

SikaMelt[®]-9255

The high cohesion removable PSA Hot Melt with low glass transition temperature

Technical Product Data

Chemical base	Thermoplastic rubber
Colour	Yellowish, clear
Cure mechanism	Physical hardening
Density (CQP 006-7)	1,0 kg/l approx.
Solid content	100%
Viscosity at 190°C (Brookfield Thermosel)	22000 mPas approx.
Softening temperature (CQP 538-5)	120°C approx.
Application temperature	170 - 200°C
Shear adhesion failure temperature SAFT (CQP 560-1)	85°C approx.
Peel strength (CQP 568-1)	15 N/25 mm approx.
Shelf life (storage below 25°C in sealed container) An excess of the recommended storage temperature during transport is not critical.	12 months after production

¹⁾ CQP = Corporate Quality Procedure

²⁾ 23°C / 50% r.h.

Description

SikaMelt[®]-9255 is a high cohesion pressure sensitive hot melt adhesive based on thermoplastic rubber. It has very high tack, strong initial adhesion, low glass transition temperature and excellent cohesion properties.

SikaMelt[®]-9255 is manufactured in accordance with ISO TS 16949 / ISO 14001 quality assurance system and the responsible care program.

Product Benefits

- Good tack
- High peel strength
- Low glass transition temperature
- High cohesion
- Solvent free

Areas of Application

SikaMelt[®]-9255 is suitable to equip paper-, polymer- and metal foils, textiles, foams and a big variety of other materials with self-sticky backsides.

If soft foils as substrates contain monomeric plasticizer, SikaMelt[®]-9255 should not be used.

This product is suitable for professional experienced users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Industry



Cure Mechanism

SikaMelt®-9255 is a physically hardening adhesive.

Chemical Resistance

SikaMelt®-9255 is resistant to water, weak acids and caustic solutions. As the chemical resistance depends on type and condition of the substrate, chemical concentration, exposure duration and temperature, a project adapted adhesive performance test is strongly recommended. The above information is offered for general guidance only. Advice on specific applications will be given on request.

Method of Application

Surface preparation

Bonding area must be clean, dry and free from grease, oil and dust. Adhesion can be improved by suitable substrate pre-treatment. Advice on specific applications is available from the Technical Service Department of Sika Industry.

Application

SikaMelt®-9255 can be applied directly or in a transfer procedure by appropriate melting equipment out of containers, and out of drums for film, spot-, bondline- or spray-application. For automated application a suitable filter system is required.

If applied directly, SikaMelt®-9255 is distributed homogeneously on the substrates and let cool down. If applied via transfer, SikaMelt®-9255 is distributed first on a silicon-paper or foil. The substrate has to be pressed into the adhesive layer. The silicon paper / foil acts as a protective layer. After removing it the adhesive layer has been transferred to the substrate. Transfer application is especially used for bonding of porous or strongly absorbing materials like foams.

The adhesive surface has to be protected against dust, light and oxygen. Therefore it is necessary to cover the adhesive film with a silicon paper or foil. Only suitable silicon papers or foils for pressure sensitive adhesives should be used.

Standstill periods for several hours or over night have to be avoided, especially at temperatures above 120°C. During longer periods of interruption (<48h) the equipment temperature has to be lowered to 80°C.

To avoid ageing reactions the liquid adhesive material has to be stored under nitrogen or carbon dioxide.

The adhesive viscosity is dependent on the temperature. For application the adhesive viscosity can be adjusted by changing the temperature (see diagram).

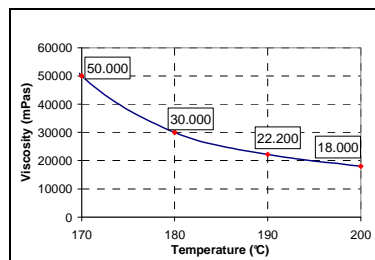


Diagram 1: Viscosity of SikaMelt®-9255 as a function of temperature

For advice on selecting and setting up a suitable pump system please contact the System Engineering Department of Sika Industry.

Removal

The melting reactors can be cleaned with SikaMelt®-9901 or other commercially available cleaning resins. SikaMelt®-9255 may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Hands and exposed skin should be washed immediately using Sika® Handclean Towel or a suitable industrial hand cleaner and water. Do not use solvents!

Further Information

Copies of the following publications are available on request:

- Material Safety Data Sheets

Packaging Information

Box	4 kg
Box	8 kg
Drum	160 kg

Value Bases

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

Health and Safety Information

For information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

Legal Notes

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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