

## TECHNOMELT AS 4225

May 2019

### PRODUCT DESCRIPTION

TECHNOMELT AS 4225 provides the following product characteristics:

<b>Technology</b>	EVA
<b>Product Type</b>	Hotmelt
<b>Cure</b>	Physical setting
<b>Condition</b>	thermoplastic
<b>Components</b>	One-component
<b>Application</b>	General assembly
<b>Color</b>	White, opaque

### Application Areas:

TECHNOMELT AS 4225 is used for general assembly applications, e.g. for the fixation of pleats in filter applications.

### TECHNICAL DATA

Density, g/cm <sup>3</sup> ISO 1183-1, 20°C	~1.0
Softening point, °C ASTM E28 (in glycerine)	117 to 123
Melting Viscosity at 160 °C, mPas ASTM D 3236 (RVT, spindle 27)	9,000 to 15,000
Viscosity at 160 °C, mPas	12,000
Viscosity at 170 °C, mPas	9,000
Viscosity at 180 °C, mPas	7,000
Open Time, 160°C secs Henkel method MH 46	16

### 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 systems

The product is applied by nozzle and slot die, foaming, spray- and roller application is possible as well.

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.

#### 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 Purmelt 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 **Material 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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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.

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