

technical datasheet

General description

FOUNDRY TEC 705 has been developed to bond sand cores when a very high heat resistance is required, it allows sand cores to be dried at much higher oven temperatures. It is polyamide based and has a highest heat resistance of all the FOUNDRY TEC adhesives.

It is low char and will provide fast heat resistant bonds on large and small sand cores.

This is polyamide-based material and consequently will absorb a small amount of moisture from the atmosphere. This does not affect the performance and all test data relates to fully saturated materials

Please keep the adhesive sealed in the special packs provided. Moisture contaminated adhesives may be dried in an oven at 158°F for 24-48 hours.

Technical characteristics

Adhesive type: Synthetic Polymer Based Hotmelt
 Colour: Light Brown
 Molten tack: Medium

	1/2"	5/8"	1 3/4"	Bulk
Form	1/2" x 12"	5/8" x 12"	1 3/4" x 1 3/4"	Prills
Sticks per lb (approx)	18	11	8	
Carton quantity	22lb(4x5 1/2lb foil bag)	22lb(4x5 1/2lb foil bag)	22lb (Tub)	44lb
Pallet weight:	1100lb	1100lb	1100lb	2200lb
Suggested application temperature	380-420°F	380-420°F	380-420°F	380-420°F
Brookfield viscosity (POW-12-VISC) spindle 27	5500 @ 375°F	5500 @ 375°F	5500 @ 375°F	5500 @ 375°F
Ring & ball softening point (ASTM E28)	310°F	310°F	310°F	310°F
Heat resistance (BS5350 Part H3)	275°F	275°F	220°F	220°F
Open time	Medium	Medium	Medium	Medium
Low temperature flexibility (tg)	14°F	14°F	14°F	14°F
Applicators or hotmelt system	<input checked="" type="checkbox"/> Tec 150-12 <input type="checkbox"/> Tec 150-12LM <input checked="" type="checkbox"/> Tec 175-12 <input type="checkbox"/> Tec 175-12LM <input checked="" type="checkbox"/> Tec 250-12 <input type="checkbox"/> Tec 250-12LM <input checked="" type="checkbox"/> Gastec 100 <input checked="" type="checkbox"/> Gastec 300 <input checked="" type="checkbox"/> Gastec 500 <input checked="" type="checkbox"/> Tec 810-12 <input type="checkbox"/> Tec 810-12LM	<input checked="" type="checkbox"/> Tec 810-15 <input type="checkbox"/> Tec 810-15LM	<input checked="" type="checkbox"/> Tec 3150-43 <input type="checkbox"/> Tec 3150-43LM <input checked="" type="checkbox"/> Tec 3200-43 <input checked="" type="checkbox"/> Tec 6100-43 <input type="checkbox"/> Tec 6300-43 <input checked="" type="checkbox"/> Tec 7100-43 <input type="checkbox"/> Tec 7300-43	<input checked="" type="checkbox"/> Bulk tank <input type="checkbox"/> Spray <input checked="" type="checkbox"/> Jet <input checked="" type="checkbox"/> Slot coater <input checked="" type="checkbox"/> Roller <input type="checkbox"/> PUR system

F.D.A. approved. All the constituent parts of this adhesive have been approved by the American F.D.A. under C.F.R. 21.175.105 (adhesives) (subject to limitations).

Tecbond Reference	Description	1/2"	5/8"	1 3/4"	CT	Bulk
5	High delivery, low viscosity, long open time. Product assembly adhesive.	•		•	•	•
14	High delivery, very fast setting packaging adhesive.	•	•	•		
1942	Product assembly adhesive for wood and many plastics.	•	•	•		
1X	Low viscosity, wood working & packaging adhesive. Medium open time.	•		•		
213	Economical, general purpose adhesive.	•	•	•		
214	Economical, fast setting, packaging adhesive.	•	•	•		
23	Medium viscosity multipurpose adhesive.	•	•	•		
232	Economical, clear, general purpose adhesive.	•	•	•		
232 Coloured	Coloured, medium open time, general purpose adhesive. Brown, Green, White, Black, Blue, Gold, Silver, Red, Yellow.	•				
232 Glitter	Multicolour, Red, Green, Silver, Gold.	•				
240	High delivery, long open time, multipurpose, clear adhesive.	•	•	•		
246	Clear and black versions, high performance, gap filling, difficult surfaces, dent pulling.	•				
260	High performance, long open time, tough, flexible adhesive.	•	•	•		
265	Long open time product assembly adhesive for smooth and shiny surfaces.			•		
267	High heat resistant, medium open time, product assembly adhesive.			•		
2169	Peelable adhesive, low tack, non-migrating, CD & credit card attachment, glue dots.				•	•
342	High viscosity, fast setting, white adhesive.	•		•		
410	Pallet stabilisation spray adhesive			•		
420	General purpose spray adhesive.			•		
425	High delivery, high performance, spray adhesive.			•		
430	High performance, long open time spray adhesive.			•		
4741	Full pressure sensitive, very aggressive, multipurpose, paper & plastic materials.				•	•
7718	Coloured, low viscosity, potting, encapsulation & knot filling / wood repair polyamide adhesive.	•	•			
7784	High temperature resistant multipurpose polyamide adhesive.	•	•	•		
7785	High temperature & chemical resistant multipurpose polyamide adhesive.	•	•	•		
9010	Reactive hotmelt. Heat & chemical resistant bonds, rigid bond, once set does not reactivate with heat.				•	
9030	Reactive hotmelt. Heat & chemical resistant bonds, flexible bond, once set does not reactivate with heat.				•	
LM44	Lowmelt, fast setting, high performance, white adhesive.	•		•		

Storage Store in a clean dry place at temperatures between 41°F and 86°F with boxes closed. Do not expose to direct sunlight or localised heat sources such as radiators or hot pipes.

Removal of glue Assembled components can be separated by heating assembly to a temperature slightly above the heat resistance figure.

EVA & Polypropylene: Residues of EVA and polypropylene based hotmelts can be removed from components with white spirit.

Polyamide: Residues of polyamide based hotmelt can be removed from components with acetone.

PUR: Prior to cross linking adhesive can be removed with white spirit or ketone. Once fully cross linked the adhesive cannot be easily removed.

Please note The information contained on this data sheet is for guidance only. It is the result of careful laboratory evaluations by trained and qualified staff using British Standard or similar test methods. However, no warranty is expressed or implied regarding the accuracy of the data or the suitability of the adhesive for any specific purpose. In every case, we strongly recommend that the user shall make their own test to determine to their own satisfaction the suitability of the adhesive for their particular purpose. Neither the seller nor manufacturer shall be liable for any injury, loss, damage, direct or consequential arising out of the use or inability to use the product. Further information is always available to help solve your adhesive problems. Should you require any further information on our adhesives please contact your nearest distributor.