

# THERMORESOL

## 4500/2

Pressure Sensitive hot melt adhesive with 100% active material based on synthetic polymers and modified resins.

TECHNOLOGY	HOT MELT
RING & BALL	≈ 130°C
NATURE	RESINS AND POLYMERS
COLOUR	LIGHT YELLOW

### PROPERTIES

Technology	Polymers and Resins
Colour	Yellow
Density @ 23 °C	0.90 ± 0,05 g/ml
Viscosity @ 120 °C (Spindle 27- 2.5 rpm)	30.000 ÷ 4.000 cps
Ring & Ball (UNI EN 1238)	130 ± 5°C
Color (Gardner Index)	Giallo
Appearance	Solid: Free pack or Pails

### PERFORMANCE

Peel Adhesion @ 180°C (FMT 1-vetro/1h)	> 10 N/Inch
Loop-Tack (FTM 9-Vetro)	> 20 N/inch
Shear Strength	(FTM 8 - Vetro – 40°C – 1 Kg) > 1 week (FTM 8 – Vetro – 70°C – 1 Kg) > 3 hours
Compatibility Release	Solvent based silicone: Compatible Solvent based silicone: Compatible UV-crosslinkable silicone: Compatible
Food Contact	-
Application Temperature	150 – 180 °C

### DESCRIPTION

Hot Melt pressure sensitive used to produce self-adhesive materials, such as adhesive tapes, labels and insulating materials. It is suitable for applications with high cohesive strength requirements.

Particularly suitable for bonding supports that have good resistance to thermal tempering. The product is suitable for bonding difficult materials such as plasticized. Suitable for bonding carpets, rugs, felts, etc. Wide range of applications, in various sectors.

Use in structural applications requiring high shear strength. It passes the "automotive fogging" test at 80 °C and 100 °C.

It can be applied by roller or by extrusion using a special gun, at temperatures between 150 °C and 180 °C. For applications with low weight (15-30 g / m2) we recommend a nozzle with a rotating wand.



## APPLICATION

- Before proceeding with gluing, prepare the substrates (see paragraph "recommendations")
- Apply the adhesive on one of the two surfaces to be glued and assemble the components with great care.
- Remove excess glue before it cures.
- Allow the adhesive to react for the time necessary for it to develop sufficient resistance to handling.
- The glued surfaces must be stopped with pliers until they are completely fixed.
- The unreacted adhesive is stable in the absence of moisture. The material must be protected or purged to avoid exposure to moisture during prolonged downtime (nights, weekends).
- Can be extruded using a special gun, designed to be used with thermo-fusible adhesives

## PROPERTIES AND USES

- Used in automotive for fixing plastic components on thermoplastics and felts or TNT.
- For best performance it is recommended to work on clean, dry and degreased surfaces. Apply the product over the entire engaged surface and tighten thoroughly.
- Quick setting.
- Fundamental to obtaining a good result even on difficult materials is the safety of having gluing devices capable of keeping the temperature always within the necessary tolerances. If it should be considered useful, equip yourself with two gluing devices to alternate.
- Pay attention if the glued parts are exposed to frost or high percentages of humidity.
- Excellent resistance to fatigue, shocks and loads.
- Good resistance to acids and bases and hydrocarbon solvents
- In order to improve bonding on low surface tension plastics, a primer can be applied to the bonding area.
- Avoid excess primer, let it dry after deposition.

## RECOMMENDATIONS

### Substrate preparation

The substrates must be thoroughly clean, dry and free of oil, grease and dust which can certainly affect the quality of the bonding. Best cleaning by use of isopropyl alcohol MK-WIPES, MK Sol-Neo or MK Sol-13 in accordance with local regulations. Degrease the PVC and metal surfaces with a non-greasy solvent. Always check the compatibility of your solvents with the substrate to be bonded. If necessary, slightly sand or strongly abrade the surfaces to be bonded.

## PRECAUTIONS FOR USE

Mastikol® products should be used following the normally precautions adopted during chemical substances handling. It is recommended to wear rubber or latex gloves and to protect the eyes adequately. Thoroughly clean the skin at the end of the work shift with warm soapy water. The use of solvents is not recommended. Dry yourself with paper wipes. It is recommended to ventilate the work area well. These precautions are detailed in the Safety Data Sheets relating to the individual products and should be referred to for a complete information.

## STORAGE AND PACKAGING

It can be stored for nine months in the original and sealed containers kept in a cool and dry environment.

Storage temperatures must be between 11°C and 23°C. Prolonged storage at a temperature above 23°C will reduce shelf life and the expiration date. Avoid direct contact with sunlight.

Free pack 14 kgs

Pails 20 LT | Drums 200 LT for industrial dispenser.

## NOTES

The information, in particular, the recommendations relating to the applications and use of Mastikol® products, are given in good faith and are based on current knowledge and experience of the products, when properly stored, handled and applied under normal conditions. Mastikol® assumes no responsibility for the results obtained by third parties for which there is no control over the method.

It is the customer's responsibility to confirm the suitability of the product for the application. As it is not possible to control the application, use or processing of the products; no liability is assumed in this regard. The customer must ensure that the use of the products does not infringe any third party intellectual property rights. Specifically, Mastikol® disclaims all express or implied warranties, including warranties of merchantability or fitness for specific purposes, arising from the sale or use of Mastikol® products. No liability is accepted for consequential or incidental damages of any kind, including loss of profit.

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PROFESSIONAL BONDING SOLUTION