POWER ADHESIVES

TEC-BOND 240 HOTMELT ADHESIVE

DATA SHEET

GENERAL DESCRIPTION

TEC-BOND 240 is a clear high performance, product assembly adhesive, which has excellent adhesion to wood, ceramics, light gauge metals and many plastics, such as rigid PVC, polystyrene, ABS and acrylic.

TEC-BOND 240 melts down easily so both the output and ease of use of particularly the small glue guns is improved.

TECHNICAL CHARACTERISTICS

Adhesive type:	Synthetic polymer based hotmelt
Colour:	Clear/transparent (12mm sticks also available in white)
Molten tack:	Medium

Diameter (Nominal)	12mm	20mm	43mm	Bulk
Length (Nominal)	300mm	N/A	43mm	N/A
Carton Quantity	5 kilos		10 kilos	
Sticks per kilo (approx.)	34		17	
Suggested Application Temperature:	195ºC		195ºC	
Brookfield viscosity (ASTM D3236) @ 180ºC spindle 27	5500 cps		5500 cps	
Ring & Ball Softening Point (ASTM E28)	87ºC		87ºC	
Heat Resistance (BS5350 Part H3)	75ºC		75ºC	
Open Time	Long		Long	
Low temperature flexibility (tg)	-30ºC		-30ºC	

SIZES AVAILABLE	SUITABLE APPLICATORS	TYPICAL OUTPUT
12mm sticks	HOTFIX 180, TEC 200	0.9 Kg/hr
	TEC 650, GAS-TEC 300, GAS-TEC 500	1.4 Kg/hr
	TEC 700,	1.7 Kg/hr
	TEC 901	1.9 Kg/hr
	Most other 12mm applicators	Variable
43mm slugs	TEC 3200,	2.1 Kg/hr
	TEC 6100	3.6 Kg/hr

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

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HEALTH & SAFETY

Hotmelt adhesives pose virtually no hazards to heath when used in normal industrial practice, but because they are used in a 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 hands 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 cottonwool 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 hazard, but in a fire hotmelts are combustible, use dry powder or CO2 extinguisher. Do not use water.

STORAGE

Store in a clean dry place at temperatures between 5°C 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 resistance figure.

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

POLYAMIDE: Resides 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 the data or the suitability of the adhesive for any specific purpose. In every case, we strongly recommend that the user shall make their own test to determine to their own satisfaction the suitability of the adhesive for their particular purpose. Neither seller nor manufacturer shall be liable for any injury, loss, damage, 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 adhesives or applicators please contact your nearest distributor.