



TEC-BOND 7718/12/250/BLACK HOTMELT ADHESIVE

**POWER
ADHESIVES**

DATA SHEET

GENERAL DESCRIPTION

TEC-BOND 7718/12/250/black is a polyamide hotmelt adhesive with a very low viscosity for potting and encapsulating that runs well through most 12mm glue guns.

The formulation is pigmented 'Black' to prevent the encapsulated components being visible.

The setting time is usually less than 2 minutes, but does depend on the amount and temperature of the adhesive applied. For small applications a setting time of 5-10 seconds is common.

The use of a hotmelt speeds up application as there is no mixing and any unused material remains in the glue gun ready for next time, so there is no waste.

Application by glue gun is quick, accurate and safe.

TECHNICAL CHARACTERISTICS

Adhesive type:	Synthetic polymer based hotmelt
Colour:	Black
Molten tack:	Medium

Diameter (Nominal)
 Length (Nominal)
 Carton Quantity
 Sticks per kilo (approx.)
 Suggested Application Temperature:
 Brookfield viscosity (ASTM D3236) @ 190°C spindle 27
 Ring & Ball Softening Point (ASTM E28)
 Heat Resistance (BS5350 Part H3)
 Open Time
 Low temperature flexibility (tg)
 Surface resistivity Mohm BS 6233
 Volume resistivity Mohm/mm BS 6233
 Breakdown voltage/Dielectric strength kV BS EN 60234-1
 Breakdown strength kV/mm BS EN 60234-1

	12mm	20mm	43mm	Bulk
Length (Nominal)	250mm	N/A	N/A	N/A
Carton Quantity	10x10 stick pack			
Sticks per kilo (approx.)	40			
Suggested Application Temperature:	190 - 215°C			
Brookfield viscosity (ASTM D3236) @ 190°C spindle 27	950 cps			
Ring & Ball Softening Point (ASTM E28)	160°C			
Heat Resistance (BS5350 Part H3)	135°C			
Open Time	Short			
Low temperature flexibility (tg)	-10°C			
Surface resistivity Mohm BS 6233	2.51 x 10 ⁹			
Volume resistivity Mohm/mm BS 6233	1.38 x 10 ⁹			
Breakdown voltage/Dielectric strength kV BS EN 60234-1	30			
Breakdown strength kV/mm BS EN 60234-1	15.6			

Please note, the test data recorded is the normal/typical value

SIZES AVAILABLE

12mm sticks

SUITABLE APPLICATORS

TEC 200
TEC 650, GASTEC 500
TEC 700,
TEC 901
Most other 12mm applicators

TYPICAL OUTPUT

0.5 Kg/hr
0.7 Kg/hr
1.4Kg/hr
2.0 Kg/hr

This product has been tested and complies with UL V0 fire retardency requirements.

Important Note.

This is a polyamide-based material and consequently will absorb a small amount of moisture from the atmosphere. This does not affect the performance and all test data relates to fully saturated material. However, even a small amount of moisture contamination will turn into a large amount of steam at glue gun temperature. This will cause the glue gun to drip, foam and glue stick to back up.

Please keep the adhesive sealed in the special packs provided. Moisture contaminated adhesive may be dried in an oven at 70°C for 24-48 hours.

HEALTH & SAFETY

Hotmelt adhesives pose virtually no hazards to health when used in normal industrial practice, but because they are used in a molten state at high temperatures there is a risk of thermal burns. Skin contact with molten hotmelt should be avoided and precautions taken against accidental splashes of adhesive. The use of overalls, cotton gloves and safety glasses help minimise the risk of burns.

INHALATION: Vapours given off during normal operation are not considered toxic, but if overheated, chemical breakdown of the components may occur releasing a complex mixture of organic materials, some of which may be toxic or irritant. Ensure hotmelts are run at the recommended operating temperatures and use in a well-ventilated area.

EYE CONTACT: For solid hotmelt treat as inert particles and irrigate copiously with clean fresh water. For molten hotmelt irrigate with cold water and seek medical advice immediately.

SKIN CONTACT: Solid cold hotmelt is harmless to the skin. Wash hands with soap and water. Skin affected by molten hotmelt should be plunged into cold water immediately and left until the burning sensation subsides. If no tap is accessible have a bucket of clean cold water available. If coated with hotmelt move fingers to prevent a tourniquet effect as it cools. Do not remove the adhesive when molten as it might remove skin to quite a depth leaving a raw wound. Even when solid remove with care as the above may still occur. If difficult to remove, with medical approval, olive oil or liquid paraffin should be soaked into a cotton wool pad and placed over the affected area. This will slowly soften the adhesive into the pad. When hotmelt is removed treat as a normal burn.

FIRE: Not normally a hazard, but in a fire hotmelts are combustible, use dry powder or CO2 extinguisher. Do not use water.

STORAGE

Store in a clean dry place at temperatures between 5°C and 30°C with boxes closed. Do not expose to direct sunlight or localised heat sources such as radiators or hot pipes.

REMOVAL OF GLUE

Assembled components can be separated by heating assembly to a temperature slightly above the heat resistance figure.

EVA & POLYPROPYLENE: Residues of EVA and polypropylene based hotmelts can be removed from components with white spirit.

POLYAMIDE: Residues of Polyamide based hotmelt can be removed from components with acetone.

PLEASE NOTE

The information contained on this data sheet is for guidance only. It is the result of careful laboratory evaluations by trained and qualified staff using British Standard or similar test methods. However, no warranty is expressed or implied regarding the accuracy of the data or the suitability of the adhesive for any specific purpose. In every case, we strongly recommend that the user shall make their own test to determine to their own satisfaction the suitability of the adhesive for their particular purpose. Neither seller nor manufacturer shall be liable for any injury, loss, damage, direct or consequential arising out of the use or inability to use the product. Further information is always available to help solve your adhesive problems. Should you require any further information on our adhesives or applicators please contact your nearest distributor.

