



# MACROMELT 2035

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## PRODUCT DESCRIPTION

MACROMELT 2035 provides the following product characteristics:

<b>Technology</b>	Polyamide
Product Type	Hotmelt
<b>Cure</b>	Physical setting
Condition	Thermoplastic
Components	One-component
<b>Application</b>	Filter
Color	Amber

## Application Areas

MACROMELT 2035 is used in many areas of the automotive filter industry. The adhesive is used mainly for fixing/ensuring of pleats and sealing of pleats in automotive air and oil filters.

## TECHNICAL DATA

### Macromelt 2035:

Softening point, °C	195 to 205
ASTM E28 (in glycerine)	
Melting Viscosity at 220 °C, mPas	3,500 to 6,500
ASTM D 3236 (RVT, spindle 27)	
Elongation, %	500
ISO 527, Specimen no.5	
Cross-head-speed: 50mm/min	
Yield Strength, N/mm <sup>2</sup>	10
ISO 527, Specimen no.5	
Cross-head-speed: 50mm/min	
Break Strength, N/mm <sup>2</sup>	13
ISO 527, Specimen no.5	
Cross-head-speed: 50mm/min	
E-modulus 2%, N/mm <sup>2</sup>	150
ASTM D 638	

## DIRECTIONS FOR USE

### Preliminary Statement:

Prior to application 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.

### Preparation:

The surfaces of the substrate must be dry and free from oil, grease and dust.

### Application:

Application Temperature : 210 to 240 °C  
 Application System : Hotmelt application systems  
 Application System : Hotmelt extruder system

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 130°C, but not longer than 72 hours. MACROMELT 2035 may absorb moisture from the air. This will not be apparent in the solid form, but may cause bubbles on heating and could affect the bond quality. It is important, therefore, that containers are kept closed and sealed when not in use.

Apply the adhesive as closely as possible to the side where the parts to be bonded are joined and in a thickness ensuring complete and intensive coating of both surfaces.

Immediately after joining, keep the parts pressed together until the bonded joint is held by the adhesive itself. The time which this requires is largely dependent on the recovery of the material to be bonded. If the joint is parted even by some tenths of millimeters during the binding stage, a ridge is formed which leads to reduced load capacity of the joint.

### 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 Macromelt 0062 (see separate technical information).

### Classification:

Please refer to the corresponding **safety data sheets** for details on:

#### Hazardous Information

#### Transport Regulations

#### Safety Regulations

### 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.

## ADDITIONAL INFORMATION

### Disclaimer:

The information provided herein, especially recommendations for the usage and the application of our products, is based upon our knowledge and experience. Due to different materials used as well as to varying working conditions beyond our control we strictly recommend to carry out intensive trials to test the suitability of our products with regard to the required processes and applications. We do not accept any liability with regard to the above information or with regard to any verbal recommendation, except for cases where we are liable of gross negligence or false intention.

This datasheet replaces all former versions.

Reference 0.0