

## Technical Data Sheet

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### technicoll® 9304 Hot melt adhesive with high resistance to heat



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#### Field of application

technicoll® 9304 is a multipurpose hot melt adhesive.

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#### Special characteristics

technicoll® 9304 is characterised by high cohesion and good resistance to heat (also in long-term use).

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#### Handling data and product data

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|----------------------------------|---|
| Base                             | polyolefin  |
| Viscosity (+180 °C)              | approx. 13000 mPas  |
| Processing temperature           | +180 °C to +200 °C  |
| Open time                        | approx. 100 seconds, depending on substrate and amount of application             |
| Setting time                     | approx. 3 minutes, depending on substrate and amount of application               |
| Colour                           | white   |
| Softening point                  | approx. +155 °C (ring/ball)   |
| Resistance to thermal distortion | approx. +90 °C  |
| Density                          | 1.0 g/cm <sup>3</sup>   |
| Solid content                    | 100 %   |
| Cleaning / material              | technicoll® 8363  |
| 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<br>Avoid heat (sun) – the outer shape of the hotmelt may change  |

## Favoured substrates

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- paperboard, paper
- textiles, fabrics
- derived timber products
- thermoplastics like: PS, PVC-u, PMMA, PC, PA
- PP, POM

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

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Raw materials accord to FDA regulation 21 CFR §175.105.

## Surface preparation

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

## Application of adhesive

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Apply technicoll® 9304 as a dot, film or bead or spray a sufficient quantity of adhesive to the surface to be bonded and adhere parts immediately. Short pressure increases the strength. When using the spray coat method, the open time is shorter.

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Deviating information of earlier versions is invalid.

### Special notice:

All information given on this data sheet is based on our knowledge and experience at the time of printing. The information is not binding. We advise to determine the suitability of our products with respect to their intended use and method of application. Therefore, a warranty claim cannot be granted.