

## TECHNOMELT® AS 3278

Known as INSTANT-LOK® 3278  
April 2021

### PRODUCT DESCRIPTION

TECHNOMELT® AS 3278 provides the following product characteristics:

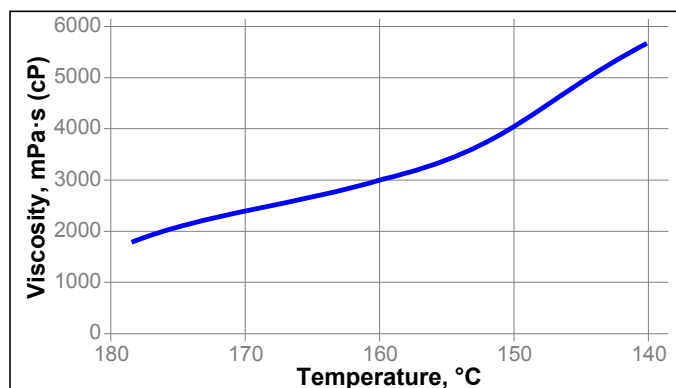
<b>Technology</b>	EVA
<b>Chemical Type</b>	Hot Melt Adhesive
<b>Cure</b>	Physical Setting
<b>Appearance</b>	White Pellet
<b>Components</b>	One-component
<b>Viscosity</b>	Medium
<b>Application</b>	Bonding, General Assembly and Filter Pleating
<b>Application Temperature</b>	140 to 170°C
<b>Specific Benefits</b>	<ul style="list-style-type: none"><li>• Good heat stability</li><li>• Strong bond strength</li><li>• Suitable for non-woven and paper substrates</li></ul>

TECHNOMELT® AS 3278 is a one-component industrial grade EVA Hot Melt Adhesive. Once applied TECHNOMELT® AS 3278 solidifies to form a tough, resilient adhesive with good heat stability and bond strength. Typical applications include excellent performance in air filter pleating assembly. It is a versatile adhesive for many substrates such as non-woven and paper.

### TYPICAL MATERIAL PROPERTIES

#### Physical Properties

Specific Gravity, @ 23°C ISO 1138	0.95
Softening point, °C Ring and Ball	106 to 117
Melting Viscosity- RVT, @ 170°C, mPa·s (cP) ASTM D3236: Spindle 27	1,800 to 2,500



### GENERAL INFORMATION

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or their strong oxidizing materials.**

**Please consult the Safety Data Sheet (SDS) for safe handling information of this product.**

### DIRECTIONS FOR USE

1. Use gloves to minimize skin contact. DO NOT use solvents for cleaning hands.
2. The surfaces of the substrate must be dry and free from oil, grease, and dust.
3. Hotmelt application system with gear pump recommended.
4. When bonding to a substrate with high thermal conductivity the use of a specific application temperature is required for good wetting.
5. Do not heat the product above the specified application temperature range.
6. When the product is not in use do not apply heat, this will degrade the quality of the product and in extreme cases cause carbonization or charring.
7. Carbonized material must be removed mechanically.
8. To internally clean the system add TECHNOMELT® PUR CLEANER 2 to reservoir and continue to purge material until it comes out blue in colour.
9. For cold cleaning of surface soiling on application equipment, conveyor belts or other machine parts TECHNOMELT® CLEANER MELT-O-CLEAN can be applied. It is based on natural citrus extract 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.

**Storage:**

Store product in the unopened container in a cool dry location. Storage information may be indicated on the product container labeling.

**Optimal Storage: Up to 28° C. Storage above 35° C can adversely affect the ability to handle and dispense the material.**

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Henkel representative.

**Product Specifications**

The technical data contained herein are intended as reference only and are not considered specifications for the product. Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

**Approval and Certificate**

Please contact Henkel representative for related approval or certificate of this product.

**Data Ranges**

The data contained herein may be reported as a typical value. Values are based on actual test data and are verified on a periodic basis.

Temperature/Humidity Ranges: 23°C / 50% RH = 23±2°C / 50±5 % RH

**Conversions**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\text{N} \times 0.225 = \text{lb/F}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{psi} \times 145 = \text{N/mm}^2$   
 $\text{MPa} = \text{N/mm}^2$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

**Disclaimer**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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**Reference 1**