



# ASKOBOND HM N 77

Thermoplastic hotmelt adhesive for cores and molds made from sand.

## Product Properties

Copolyamide

ASKOBOND HM N 77 is a special hotmelt adhesive for cores and molds in foundry operation. The adhesive has very low melting viscosity, superior adhesive power and high heat resistance.

Suitable for cold box and resol/CO2 cores as well as shell cores and firebricks.

For easier application of hotmelt adhesives we would like to suggest adequate tools laid out for the respective application demands and extent of the glue job..

## Analytical values

- |  |   |
|--|---|
| • Color ratio:   | max. 8  |
| • Amine value (ISO 9702):  | max. 4 [mg KOH/g]   |
| • Acid value (ISO 2114):   | max 7 [mg KOH/g]  |
| • Softening point R-B (ISO 4625):  | 172-178 [°C]  |
| • Melt viscosity @ 180°C (ISO 2884):   | 0.3 + 0.1 [Pa s]  |
| • Working temperature:   | 190-220 [°C]  |
| • Open time (melt temperature @ point of application 200°C):   | - LEITZ divider @ 23°C: 3 + 2 [sec.]<br>- Channel method: 23 + 3 [sec.] |
| • Curing time on Nora rubber test piece @ 23°C (melt temperature @ point of application 200°C): 2 + 1 [sec.] |   |

## Storage & Handling

Packaging: 25 kg paper bags

Storage: 24 months if stored dry between 10 and 30°C.

Please refer to paragraph # 7 "Handling and Storage" in Safety Data Sheet.

Labelling: Please refer to the Safety Data Sheet