Teroson

Technical Data Sheet

Reammide PAS 5035

Thermoplastic Hot-Melt Adhesive
for fixing and sealing of pleats in
automotive filters

Base: Polyamide

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Product Description

Reammide PAS 5035 is an amber-coloured, polyamine-based hot-melt adhesive.

Application Areas

Reammide PAS 5035 is an universal hot-melt adhesive, which is used in many areas of the automotive filter industry. The adhesive is used mainly for fixing/ensuring of pleats and sealing of pleats in automotive air and oil filters.

Technical Data

Colour:	amber
Softening point (ASTM E 28):	195 - 205°C
Viscosity (ASTM D 3236):	3.500 - 6.500 mPa.s
Temperature:	220°C
Elongation at break:	approx. 500 %
Yield point (ASTM D 1708):	approx. 10 N/mm^2
Shear strength (ASTM D 1708):	approx. 13 N/mm^2
E-modulus (ASTM D 638):	approx. 150 N/mm^2

Preliminary statement

Prior to application it is necessary to read the **Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labelling, the relevant precautions should always be observed.

Preparation

The surfaces of the substrates must be dry and free from oil, grease and dust.

Application

Use hot-melt adhesive applicators to process Reamide PAS 5035. The product is special suitable for extruder hot-melt applicators. The usual processing range is between 210 and 240°C.

While processing, take care to maintain a gentle thermal load by keeping to the recommended working temperature. Avoid overheating above the given processing temperature since, if prolonged or repeated, it may lead to reduction of quality and - in extreme cases - to carbonization of the hot-melt adhesive.

Do not leave the melted adhesive in the applicator for several hours at processing temperature without extraction. During breaks in work the temperature of the hot-melt adhesive should be lowered to approx. 90°C in the entire applicator, but not for longer than 72 hours. Refill the quantity of granules used, taking care that the melting pan is filled. Avoid loading with the wet material (due to uptake of moisture from the air) since moist hot-melt adhesive tends to foam. This causes a foam-like structure of poor solidity when cooled. Therefore, be sure to close the container tightly again after extraction.

Apply the adhesive as closely as possible to the side where the parts to be bonded are joined and in a thickness ensuring complete and intensive coating of both surfaces. When joining materials of different adhesive properties apply the adhesive to the surface which is more difficult to join if possible. If this is not possible, it is advisable to raise the application temperature or increase the thickness of the

adhesive layer applied. Also, the stated processing temperature should be maintained as otherwise sufficient coating - particularly of substrates with good heat conductivity - is not ensured.

Immediately after joining, keep the parts pressed together until the bonded join is held by the adhesive itself. The time which this requires is largely dependent on the recovery of the material to be bonded. If the join is parted even by some tenths of millimeters during the binding stage, a ridge is formed which leads to reduced load capacity of the join.

Storage

Frost-sensitive	no
Recommended storage temperature	10°C to 20°C
Shelf-live	24 months in original packaging

Packaging

Bag	25 kg
Big Bag	500 kg

Hazard Indications/ Safety Recommendations/ Transport Regulations	see Safety Data Sheet

Important

The data above, particularly the recommendations for application and use of our products is based on our knowledge and experience. Due to different materials and conditions of application which are beyond our knowledge and control we strongly recommend carrying out sufficient tests in order to ensure that our products are suitable for the intended process and applications. Except for wilful acts any liability based on such recommendations or any oral advice is hereby expressly excluded.

This Technical Data Sheet supersedes all previous editions.

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