
Sticks per kilo (approx.)	34	20	17
Suggested Application Temperature:	195°C	195°C	195°C
Brookfield Viscosity (ASTM D3236) @ 180°C spindle 27	9500 cps	9500 cps	9500 cps
Ring & Ball Softening Point (ASTM E28)	87°C	87°C	87°C
Heat Resistance (BS5350 Part H3)	75°C	75°C	75°C
Open Time	Medium	Medium	Medium
Low Temperature Flexibility (tg)	-30°C	-30°C	-30°C

Sizes Available	Suitable Applicators	Typical Output
12mm sticks	P/150	0.23kg/hr
	P/312	0.75kg/hr
	P/300G	1.20kg/hr
	P/712	2.00kg/hr
	P/812	1.6kg/hr
	P/912	2.4kg/hr
	Most other 12mm applicators	
15mm sticks	P/915	Variable
43mm slugs	P/543	3.5kg/hr
	P/610	4.1kg/hr

All constituent parts of this adhesive have been approved by the American F.D.A under C.F.R.21.175.105 (adhesives)

HEALTH AND SAFETY

Health and Safety

Hotmelt adhesives pose virtually no hazards to health when used in normal industrial practice, but because they are used as molten state at high temperatures there is a risk of thermal burns. Skin contact with molten hotmelt should be avoided and precautions taken against accidental splashes of adhesive. The use of overalls, cotton gloves, and safety glasses help minimise the risk of burns.

Inhalation:

Vapours given off during normal operation are not considered toxic, but if overheated, chemical breakdown of the components may occur releasing a complex mixture of organic materials, some of which may be toxic or irritant. Ensure hotmelts are run at the recommended operating temperatures and use in a well-ventilated area.

Eye Contact

For solid hotmelt treat as inert particles and irrigate copiously with clean fresh water. For molten hotmelt irrigate with cold water and seek medical advice immediately.

Skin Contact

Solid cold hotmelt is harmless to the skin. Wash hand with soap and water. Skin affected by molten hotmelt should be plunged into cold water immediately and left until the burning sensation subsides. If no tap is accessible have a bucket of clean cold water available. If coated with hotmelt, move fingers to prevent a tourniquet effect as it cools. Do not remove the adhesive when molten as it might remove skin to quite a depth leaving a raw wound. Even when solid remove with care as the above may still occur. If difficult to remove, with medical approval, olive oil or liquid paraffin should be soaked into a cotton wool pad and placed over the affected area. This will slowly soften the adhesive into the pad. When hotmelt is removed treat as a normal burn

Fire

Not normally a hazards but in fire hotmelts are combustible, use dry powder or CO2 extinguisher. Do not use water.

Storage

Store in a clean dry place at temperature between 5 and 30°C with boxes closed. Do not expose to direct sunlight or localised heat sources such as radiators or hot pipes.

Removal of Glue

Assembled components can be separated by heating assembly to a temperature slightly above the heat resistant figure.

EVA & Polypropylene

Residues of EVA and polypropylene based hotmelts can be removed from components with white spirit.

Polyamide

Residues of polyamide based hotmelt can be removed from components with acetone.

PLEASE NOTE

The information contained on this data sheet is for guidance only. It is the result of careful laboratory evaluations by trained and qualified staff using British Standard or similar test methods. However, no warranty is expressed or implied regarding the accuracy of this data of the suitability of the adhesive for any specific purpose. In every case, we strongly recommend that the user shall make their own tests to determine to their own satisfaction the suitability of the adhesive for their own particular purpose. Neither seller nor manufacturer shall be liable for any injury, loss, damage, and direct or consequential arising out of the use or inability to use the product. Further information is always available to help solve your adhesive problems. Should you require any further information on our adhesive or applicators please contact your nearest distributor.