



## HM-1238 HMPSA for Label

### *Technical Data Sheet*

#### **Product description:**

HM-1238 is pressure sensitive hot melt adhesive for labels. With great loop tack and holding power, good balance of peel, great die-cutting performance, excellent resistance to low temperature and ageing, HM-1238 can be used in automatic labeling at high speed.

#### **Physical properties:**

Composition:	Synthetic resin
Appearance:	yellow opaque
R&B softening point:	approx. 105 °C
Brookfield viscosity:	165 °C-----about 14000 mps 175 °C-----about 11000 mps 185 °C-----about 8000 mps
Density:	0.98 g /cm <sup>3</sup>
Toxicity:	none

#### **Technical data:**

Pressure sensitive properties of a 23g/m<sup>2</sup>-coating on 21g/m<sup>2</sup> carbon paper  
(23 ± 2 °C , 50 ± 10%Rh)

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#### **180 °C peel adhesion to steel (FTM 1)**

After 20min: 20-28N/inch

After 24 H: 20-28N/inch

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#### **Loop tack on steel (FTM 9)**

20-28N/inch

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#### **Shear adhesion to steel (FTM 8)**

23 °C :>24H with 1 kg/inch<sup>2</sup>

40 °C :2H with 1 kg/inch<sup>2</sup>

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#### **Shear adhesion failure temperature on steel (SAFT)**

0.5 °C/min;0.5kg/inch<sup>2</sup>,approx 65 °C

#### **Application Instructions:**

Its adhesion performance will be affected by substrates, release paper and application environment, so trial run is necessary to determine whether the adhesive is suitable.

There should be no dust or oil on the surface of substrates and release paper, also the substrates and release paper should be treated to constant temperature and humidity before application.

Application methods: roller or spray

Operating temperature: the 160-180 °C, is recommended in the glue viscosity can be adjusted by the temperature of summer appropriate Down 5-10 °C, raised 5-10 °C in winter.

Application-temperature of the labels between +8 °C and 35 °C, Temperature resistance of the applied label from -10 °C to +45 °C

Foshan NanPao Advanced Materials Co., Ltd.

No.12, Kele Avenue , Leping Town, Sanshui District, Foshan City, Guangdong Province, China

Tel:(+86-757)87393000/87393049

Fax:(+86-757)87393047



**Packaging and Storage :**

Shelf Life: 24 Months in dry and cool environment

Packaging: 20kg/Box,5kg/cake

**Cleaning:**

The residual adhesive can be rubbed off by wooden shovel before it is totally cooled.

Cooled glue can

be cleaned with specialized detergent. Applicators can be cleaned with mineral oil at 120°C,  
then purged with hot melt adhesive.

**Warnings:**

Don't mix the product with other adhesives.

Keep the adhesive containers covered to avoid dust or contamination.

Stop heating if you don't use it for a long time to avoid the carbonization of the adhesive

Wear safety glasses, safety gloves and safety clothes when using hot melt adhesive to avoid scald..

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