



TECBOND 7718 HOTMELT ADHESIVE

**POWER
ADHESIVES**

DATA SHEET

GENERAL DESCRIPTION

Tecbond 7718 is a polyamide adhesive with a very low viscosity that sets very hard. It is used for two main applications. Potting and encapsulation in the electronics industry as well as knot filling/wood repair in the woodworking industry.

Potting and Encapsulation: Tecbond 7718 has been tested for use in electrical / electronic applications and the electrical characteristics are listed below. The use of hotmelt speeds up assembly as there is no mixing and any unused adhesive remains in the glue gun ready for next time, so there is no waste. Setting time is usually less than 2 minutes. Coloured versions of the adhesive are available which can be useful to hide components or colour code for traceability.

Knot Filling / Wood Repair: The flow characteristics, hard setting and low shrinkage nature of Tecbond 7718 make it ideal for filling cracks and voids often found around knots in many types of wood. The adhesive is applied by glue gun, trimmed with a sharp knife or chisel and then sanded as usual before finishing. The adhesive is available in different colours to match the wood.

TECHNICAL CHARACTERISTICS

Adhesive type	Polyamide based hotmelt
Colour	12 & 15mm Amber, Black, Beige & Cola (Bulk Amber only)
Molten Tack	Very High

Diameter (Nominal)	12mm	15mm	Bulk
Length (Nominal)	250mm	250mm	N/A
Bulk Carton Quantity	10kg (4x2.5kg)	10kg (4x2.5kg)	10kg
Small Pack Carton Quantity	10 x 10 stick pack	10 x 6 stick pack	N/A
Sticks per kilo (approx)	40	24	Small pellets
Suggested Application Temperature:	215°C	215°C	190 - 215°C
Brookfield viscosity (ASTM D3236) @ 190°C spindle 27	950 cps	950 cps	950 cps
Ring & Ball Softening Point (ASTM E28)	160°C	160°C	160°C
Heat Resistance (BS5350 Part H3)	135°C	135°C	135°C
Open Time	Short	Short	Short
Low temperature flexibility (tg)	-10°C	-10°C	-10°C
Surface resistivity Mohm BS 6233	2.51×10^6	2.51×10^6	2.51×10^6
Volume resistivity Mohm/mm BS 6233	1.38×10^6	1.38×10^6	1.38×10^6
Breakdown voltage/Dielectric strength kV BS EN 60243-1	30	30	30
Breakdown strength kV/mm BS EN 60243-1	15.6	15.6	15.6

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Please note, the test data recorded is the normal/typical value

SIZES AVAILABLE

12mm sticks

15mm sticks

SUITABLE APPLICATORS

TEC 250
GASTEK 500
TEC 810-12
TEC 810-15
Most other 12 & 15mm applicators

TYPICAL OUTPUT

0.5 kg/hr
0.7 kg/hr
1.5 kg/hr
2.0 kg/hr

This product has been tested and complies with UL 94-V0 fire retardancy requirements.

Important Note

This is a polyamide-based material and consequently will absorb a small amount of moisture from the atmosphere. This does not affect the performance and all test data relates to fully saturated material. However, even a small amount of moisture contamination will turn into a large amount of steam at glue gun temperature. This will cause the glue gun to drip foam, and glue stick to back up.

Please keep the adhesive sealed in the special packs provided. Moisture contaminated adhesive may be dried in an oven at 70°C for 24-48 hours.

HEALTH & SAFETY

Hotmelt adhesives pose virtually no hazards to health 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 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 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 & 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.

PUR: Prior to cross linking adhesive can be removed with white spirit or ketone. Once fully cross linked the adhesive cannot be easily removed.

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.



TEC 810-12

INDUSTRIAL MID RANGE GLUE GUN

... the power to perform

POWER ADHESIVES

The TEC 810-12 brings a new level of performance and reliability to the mid range industrial glue gun section of the market.

The TEC 810-12 has been designed for continuous industrial use. Built in the UK to the highest standard with the goal of having the highest performing glue gun in its class.

The TEC 810-12 features a highly efficient melt chamber which gives a warm up time of only 2 to 3 minutes, with a glue delivery rate in excess of 2 kilos an hour (depending upon glue formulation).

The temperature is accurately controlled by a preset thermostat.

These can be easily changed to adjust the gun temperature for the different types of Hotmelt and Lowmelt adhesives available.

The TEC 810-12 is exceptionally comfortable and easy to use with a full hand lever trigger, narrow profile handle and soft feel grip. The trigger can also be adjusted to suit different sized hands.

The guns thin profile improves access and visibility and the smooth nose section is easy to clean. With illuminated on/off switch and a detachable base stand that also includes a nozzle spanner and stores the trigger stop adjustment screw.

The TEC 810-12 is the only choice for an industrial mid range glue gun as it meets all requirements in this section of the market.

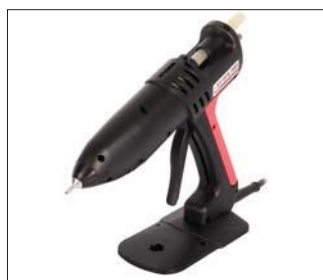
Covered by a one year guarantee the TEC 810-12 complies with worldwide industrial and electrical safety standards.



FEATURES



Illuminated on-off switch & detachable stand incorporating nozzle spanner



Thin profile for easy visual positioning of the molten adhesive



Narrow profile handle with soft feel grip & full hand lever trigger & adjustable trigger stroke screw.



Easy change temperature thermostats & rubber nozzle shroud for extra safety.

FOR OUR FULL PRODUCT RANGE PLEASE VISIT OUR WEBSITE
www.poweradhesives.com

SPECIFICATION

VOLTAGE	230V or 110-120V 50-60HZ
HEATER	250W High performance stainless steel cartridge
TEMP CONTROL	Pre-set Thermostats (Fitted with 195 ^o c) with safety thermal fuse other temperature easy change thermostats available
WEIGHT	0.5kg
POWER CABLE	2m three core rubber sheathed cable fitted with UK plug European, Australian, Swiss & USA versions available
MELT RATE	Up to 2kilo/hr depending on adhesive & temperature
ADHESIVE SIZE	TECBOND 12mm glue sticks

OPTIONAL NOZZLES The **TEC 810-12** is supplied with a one piece one hole nozzle with 2mm orifice (part number ADJ010) Optional nozzle caps are available for specialised purposes and to speed up adhesive application.



REF	PART No	TYPE	DESCRIPTION
1	ANZ999	Adaptor	This part is needed to use Nos 2, 3 & 5 caps
2	MNZ013	2 Hole	2 Parallel Adhesive lines 10mm apart
3	MNZ027	3 Hole	3 Parallel Adhesive lines 5mm apart
4	ADJ004	Slotted Spreader	Allow a 12mm wide spread of glue
5	PA5032	L Nozzle	Fast full overlap carton sealing

OPTIONAL ACCESSORIES



TEC SB/1200 Spring Balance with a maximum extended cord length of 1.6m designed to minimise operator fatigue. It also increases productivity and reduces the chance of accidental damage to the applicator.



TECBOND High Performance 12mm Adhesive sticks specially designed for use in the **TEC 810-12** gun. The **TECBOND** range of adhesives provides variations in setting time heat resistance and viscosity to suit every application. Also available coloured & glitter glue sticks for that extra creativity.



TEC Metal Stand

Part No MDC009 ideal for use on work surface or wall mounted.



TECMAT Silicon Rubber Drip Mat can be used underneath the **TEC 810-12** gun to protect work surfaces against damage caused by molten hotmelt adhesive

