

Adhesive type H1

Adhesive properties:

Hot-melt adhesive, artificial rubber based with foil or paper as release liner.
Conforms to 21 CFR 175.105 for FDA indirect food contact.
Very high adhesive, elastic film.
Adhesion is good to excellent on almost all materials, limited application on PVC.

Adhesion:

Peel strength : approx. 23 N/cm

Shear strength : approx. 100 N/cm²

All measurements relate to a self adhesive finished KLETTOSTAR[®] hook at room temperature.

The bond strength is tested on a high quality polished steel in accordance with DIN 16864 and the Ford Spec. SKM-3G 9512-A.

Temperature range:

approx. - 30°C up to + 93°C (short time) depending on the surface and load

Softening point:

approx. + 85°C, in accordance with Ford Spec. SKM-3G 9512-A

Glue resistance:

virtually weather and waterproof

Resistant to ageing due to moisture and heat in accordance with Ford Spec. SKM-3G 9512-A

Appearance (colour):

honey-like, transparent.

Storage:

dry, dust-free, dark area, up to max. temperature 25°C

Shelf life:

in suitable storage 12 months

Materials to be bonded:

many plastics and plastic foils, metal, wood, stone, porcelain, glass, varnished parts

Remarks:

High levels of softening agents in plastics, especially oligomers, lead to plasticizer migration at the bordering edges and a weakening or failure of the adhesive bond.

In most cases a damage of the adhesive is shown by a reduction of the adhesive strength and a softening of the adhesive at the same time. The adhesive becomes viscous and stringy. Strong migration of softener can even result in creeping of the adhesive.

Test for suitability:

Because of different surfaces, environmental exposures (temperatures, moisture or wetness) operational load tests to determine the suitability are absolutely essential.

Instructions for bonding

Background:

The surface to be bonded must be free of grease, loose particles and moisture. In addition the surface must be suited to the adhesive; not too uneven, weathered, brittle, too soft, too unstable, saturated with softeners, furnished with flaking or glue-resistant lacquers or coats of paint.

The surface has to be pre-treated with:
acetone for metal/aluminium
lighter fuel for lacquered surfaces and plastics.

Influence:

The adhesive must flow onto the surface and create full surface contact.

Best bonding results are reached when the surface and the self-adhesive coated tape have a temperature of at least 20°C.

Hard pressure is necessary (e. g. with a rubberized roller).

Intensifying the bond:

By short exposure to heat, e. g. approx. 2 minutes hot air with 60-80°C or warming cabinet the bond can be intensified.

Load:

Since the glue has to bond with the surface it is recommended not to put a weight on before 30 minutes (even better 2 hours).

Removing surplus glue:

Useful solvents are e.g.:

lighter fuel, acetone, ethyl acetate

Important: Test suitability of surface before application, most important for lacquer and plastic surfaces.

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