

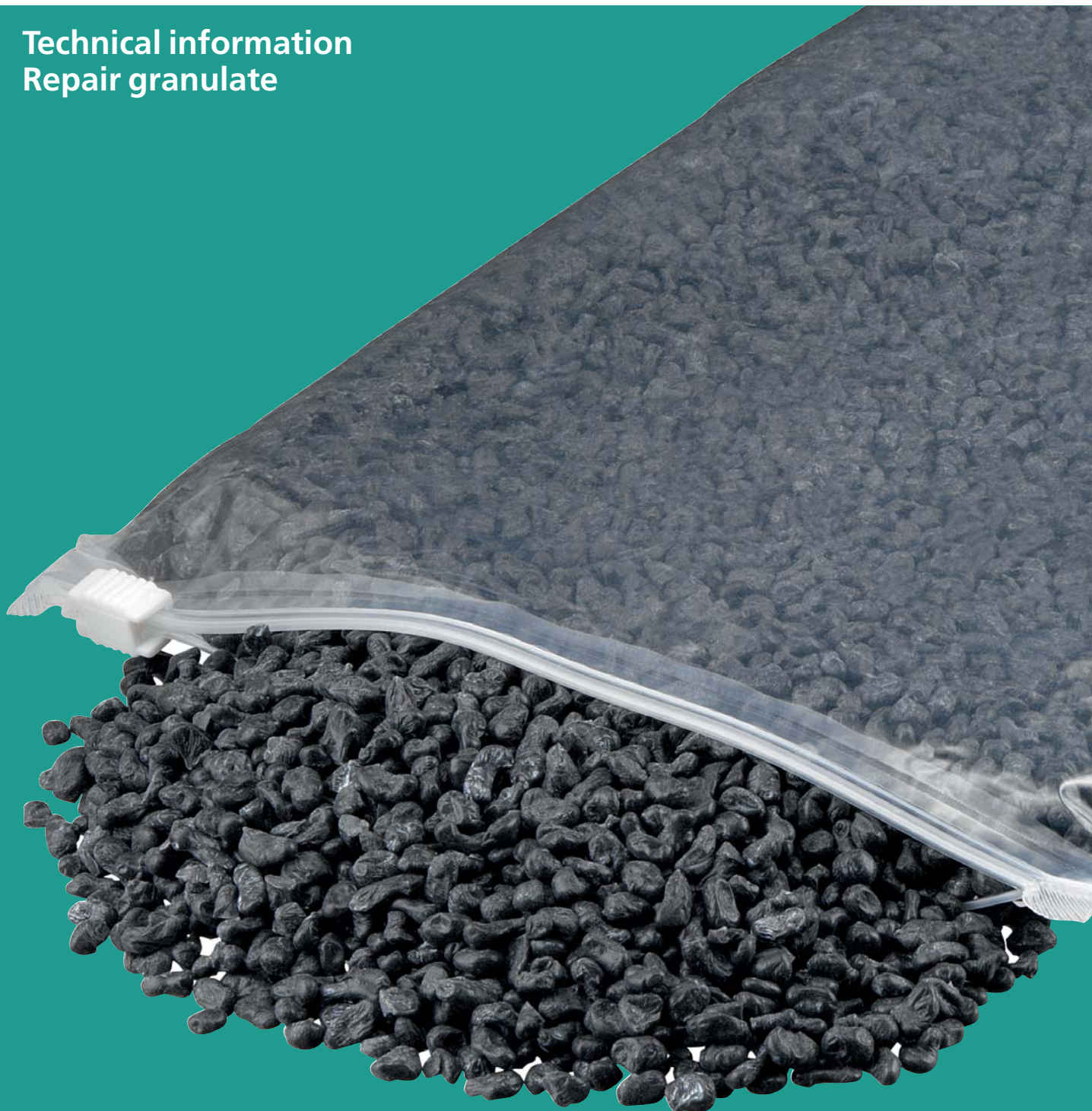


THE FORMWORK

NOE[®] repair

Dated: 08.2012

Technical information
Repair granulate



Technical information

NOErepair Repair granulate



Hot-melt adhesive

- NOErepair Repair granulate, grey, Part No. 844070
- NOErepair Repair granulate, brown, Part No. 844071

Applicators

- Hot-melt adhesive gun MS 200 Part No. 397041
- Hot-melt adhesive gun HM 710 Part No. 844080

Fields of application

Repair of NOEform formwork facing (repair granulate, brown) and NOEboard formwork facing (repair granulate, grey)

Properties

- Very good thermal stability, elastic.
- The hot-melt adhesive has been certified in accordance with UL 94V-O.
- The raw materials used conform to the BGA and/or FDA guidelines for the food packaging.

Description

- Type: Polyamide-based
- Colour: Grey or brown slight colour differences of the hot-melt adhesive do not affect the quality of the product.
- Characteristics: The components of the hot-melt adhesive are classified as harmless to health. Special labelling of this product to satisfy the Dangerous Goods Act is not necessary.

Technical data

- Softening point: Approx. 140 °C ring and ball
- Heat resistance: Approx. 110 °C (in accordance with WPS 68, shear stress 100 g/cm² of bonded area)
- Viscosity: Approx. 3500 mPas at 190 °C (Brookfield)
- Density: Approx. 1.00 g/cm³
- Solids content: 100 %
- Processing temperature: 180 °C
- Open time: Approx. 40 seconds, depending on the material and amount applied, (bead application 3 mm, 180 °C) beech (4 mm thick)

- Set time: Approx. 20 seconds, depending on insulating effect of the materials, type of application and adhesive material (refer to open time)
- Dimensions: Granulate, in bulk
- Delivery form: Bag à 1 kg Sack à 20 kg

Storage

Shelf life 18 months in an indoor climate (DIN 50010) and in undamaged original packaging. Avoid heat (e.g. sunlight), otherwise the outside shape of the hot-melt adhesive may change.

Processing instructions

- The surfaces to be bonded must be free of dust, dirt, moisture, grease and release agents. Plasticisers in plastics and paints may affect the durability of the bond.
- Apply hot-melt adhesive as dots, films or beads.
- Pressing the parts together for a short period increases the strength of the bond.
- Polyamides seek to remain in equilibrium with the humidity of the air.
- The absorbed moisture can lead to foaming (steam formation) when polyamides melt. We recommend that the packaging is carefully sealed up again after material has been taken out and if necessary the hot-melt adhesive is dried at approx. 50 °C for 48 hours before use.
- When processed in open melting containers, polyamide hot-melt adhesives have a tendency to oxidise if they are exposed for long periods to atmospheric oxygen (deepening of colour and, in extreme cases, skin formation).
- Oxidation can be avoided by covering the melted adhesive in melting tank melters with a buffering layer of dry protective gas (e.g. nitrogen) or using pneumatic applicators with a protective gas shield.
- We recommend the use of NOE release agent and formwork oils on formwork that has been repaired with NOErepair – repair granulate as they have been tested for compatibility with the granulate.

Safety advice

- Observe the operating instructions supplied with the applicators!
- Caution: Hot! The hot-melt adhesive and the nozzle of the applicator can reach temperatures high enough to burn skin if inadvertently touched. If this happens, cool the affected area of skin quickly with plenty of cold water and seek medical advice if necessary.
- Melt adhesives also give off vapours that could lead to an odour nuisance, even if used at the prescribed processing temperature. If the prescribed processing temperature is exceeded over a longer time, the vapours given off could irritate the mucous membranes of certain people.
- Ensure adequate ventilation when processing large quantities of hot-melt adhesive in confined working spaces. Vacuum extraction of hot-melt adhesives is recommended, in particular if processing temperatures are above 200 °C.

Notes

- The technical information provided is to the best of our knowledge. The content is not legally binding.
- We reserve the right to make technical changes.
- We recommend customers perform their own tests in every case.
- The NOE general terms and conditions of trade apply.

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NOE-Schaltechnik
Georg Meyer-Keller GmbH & Co. KG
Kuntzestr. 72, 73079 Suessen,
Germany
Tel. +49 7162 13-1
Fax +49 7162 13-288
info@noe.de
www.noe.de