# Technical Information

# Technomelt Q 5303



Thermoplastic hotmelt adhesive
for assembly application

Basis: Polyolefin

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## Product Description

Technomelt Q 5303 is a thermoplastic hotmelt adhesive, based on Polyolefines.

## Application Areas

Technomelt Q 5303 is used for assembly applications, special for bonding of polypropylen and other polyolefines.

## Technical Data

| | | Method |
|---|---|---|
| Colour: | light beige | |
| Solids: | 100% | |
| Softening Point (R & B): | 118 - 130°C | ASTM E 28 |
| Viscosity (Brookfield, Spindle 27) | | |
| at 180°C: | 3.200 – 5.200 mPa.s | ASTM D 3236 |
| at 190°C: | 2.000 – 3.400 mPa.s | ASTM D 3236 |
| Application temperature: | 170 – 200°C | |

## Application

### Preliminary remark

Prior to application it is necessary to read the Safety Data Sheet for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labelling, the relevant precautions should always be observed.

### Preparation

The substrates must be dry, free of oil, grease and dust.

**Application**

Technomelt Q 5303 is applied by melting equipment with gear pump. The usual processing range is between 170 and 200°C.
While processing, take care to maintain a gentle thermal load by keeping to the recommended working temperature, since prolonged overheating or too often repeated melting will inevitably entail quality changes in the adhesive. The stated processing temperatures are standard values which, according to the processing method, may vary within certain limits.
Apply the adhesive as closely as possible to the site where the parts to be bonded are joined and in a thickness ensuring complete and intensive coating of both surfaces. When joining materials of different adhesive properties apply the adhesive to the surface which is more difficult to join, if possible. If this is not possible, it is advisable to raise the application temperature or increase the thickness of the adhesive layer applied.
Immediately after joining, keep the parts pressed together until the bonded join is held by the adhesive itself. The time which this requires is largely dependent on the recovery of the material to be bonded and the “hot tack” of the adhesive. If the join is parted even by some tenths of millimeters during the biding stage, a ridge is formed which leads to reduced load capacity of the join.

**Cleaning**

For the cleaning of the application equipment we recommend to use our cleaner V1960.

## Storage

| | |
|---|---|
| Frost-sensitive | No |
| Recommended storage temp. | 10°C to 35°C |
| Shelf-life | 24 months |

## Packaging

| | |
|---|---|
| Bags | 20 kg |

| | |
|---|---|
| **Hazard Indications/ Safety Recommendations/ Transport Regulations** | see Safety Data Sheet |

## Important

The above data, particularly the recommendations for application and use of our products are based on our knowledge and experience. Due to the different materials and conditions of application which are beyond our knowledge and control we recommend strongly to carry out sufficient tests in order to ensure that our products are suitable for the intended processes and applications. Except for willful acts any liability based on such recommendations or any oral advice is hereby expressly excluded.

**This Technical Data Sheet supersedes all previous editions.**

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