TECHNOMELT

Technical Data Sheet

TECHNOMELT AS 5303

Known as Technomelt Q 5303
December 2022

PRODUCT DESCRIPTION

TECHNOMELT AS 5303 provides the following product characteristics:

Technology	Polyolefin
Product Type	Hotmelt
Appearance	Light beige

TECHNOMELT AS 5303 is a thermoplastic hotmelt adhesive, based on Polyolefines.

Application Areas:

TECHNOMELT AS 5303 is used for assembly applications, especially for bonding of polypropylen and other polyolefines.

TECHNICAL DATA

(as supplied)

Colour	light beige
Solid content, %	100
Softening point, °C (R&B) ASTM E 28	118 to 130
Viscosity Brookfield, Spindle 27	
at 180°C, mPa.s ASTM D 3236	3,200 to 5,200
at 190°C, mPa.s ASTM D 3236	2,000 to 3,400
Application temperature, °C	170 to 200

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 substrates must be dry, free of oil, grease and dust.

Application:

TECHNOMELT AS 5303 is applied by melting equipment with gear pump.

The usual processing range is between 160 to 200°C.

While processing, take care to maintain a gentle thermal load by keeping the recommended working temperature range, because overheating or too often repeated melting may cause quality changes in the adhesive.

The stated processing temperatures are standard values which, according to the processing method, may vary within certain limits.

Apply the adhesive as closely as possible to the site where the parts to be bonded are joined and in a thickness ensuring complete and intensive contact to both surfaces.

When the materials which are bonded have different adhesion properties apply the adhesive to the surface which is more difficult to bond.

If this is not possible, it is recommended to increase the application temperature and/or the thickness of the adhesive layer applied.

Immediately after joining, keep the parts together until the bonded join is held by the adhesive itself.

The required fixing time is depending on the recovery force of the material to be bonded, the “hot tack” and the solidification properties of the adhesive.

Cleaning:

For the cleaning of the application equipment we recommend to use our TECHNOMELT 1960.

Storage:

Frost-sensitive	no
Recommended storage temperature, °C	10 to 35
Shelf-life, months (in unopened original packaging)	24

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

- **Hazards identification**
- **Transport information**
- **Regulatory information**

ADDITIONAL INFORMATION

Disclaimer

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