

TECHNOMELT AS 5373

Known as Macromelt Q 5373
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PRODUCT DESCRIPTION

TECHNOMELT AS 5373 provides the following product characteristics:

Technology	Polyolefin
Product Type	Hotmelt
Cure	Physical setting
Condition	Thermoplastic
Components	One-component
Application	General assembly
Color	white to light beige

Application Areas:

TECHNOMELT AS 5373 is used for general assembly applications, especially for bonding and coating polypropylene or similar polyolefins.

TECHNICAL DATA

Technomelt AS 5373:

Softening point, °C ASTM E28 (in glycerine)	143 to 153
Melting Viscosity at 160 °C, mPas	75,000 to 125,000
Melting Viscosity at 170 °C, mPas	49,000 to 81,000
Melting Viscosity at 180 °C, mPas	35,000 to 55,000
Melting Viscosity at 190 °C, mPas	25,000 to 39,000
Melting Viscosity at 200 °C, mPas ASTM D 3236 (RVT, spindle 27)	18,000 to 28,000
T-peel strength at 22 °C; PP/PP ISO 11339 + ISO 6133 method B specimen width: 25 mm cross head speed: 50 mm/min*	≥70 N/cm (untreated)
Low temperature flexibility, °C approx. ASTM D 3111	-10
Water absorption, % ISO 62 (method 1)	≤0.1
Temperature creep resistance, °C Henkel method MH 11	110

*The T-peel strengths are typical and exemplary values. These values may vary when different substrates are used. Your own tests are unconditionally necessary.

DIRECTIONS FOR USE

Preliminary Statement:

Prior to use 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. Please also refer to the local safety instructions and contact Henkel for analytical support.

Preparation:

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

Application:

Application Temperature : 160 to 200 °C
Application System : Hotmelt application system with gear pump

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 90°C, but not longer than 72 hours.

We recommend the following temperatures:

grid melter: 180 °C
hose heater: 190 °C
nozzle: 200 °C

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 Technomelt 1960 (see separate technical information).

For the cold cleaning of surface soilings on application equipment, conveyor belts or other machine parts, Technomelt Cleaner Melt-O-Clean can be applied. Technomelt Cleaner Melt-O-Clean is based on natural resources and facilitates manual cleaning even in case of pronounced charring. Before using Technomelt Cleaner Melt-O-Clean, its suitability for lacquered and synthetic coated surfaces should be tested.

Classification:

Please refer to the corresponding **Material Safety Data Sheets** for details on:

Hazards identification
Transport information
Regulatory information



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.

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