



### HM1580

**Type of Adhesive**

Polyamide hot melt adhesive

**Product Benefits**

Combines medium open-time, excellent high and low temperature properties, resistance to oil, many chemicals and solvents, and adhesion to a broad spectrum of difficult-to-bond substrates.

**Typical Applications**

Demanding product assembly operations.

**Suitable Substrates**

This product has shown good bonds with some preheated metals (tinplate, steel, aluminum, etc.), glass, ceramics, and a wide variety of plastics including PVC, nylon, Lexan (polycarbonate), PVC-acrylic, and some treated polyester surfaces. Additionally, it forms excellent bonds with wood, fabrics, leather, and other porous and fibrous substrates, but in all cases the user must conduct evaluation tests to determine suitability.

**Typical Properties**

Property	Value
RECOMMENDED APPLICATION TEMPERATURE	400 deg. F
WEIGHT PER GALLON	8.4 lb-mass/gal
SHELF LIFE	365 day
HERZOG RING & BALL SOFTENING POINT	291 deg. F
STATIC SHEAR 2 PSI LOAD (10F/HR)	219 deg. F
STRESS/STRAIN ELONG. AT BREAK	1,202 percent
STRESS/STRAIN ULT. TENSILE STR	838 lb-f/in <sup>2</sup>
VISCOSITY @ 350F (10.5)	20,500 cP
VISCOSITY @ 375F (10.5)	11,750 cP
VISCOSITY @ 400F	8,200 cP
VISCOSITY @ 410F	7,000 cP



### Application Instructions

This product requires an application temperature of at least 375F (190C), but for best results should be applied at 400-450F. Application by closed, melt-only-on-demand bulk systems, or by portable, stick-fed hot melt hand guns is recommended.

Any reservoir type of hot melt application equipment capable of maintaining the suggested adhesive temperature noted above, at the required melt rates. A nitrogen blanket is suggested to prolong adhesive pot life if, maximum pot life is desired.

1. Purge the previous hot melt adhesive from the equipment.
2. Set the equipment temperature and line speed to the above suggested settings.
3. Adjust the pump pressure for the desired bead diameter.
4. The open and set time characteristics may be modified with small adjustments to the bead diameter and equipment temperature settings.

### Cleaning Instructions

Consult the equipment manufacturer for cleanup procedures. After clean-up, flush the applicator thoroughly with hot melt to purge the system.

### Typical Packaging

Please contact your local Sales Office for available packaging options.

### Storage Conditions

We suggest that this product not be stored in areas where the ambient temperature will exceed 100 F. Storage of this product at temperatures exceeding 100 F may cause the product to block together, creating handling difficulties.

### Disposal Advice

Please refer to the MSDS for disposal instructions.

### Safety Advice

To minimize the risk of burns, we recommend the use of eye protection and protective clothing when working near a hot melt applicator. To minimize the risk of flammable vapors, do not exceed a melt temperature above 400F. Prevent the build-up of vapors. Extinguish all sources of ignition during hot melt use.

Please refer to the MSDS for additional safety advice.

**CAUTION: EXTREME CARE SHOULD BE EXERCISED**



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## TECHNICAL DATA SHEET

WHEN WORKING WITH HOT MELTS IN THEIR HOT, FLUID STATES. Severe burns will result if skin contact occurs. When moving a hot melt pot from one location to another, it is suggested that protective gloves be worn. If skin contact occurs, immediately immerse contact area in cold, clean water for at least 30 minutes. Cover contacted area with a wet, clean compress and see a physician immediately.

### Our Focus is Clear. Perfecting Adhesives.

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