

TECHNOMELT AS 5376

November 2017

PRODUCT DESCRIPTION

TECHNOMELT AS 5376 provides the following product characteristics:

Technology	Polyolefin
Product Type	Hotmelt
Cure	Physical setting
Condition	Thermoplastic
Components	One-component
Application	General assembly
Color	white to light beige

Application Areas:

TECHNOMELT AS 5376 is used for general assembly applications, especially for bonding and coating polypropylene or similar polyolefins. Besides it is suitable to bond metals, especially copper and aluminium.

TECHNICAL DATA

Technomelt AS 5376:

Softening point, °C 142
ASTM E28 (in glycerine)

Melting Viscosity at 160 °C, mPas 11,000
Melting Viscosity at 180 °C, mPas 5,500
Melting Viscosity at 200 °C, mPas 3,500
ASTM D 3236 (RVT, spindle 27)

T-peel strength at 22 °C; PE/PE
ISO 11339 + ISO 6133 method B
specimen width: 25 mm
cross head speed: 50 mm/min* 25 N/cm
(untreated)

T-peel strength at 22 °C; PP/PP 25 N/cm
(untreated)

Low temperature flexibility, °C -40
ASTM D 3111

Shore A hardness 48
ISO 868/15s

Water absorption, % ≤0.2
ISO 62 (method 1)

Temperature creep resistance, °C 80
Henkel method MH 11

*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 : 180 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. The standby temperature for the product is 80°C, but not longer than 72 hours.

We recommend the following temperatures:

grid melter: 180 °C
hose heater: 190 °C
nozzle: 200 °C

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.

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.

Classification:

Please refer to the corresponding **Material Safety Data Sheets** for details on:
Hazards identification
Transport information
Regulatory information

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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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