



TECHNICAL DATASHEET

DANAFIX

Hot melt

Product:
DANAFIX 852

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

Ph.: 56 64 00 70, Fax.: 56 64 00 90, www.danalim.dk
Technical Service Ph.: 56 64 00 75

Prepared by: Laboratory, Kristian K. Pedersen

Product Description and Application:

DANAFIX 852 is a hot melt for production of pocket springs in mattresses and as an assembling adhesive.

Packaging size:

Item no.	Size
6281	25 kg

Physical / Chemical Properties:

DANAFIX 852	
Type:.....	EVA-copolymer
Colour:.....	Yellow
Softening point:.....	80 °C
Viscosity (150 °C):.....	5.500 cP
Open time (160 °C):.....	8 – 12 sec.
Shelf life:.....	Minimum 2 years in original closed packaging.

Directions for use:

Preparation: All surfaces must be clean and dry, free of dust, oil and other loose particles.

Application: The adhesive is applied with standard hot melt equipment eg. nozzle or roller. Always follow the instructions from the equipment supplier.

Application temperature: 160-180 °C

Typical settings: 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.

852	
Tank [°C]	140-150
Slange [°C]	150-160
Dyse [°C]	160-180

Cleaning: Clean the hot melt equipment with DANAFIX 918. Clean tools with DANAFIX 919.

Storage: Store dry and cool (max. 25 °C)

All information's are meant as a guideline. Sufficient test should be carried out to determine final working condition.

Safety:

Hazard Symbols: None

Risk and Safety phrases: None

For further information concerning safety, refer to safety Datasheet.

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 melt DANA LIM offers:

810-series: Hot melt sticks

840-series: Hot melt in cartridges for edge bonding

850-series: Assembling

860-series: Profile wrapping

870-series: Edge bonding

880-series: Packaging closing

890-series: Pressure sensitive

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.