

# Technical Information

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Loctite - Teroson - Henkel

## MACROMELT Q 5355

<u>Type of Product:</u>	Hot melt adhesive based on polyolefins.	
<u>Field of application:</u>	Hot melt adhesive for general assembly applications, especially for bonding and coating polypropylene and copper.	
<u>Application system:</u>	Application system for hot-melt adhesives with a gear pump.	
<u>Material properties:</u>		
Colour:	lightbeige - brown	
Softening point:	141 ± 6 °C	ASTM E 28 (in Glycerine)
Melting viscosity:	180 °C 8500 ± 2500 mPa.s 190 °C 6500 ± 2000 mPa.s 200 °C 5000 ± 1500 mPa.s	ASTM D 3236 (RVT, spindle 27)
Temperature creep resistance:	120 ± 5 °C	Henkel-method MH-11
Low temperature flexibility:	<= -20 °C	approx. ASTM D 3111
Water-absorption:	<= 0,1 %	DIN 53495 (method 3)
T-peel strength: PP/PP (22 °C) Cu/Cu (22 °C) PE-X/PE-X (22 °C)	60 N/cm (untreated) 50 N/cm 30 N/cm (untreated)	DIN 53282 and DIN 53539 meth. C spec. width:25mm cross head speed:50 mm/min
	(The T-peel strengths are typical and exemplary values. These values may vary when different substrates are used. Your own tests are unconditional necessary.)	
Application temperature:	180 - 200 °C	

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<u>Handling suggestions:</u>	When substrates with high heat conductivity are bonded the use of a given application temperature is necessary for good wetting. The substrate surface should be free of dust and cleaned with a suitable solvent so that there is no fat and oil. Don't heat the product over the mentioned application temperature range. If the applicator is not used for longer than one hour, temperature must be reduced to avoid oxidation and degradation of the material. The optimal standby temperature is 80 °C, but not longer than 72 hours.
<u>Apparatus cleaning:</u>	Remove very strong coked and not thermoplastic rests of hot melt mechanical. We recommend a solvent free cleaning agent for the hot application apparatus like V 1940 (see separate technical information). Additionally we recommend our new cold-cleaner MELT-O-CLEAN® .
<u>Safety precautions:</u>	No health hazards are expected when Macromelt Q 5355 is in solid form. However, once melted it is like any hot liquid, which can produce severe burns. The appropriate safety precautions should be used (see also safety-data-sheet). If the molten adhesive has contacted your skin, cool the affected area immediately with cold water. Do not try to remove the adhesive from the skin. Go to your first aid station for attention.
<u>Regulations:</u>	Based on the data available, the products are not hazardous materials and according to EU-regulations they require no special labelling.
<u>Form of supply:</u>	Granules in cardboxes inside with PE-foil containing 15 kg net. Blocks per 0.5 kg in cardboxes with 12 kg net.
<u>Disposal:</u>	EAK code: 080404, cured adhesives and sealants.
<u>Storage:</u>	Up to max. +35 °C, min. 24 months in original closed container.

Information provided herein is based upon our practical knowledge and experience. Due to different materials used as well as to varying working conditions which are beyond our control we strictly recommend to carry out intensive trials. Any warranty and/or liability shall not be based on above information or personal consultation, except the contents of a consultation is explicitly confirmed by us in writing.