

TECHNOMELT AS 5374

November 2014

PRODUCT DESCRIPTION

TECHNOMELT AS 5374 provides the following product characteristics:

Technology	Polyolefin
Product Type	Hotmelt
Cure	Physical setting
Condition	Thermoplastic, pressure sensitive
Components	One-component
Application	General assembly
Color	brown

Application Areas

TECHNOMELT AS 5374 is used for general assembly applications.

The product is especially suitable for bonding polypropylene or similar polyolefins, but shows excellent adhesion to polar substrates like PA, ABS and PBT as well.

TECHNICAL DATA

Technomelt AS 5374:

Softening point, °C	98
ASTM E28 (in glycerine)	
Melting Viscosity at 170 °C, mPas	2,200 to 3,000
ASTM D 3236 (RVT, spindle 27)	
Temperature creep resistance, °C	50
Henkel method MH 11	
Cold flexibility, °C	-10
ASTM D 3111	
Open Time	pressure sensitive

DIRECTIONS FOR USE

Preliminary Statement:

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Preparation:

The surfaces of the substrate must be dry and free from oil, grease and dust.

Application:

Application Temperature : 160 to 200 °C

Application System : Hotmelt application system with gear pump

When bonding to a substrate with high thermal conductivity the use of a specific application temperature is required for good wetting.

Do not heat the product above the specified application temperature range. When the product is not in use do not apply heat, this will degrade the quality of the product and in extreme cases cause carbonisation.

When the product is not in use do not apply heat, this will degrade the quality of the product and in extreme cases cause carbonisation. The standby temperature for the product is 60°C, but not longer than 72 hours.

Cleaning:

Carbonised and set (non thermoplastic) material must be removed mechanically. Removal of the thermoplastic material from the hot apparatus can be achieved with solvent free cleaning system, such as Technomelt 1960 (see separate technical information).

For the cold cleaning of surface soilings on application equipment, conveyor belts or other machine parts, Technomelt Cleaner Melt-O-Clean can be applied. Technomelt Cleaner Melt-O-Clean is based on natural resources and facilitates manual cleaning even in case of pronounced charring. Before using Technomelt Cleaner Melt-O-Clean, its suitability for lacquered and synthetic coated surfaces should be tested.

Classification:

Please refer to the corresponding **Material Safety Data Sheets** for details on:

Hazardous Information
Transport Regulations
Safety Regulations

Storage:

When properly stored in a cool, dry location, with the container tightly closed when not in use, this product will have a shelf life of at least 24 months.

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