

TECHNOMELT AS SP101

Known as INSTAWELD SP101
August 2018

PRODUCT DESCRIPTION

TECHNOMELT AS SP101 provides the following product characteristics:

Technology	Polyolefin
Product Type	Hotmelt
Application	Automotive Industry
Aspect	0.5 kg Easymelt block
Curing Condition	Physical Setting

Application Areas:

TECHNOMELT AS SP101 is a high softening point polyolefin hot melt use in automotive industry to bond PP, PC, PMMA without surface treatment.

It is use for taillight assembly.

TECHNICAL DATA

Density, g/cm ³	environ 1
Softening point	148°C (Mettler)
Viscosity (Thermosel Spindle 27 speed 10 rpm):	
• at 180°C : 13,000 ± 2,000 mPa.s	
• at 190°C : 7,000 ± 1,000 mPa.s	
• at 200°C : 3,500 ± 500 mPa.s	
Open time	10 ± 2 s at 180°C
SAFT	90°C
Recommended application temperature	180 to 200°C
• PP /PP : 1.5 N/mm ² cohesive failure	
• PC/PC :1.2 N/mm ² cohesive failure	
• PMMA/PMMA : 1.2 N/mm ² cohesive failure	
Lap shear 100 mm/min 1 mm thickness at 23°C:	
Elongation at break	20%
Heat resistance	50% of lap shear resistance at 60°C

Good ageing performance in water as in high humidity conditions

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

The product is applied by nozzle, slot die or roller.

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.

HOT MELT CLEANER Q 1924

For cold cleaning of surface soiling on application equipments as conveyor belt or other machine parts use.

TECHNOMELT CLEANER MELT O CLEAN

Storage:

Recommended Storage and Transportation Temperature, °C	+10 to +30
Shelf-life (in unopened original packaging)	24 months
Frost-Sensitive	yes

Packaging:

TECHNOMELT AS SP101 is in 0.5 kg Easymelt block
12 kg cardboard
384 kg palette

Classification:

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

Hazards identification

Transport information

Regulatory information



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