

TECHNICAL DATA SHEET

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ACROMELT ST 94**GENERAL CHARACTERISTICS / MAIN USE :** Special PSA hot-melt adhesive, high heat resistance, for automotive

ACROMELT ST 94 is a versatile PSA hot-melt with especially high heat resistance which makes it suitable for production of various automotive interior parts. Adhesive combines high initial adhesion with high cohesion properties in a wide temperature range. Therefore it can be used in many industries such as automotive, transportation, marine, building, etc. Adhesive film is sticky and can be applied on textiles, back foamed textiles, carpets, various polyurethane composites, foams, polymers, metals, wood, laminates, nonwoven, cardboard and decorative parts with self-sticky backsides.




TECHNICAL PROPERTIES OF PRODUCT :

Chemical base	Synthetic thermoplastic rubber and resins.
Colour	Clear / amber (honey-like).
Consistency	Liquid and easy to apply by most standard hot-melt equipment at +160°C to +180°C.
Viscosity Brookfield	~ 5500 mPa.s at 180°C (Spindle 27)
Density	~ 1,00 g/cm ³
Softening temperature	~ +130°C (Ring & Ball, ASTM E-2867)
Solid content	100 %
Application temperature	~ +160°C to +180°C (standard conditions - short time at 190°C is acceptable)
Temperature resistance	Up to +90°C (initial testing has to be done according to requirements for each use)
Film properties	High initial adhesion combined with high cohesive strength at medium-high temperature. Used raw materials compliant with FDA regulations 21, section 175.105.
Cleaning	Use of Acroclean W 200 is recommended for occasional cleaning of melting & application systems.

PREPARATION AND PROCESSING :

Materials and Surfaces	The surfaces to be coated must be clean, dry, stable and free of any dust, oil and grease. Store materials and process in dry places and not below +15°C. This adhesive is not suitable for plasticized materials or substrates (potential risk of migration). Our technical department is available for any technical advice or initial testing on special materials.
Processing	After being heated up at required temperature level with appropriate melting equipment, apply by extrusion, coater, spraying or any other method either directly on one material side (best on side which is most difficult to bond) or in a transfer procedure on silicon paper or siliconized polyethylene foil. In the case of coatings with self-sticky backsides, the protector foil is acting as an anti-adhesion layer which preserves from dust. After removing protective film, adhesive layer has then to be pressed on second material for final bonding. Please investigate precisely with your engineering department the best process parameters (quality, weight, thickness) according to your special requirements. In case of longer periods of production stop, drop melting temperature down to approximately 100-120°C in order to prevent useless, excessive oxidation of adhesive. For any required additional questions, please contact our technical department.
Cleaning	Use of Acroclean W 200 is recommended for occasional cleaning of melting & application systems.

RECOMMENDATIONS / STORAGE / SAFETY :

Storage	≤ 24 months (≤ +25°C) in a dry place, tightly closed original packaging which has to be protected from direct sunlight, heat and high moisture.
Packaging / transport	Cardboards containing 15 kg adhesive in small pillows for easy handling. Drums on demand. ADR Classification: void.
Handling precaution	Before first using, read carefully Material Safety Data Sheet (available on request). Pictograms indicating the obligation of wearing personal protective equipment:   
Handling precaution	Before first using read carefully Material Safety Data Sheet which is available on request.
Labelling CLP regulation Hazard Pictograms / Signal word void	Hazard statements: void. General information: Take the regular precautions for handling and processing chemical products. Assure sufficient ventilation during processing. Avoid any direct skin contact with hot adhesive (risk of severe burns). Wear protective gloves and glasses. For professional / industrial use only.
General Information	The foregoing information represents values obtained in our laboratory and has been supplied in good faith, it shall not be construed to be legally binding, in particular, it shall not exempt the purchaser from taking responsibility for testing the product supplied so as to determine its suitability for the intended application. Given the high number of materials appearing on the market and the different methods of use, which are beyond our influence and control, we cannot accept any responsibility for the results of your work. Warranty is made exclusively for the constantly high quality of our products. Please note our terms of sales, delivery & payment.