

**Product:**  
**DANAFIX 857**

**Date of issue:** 29.04.2013  
(Replaces: 30.01.2012)

**Company:** DANA LIM A/S  
Københavnsvej 220, DK-4600 Køge

Ph.: 56 64 00 70, Fax.: 56 64 00 90, [www.danalim.dk](http://www.danalim.dk)  
Technical Service Ph.: 56 64 00 75

**Prepared by:** Laboratory, Kristian K. Pedersen

### Product description and application:

DANAFIX 857 is hot melt especially suitable for assembling. The adhesive obtain an elastic and strong joint, has good melting properties, do not tread and has good initial tack. DANAFIX 857 has medium viscosity and excellent adherence to lacquered surfaces and metal.

#### Application:

Materials:	857
Paper and carton:.....	●
Precoated Paper:.....	●
Wood:.....	●
Metal <sup>1)</sup> :.....	●
Glass:.....	○
Ceramics:.....	○
Textile:.....	●
Leather:.....	●
PVC – hard :.....	○
PVC – soft:.....	○
ABS:.....	●
PE:.....	○
PP:.....	○
PMMA (Akrylic glass):.....	○
PU foam:.....	●
PS soft <sup>2)</sup> :.....	●
PS hard:.....	●

1) Metals can be preheated before gluing with advance.

2) Assembling temperature must be as low as possible. If PS is assembled with other materials the adhesive has to be applied on the other materials.

Packaging size:

Item no.	Size
6288	25 kg

### Physical / chemical properties:

	857
Type:.....	EVA-copolymer
Color:.....	Yellowish transparent
Melting point:.....	App. 85 °C
Viscosity, 150 °C:.....	Ca. 9.450 cP
Storage:.....	Min. 2 years in original unsealed packaging

## Direction for use:

- Preparation:** The substrates have to go well together, be clean and dry, free of dust, oil and other loose particles. The materials have to be conditioned to room temperature. Room temperature should not be lower than 18°C and draughts have to be avoided.
- Application:** The adhesive is applied with standard hot melt equipment e.g. nozzle or roller. Always follow the instructions from the equipment supplier.
- Application temperature:** 150-180 °C.
- The temperature regulation of the equipment is normally divided into 3 zones.
- Tank:** Storage time in the tank is the longest duration for the hot melt. It is important to keep the temperature in the tank as low as possible, as the tank is where the hot melt is stored for the longest time. The temperature should be regulated to a level where the adhesive barely is melted. As rule of thumb the temperature is set 5-10°C below the temperature of the hose.
- Hose:** The hose should be regulated to a temperature between the tank and the nozzle. For high consumptions, a little higher temperature can be selected. As rule of thumb the temperature is set 5-10°C below the temperature of the nozzle.
- Nozzle:** The nozzle should be regulated to the application temperature. High temperature will increase open time and pressing time, and will normally increase the adhesion properties. Low temperature will decrease the open time and pressing time.
- Open assembly time:** 1 minute depending on the materials, temperature and amount of applied glue.
- Cleaning:** The hot melt equipment is cleaned with DANAFIX 918 and the tools with DANAFIX 919.
- Storage:** Cold and dry in original sealed packaging (max. 25 °C).

## Safety:

- Hazard Symbols:** None
- Risk and safety phrases:** None

For further information concerning safety, refer to Safety Data Sheet.

## Further information:

### **DANA LIM offers a range of adhesives for professionals:**

100-series: Upholstering adhesives  
200-series: Flooring adhesives  
300-series: Wall adhesives  
400-series: Wood adhesives  
500-series: Sealants & PU-foams  
600-series: Building-additives, fillers etc.  
700-series: Paper-, packaging- and newspaper adhesives  
**800-series: Hot melt**  
900-series: Cleaning-, release agents and hardeners.

### **In the 800-series Hot melts DANA LIM offers:**

810-serien: Hot melt sticks  
840-serien: Hot melt in cartridges for edge bonding  
**850-serien: Hot melt for assembling**  
860-serien: Hot melt for profile wrapping  
870-serien: Hot melt in granulate for edge bonding  
880-serien: Hot melt for packaging closing  
890-serien: Pressure sensitive hot melt

The information and data contained in this data sheet are based on extensive laboratory testing and our practical experiences, and are meant for helping the user to find optimum working methods. As the conditions at the user are beyond our control, we make no warranties concerning the results, achieved by the products. The information's in this technical data sheet are typical values, intended as a guideline. They should not be regarded as product specifications. Please also refer to our standard sales conditions and terms of delivery.