



HM-229 BOPP Tape HMA

Technical Data Sheet

Product description:

HM-229 is pressure sensitive hot melt adhesive. With good initial tack and high cohesion strength designed for BOPP packing tape. Good thermal stability and high holding power at 40C.

Physical properties:

Composition:	Synthetic resin
Appearance:	yellow translucent
R&B softening point:	approx. 115 °C
Brookfield viscosity:	165 °C-----about 12800 mps 175 °C-----about 9000 mps 185 °C-----about 7200 mps
Density:	0.98 g /cm ³
TG point:	approx.2 °C
Toxicity:	none

Technical data:

Pressure sensitive properties of a 23g/m²-coating on 21g/m² polyester film
(23 ± 2°C, 50 ± 10%Rh)

180 °C peel adhesion to steel (FTM 1)

After 20 min: 22-30N/inch

After 24 H: 22-30N/inch

Loop tack on steel (FTM 9)

22-28N/inch

Rolling ball (PSTC 6)

Approx 20cm

Shear adhesion to steel (FTM 8)

23 °C :>72H with 1 kg/inch²

40 °C :>24H with 1 kg/inch²

Shear adhesion failure temperature on steel (SAFT)

0.5 °C/min;0.5kg/inch²,approx 75 °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

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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 +10 °C and 50 °C, Temperature resistance of the applied label from -20 °C to +60 °C

Packaging and Storage:

Shelf Life: 24 Months in dry and cool environment

Packaging: 20kg/Box, 1kg/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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