

TECHNOMELT AS 3265

January 2021

PRODUCT DESCRIPTION

TECHNOMELT AS 3265 provides the following product characteristics:

Technology	EVA
Product Type	Hotmelt
Cure	Physical setting
Condition	Thermoplastic
Components	One-component
Application	General assembly
Color	Light yellow

Application Areas:

TECHNOMELT AS 3265 is used for general assembly applications, especially for bonding and coating aluminium foils in polyethylene and polyvinylchloride multi layer cable constructions.

TECHNICAL DATA

Technomelt AS 3265:

Softening point, °C	98 to 112
ASTM E28 (in glycerine)	
Melting Viscosity at 160 °C, mPas	3,800 to 6,200
Melting Viscosity at 170 °C, mPas	2,800 to 4,200
Melting Viscosity at 180 °C, mPas	2,450 to 3,550
Melting Viscosity at 190 °C, mPas	1,650 to 2,550
Melting Viscosity at 200 °C, mPas	1,300 to 2,100
ASTM D 3236 (RVT, spindle 27)	
T-peel strength at 22 °C; Al/Al	22 N/cm
T-peel strength at 22 °C; Al/Al (copolymer coated)	58 N/cm
ISO 11339 + ISO 6133 method B specimen width: 25 mm cross head speed: 50 mm/min**	
Water absorption, %	≤0.5
ISO 62 (method 1)	
Temperature creep resistance, °C	60 to 70
Henkel method MH 11	
Low temperature flexibility, °C	≤0
approx. ASTM D 3111	

**The T-peel strengths are typical and exemplary values. These values may vary when different substrates are used. Your own tests are unconditionally necessary.

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 180 °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. The standby temperature for the product is 80°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 PUR Cleaner 2 (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 **Safety Data Sheets** for details on:

Hazards identification

Transport information

Regulatory information

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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Reference 0.1