

HM-1004

Hot melt adhesive



DAEHEUNG CHEMICAL

HM-1004 is glue stick that can be used for various industries, including stationery, toy, accessory and automobile(interior).

1. Characteristics

- The initial adhesion is excellent.
- The bonding time within 10 seconds of working time will be shortened.
- There is no harm to the human body as a solventless type is no risk of fire.
- Working in cold area is possible because of its excellent cold resistance.
- Very good wetting and flowing.
- It can be adhered to various materials, and by using the Glue Gun possible precision part adhesive.

2. Uses

- Edge of the paper can adhesive.

3. Physical properties

Properties	Value
Main component	EVA
Color	White & Stick type
Melt viscosity	11,000±1,000 cps (at 180 °C)
Softening point	83±2 °C (Ring & Ball method)
Work temperature	170~190 °C
Open time	3~10 sec (23 °C)
Set time	5~10 sec (23 °C)

4. How to use

(1) Heat the machine for about 10minutes and begin work after check up of working temperature.

- Using product before arrival of working temperature cause a adhesive badness.
- Working temperature: 160~180 °C
- ※ Caution: In winter, raise temperature about 10 °C for prevention of badness.

When you stop the work for a long time, you ready to work under 160 °C.

If the work temperature is over 210 °C, the product can smell acetic acid.

(2) Working speed: 14~24m/min

(Working speed is different according to use temperature and season, quantity for application)

(3) Press products enough after adhesion for prevention of adhesive badness.

- (Adhesion) Role pressure: 3kg/cm² (about 42psi)

(4) Product is store in a cool and dry place.

5. Packaging

- 700g

Please contact us for further information or see Material Safety Data Sheet (MSDS) for this product.

DAEHEUNG CHEMICAL CO., LTD.

68, Sandan-ro, 64beon-gil, Pyeongtaek-si, Gyeonggi-do, Korea.

Telephone +82-2-554-8211, +82-31-668-1424

Facsimile +82-2-554-8215, +82-31-668-1425

Website www.dhcbond.co.kr



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