

PRODUCT DATA SHEET

SikaMelt[®]-285 MC

High strength pressure sensitive hot melt for assembly

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Thermoplastic rubber
Color (CQP001-1)	Light honey color, clear or opaque
Cure mechanism	Physical hardening
Density (uncured)	0.98 kg/l
Viscosity (by Brookfield)	at 190 °C 7 000 mPa·s
Softening temperature (CQP538-5)	132 °C
Application temperature	170 - 190 °C short term max. 1 hour 200 °C ^A
SAFT (CQP560-1)	100 °C
Static shear adhesion (CQP566-1)	9 kg ^B
Peel strength (CQP568-1)	45 N/25 mm ^B
Shelf life	24 months

CQP = Corporate Quality Procedure

^{A)} only valid for nozzle^{B)} 23 °C / 50 % r.h.**DESCRIPTION**

SikaMelt[®]-285 MC is a pressure sensitive hot melt adhesive based on thermoplastic rubber. It offers very high cohesion and SAFT values for assembly and lamination applications.

PRODUCT BENEFITS

- High bonding strength
- High cohesion
- Very good heat resistance

AREAS OF APPLICATION

SikaMelt[®]-285 MC is designed to stick to papers, films and metal foils, textiles, foams and a wide variety of other materials.

SikaMelt[®]-285 MC is not to be used on substrates containing monomeric plasticizer.

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

CURE MECHANISM

SikaMelt®-285 MC is a physically hardening adhesive.

CHEMICAL RESISTANCE

SikaMelt®-285 MC is resistant to aqueous surfactant, weak acids and caustic solutions.

The chemical resistance is influenced by several factors such as chemical composition, concentration, period of exposure and temperature. Therefore a project related testing in case of chemical or thermal exposure is required.

METHOD OF APPLICATION

Surface preparation

Surfaces must be clean, dry and free from grease, oil and dust.

Based on the surface and type of material, a physical or chemical pre-treatment might be required. Type of pre-treatment must be determined by preliminary tests.

Application

With adequate processing equipment SikaMelt®-285 MC can be applied directly or by transfer method. It can be applied as film, dot, bead or spray application. For automated applications a suitable filter system is required.

Due to the better adhesion performance the direct method is usually chosen whenever possible. The transfer method is often used in combination with substrates that are porous and absorbing such as foams or when they are sensitive to high temperature such as thin PE films. To protect the adhesive surface against dust, light and oxygen it is necessary to cover the adhesive film with silicone coated paper or foil.

To meet the required application properties the adhesive viscosity can be adjusted by adapting the application temperature (see diagram 1).

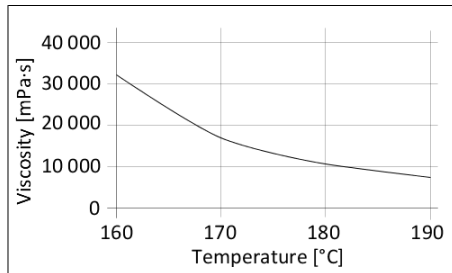


Diagram 1: Viscosity as function of temperature

During breaks SikaMelt®-285 MC is to be processed as follows:

For breaks ≥ 1 h the heating needs to be lowered to 80 °C and for breaks ≥ 4 h the heating needs to be switched off.

To ensure a constant quality during the whole production process it is recommended to protect the adhesive in the melting tank with nitrogen or carbon dioxide (to avoid possible reaction of the product with oxygen).

For advice on selecting and setting up suitable processing equipment contact the System Engineering Department of Sika Industry.

Removal

SikaMelt®-285 MC may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent.

Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water.

Do not use solvents on skin.

STORAGE CONDITIONS

SikaMelt®-285 MC has to be stored at temperature below 40 °C in a dry place.

For transportation purposes, the storage temperature can be exceeded for a period of max. 4 weeks up to 60 °C.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

Box	4 kg
Compartments box	10 kg

Please contact our customer service, for information of what packaging sizes are sold in Denmark.

BASIS OF PRODUCT DATA

All technical data stated in this document 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 shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER

Any information or suggestions for use concerning Sika's products, which we either in writing or orally have given buyers or end-users of the product, have been given in good faith based on our own experiences and based on approved praxis and the technological and scientific knowledge on the time of giving such suggestions and information, which are given without any type of guarantees, and which do not lead to any further responsibility from Sika Danmark A/S, besides what is stated in the sales agreement in question. The buyer or end-user should themselves investigate or otherwise make sure, that our products are suitable for the use in question and further make sure that the products are kept and used correct and in agreement with the published rules and considering the actual conditions in order to avoid damages or less satisfactory results. Any order is accepted and any deliverance is affected according to the general terms of sales and delivery from Sika Danmark A/S, which are considered known and accepted, and which could be handed out when asked for. Our catalogues are not up-dated automatically. The present product data sheet is only for use in Denmark. Values stated in the present product data sheet should be seen as recommended, unless stated otherwise.

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