

TECHNICAL – INFORMATION

Exakt 102-FT

PRODUCT DESCRIPTION: Exakt 102-FT is a light transparent hotmelt adhesive, based on EVA-Copolymer which can be used for many different substrates and elastic properties.

Application Areas: Exakt 102-FT is used for bonding in the graphic industry. Further applications are possible upon request.

Technical Data:

Method:

Colour:	light-transparent	
Density:	approx. 1,0 g/m ³	ASTM D 972
Solid (s) content:	100 %	
Softening Point : (R & B)	71 – 81 °C	ASTM E 28
Viscosity: (Brookfield, Spindle 27) at 160°C	1100-1400 mPa.s	ASTM D 3236
Application temperature:	145 – 180 °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 the 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:

Exakt 102-FT is preferably applied by nozzles or rollers. The usual processing range is between 145 and 180 °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 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 joint 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 joint 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 HM Blue and HM 48

Storage:

Frost-sensitive: No
Recommended storage temp.: 10°C to 20 °C
Shelf- life: 24 months

Packaging: 25 kg

Hazard Indications: see Safety Data Sheet
Safety Recommendations: see Safety Data Sheet
Transport Regulations: see Safety Data Sheet

