Technical Data Sheet

technicoll® 9302
Hot melt adhesive, pressure-sensitive

Field of application

technicoll® 9302 is a hot melt, pressure-sensitive adhesive for bonding different kinds of materials, even substrates hard to bond.

Special characteristics

The special form of delivery (small, non-adhesive pillows) allows a simple handling in hand guns (glue guns) and tank melting facilities. technicoll® 9302 has a high resistance to ageing.

Handling data and product data

Base	thermoplastic natural rubber
Viscosity (+180 °C)	approx. 1700 mPas
Application temperature	+130 °C to +180 °C
Open time	constantly sticky
Colour	transparent, yellowish
Softening point	approx. +87 °C (ring and ball)
Density	1.0 g/cm^3
Cleaning agent / material	technicoll® 8363 technicoll® 9901 (metal cleaning spray) technicoll® 9902 (plastics cleaning spray)
Cleaning agent / tool	technicoll® 8362, technicoll® 9901 (spray)
Maximum time of storage	At least 2 years when stored in sealed original packaging in cool and dry places.
Preferred storage temperature	+10 °C to +25 °C Avoid heat (sun) – the outer shape of the hot melt adhesive may change.
Behaviour at low temperature	Not susceptible to frost.

Favoured substrates

- paperboard, paper
- painted and coated materials
- derived timber products
- textiles
- metals
- PE, PP, POM
- glass, ceramics
- ABS, PS, PVC, PMMA, PC, PA

Not suitable for: Plasticised materials (PVC-p, faux leather)

Due to the large variety of possible materials and differences in adhesion behaviour hazard tests are mandatory before introducing the adhesive into the actual production process.

FDA – 21 CFR §175.105

Raw materials accord to FDA regulation 21 CFR §175.105.

Surface preparation

Bonding surfaces must be dry and clean, especially free of oil, grease or solvents. For cleaning plastic surfaces technicoll® 8363 is recommended.

Application

Apply adhesive with a hot melt gun (tank melting tool) or a tank tool with a pump, heated pipes and guns with nozzle. Also an application with nozzle, roller or disk is possible. Apply melted adhesive to one side as a dot, film or bead. Join the substrates to be bonded immediately. The adhesive sets while cooling down to room temperature. A soft, flexible film with a high tackiness will be formed.

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