

## technical datasheet

### General description

FOUNDRY TEC 501 allows very close bonds to be made with a minimum gap between sand cores.

The low viscosity of this product helps prevent stringing and improves glue gun output.

The low ash content enables FOUNDRY TEC 501 to be used in lost wax / investments foundries..

### Technical characteristics

Adhesive type: Synthetic Polymer Based Hotmelt  
 Colour: Light Brown  
 Molten tack: Medium

|   | 1/2"   | 5/8"   | 1 3/4"   | Bulk   |
|---|--|--|--|--|
| Form  | 1/2" x 12"   |  | 1 3/4" x 1 3/4"  | Prills   |
| Sticks per lb (approx)                        | 16   |  | 8  |  |
| Carton quantity                               | 11lb   |  | 22lb   | 44lb   |
| Pallet weight:                                | 1100lb   |  | 1100lb   | 2200lb   |
| Suggested application temperature             | 380°F  |  | 380°F  | 380°F  |
| Brookfield viscosity (POW-12-VISC) spindle 27 | 1200cps @ 350°F  |  | 1200cps @ 350°F  | 1200cps @ 350°F  |
| Ring & ball softening point (ASTM E28)        | 221°F  |  | 221°F  | 221°F  |
| Heat resistance (BS5350 Part H3)              | 158°F  |  | 158°F  | 158°F  |
| Open time                                     | Medium/Long  |  | Medium/Long  | Medium/Long  |
| Low temperature flexibility (tg)              | -4°F   |  | -4°F   | -4°F   |
| Applicators or hotmelt system                 | <input checked="" type="checkbox"/> Tec 150-12<br><input type="checkbox"/> Tec 150-12LM<br><input checked="" type="checkbox"/> Tec 175-12<br><input type="checkbox"/> Tec 175-12LM<br><input checked="" type="checkbox"/> Tec 250-12<br><input type="checkbox"/> Tec 250-12LM<br><input checked="" type="checkbox"/> Gastec 100<br><input checked="" type="checkbox"/> Gastec 300<br><input checked="" type="checkbox"/> Gastec 500<br><input checked="" type="checkbox"/> Tec 810-12<br><input type="checkbox"/> Tec 810-12LM | <input type="checkbox"/> Tec 810-15<br><input type="checkbox"/> Tec 810-15LM | <input checked="" type="checkbox"/> Tec 3150-43<br><input type="checkbox"/> Tec 3150-43LM<br><input checked="" type="checkbox"/> Tec 3200-43<br><input checked="" type="checkbox"/> Tec 6100-43<br><input type="checkbox"/> Tec 6300-43<br><input checked="" type="checkbox"/> Tec 7100-43<br><input type="checkbox"/> Tec 7300-43 | <input checked="" type="checkbox"/> Bulk tank<br><input type="checkbox"/> Spray<br><input checked="" type="checkbox"/> Jet<br><input checked="" type="checkbox"/> Slot coater<br><input checked="" type="checkbox"/> Roller<br><input type="checkbox"/> PUR system |

F.D.A. approved. All the constituent parts of this adhesive have been approved by the American F.D.A. under C.F.R. 21.175.105 (adhesives) (subject to limitations).

| Tecbond Reference | Description  | 1/2" | 5/8" | 1 3/4" | CT | Bulk |
|-------------------|--|------|------|--------|----|------|
| 5                 | High delivery, low viscosity, long open time. Product assembly adhesive.   | •    |      | •      | •  | •    |
| 14                | High delivery, very fast setting packaging adhesive.   | •    | •    | •      |    |      |
| 1942              | Product assembly adhesive for wood and many plastics.  | •    | •    | •      |    |      |
| 1X                | Low viscosity, wood working & packaging adhesive. Medium open time.  | •    |      | •      |    |      |
| 213               | Economical, general purpose adhesive.  | •    | •    | •      |    |      |
| 214               | Economical, fast setting, packaging adhesive.  | •    | •    | •      |    |      |
| 23                | Medium viscosity multipurpose adhesive.  | •    | •    | •      |    |      |
| 232               | Economical, clear, general purpose adhesive.   | •    | •    | •      |    |      |
| 232 Coloured      | Coloured, medium open time, general purpose adhesive. Brown, Green, White, Black, Blue, Gold, Silver, Red, Yellow. | •    |      |        |    |      |
| 232 Glitter       | Multicolour, Red, Green, Silver, Gold.   | •    |      |        |    |      |
| 240               | High delivery, long open time, multipurpose, clear adhesive.   | •    | •    | •      |    |      |
| 246               | Clear and black versions, high performance, gap filling, difficult surfaces, dent pulling.                         | •    |      |        |    |      |
| 260               | High performance, long open time, tough, flexible adhesive.  | •    | •    | •      |    |      |
| 265               | Long open time product assembly adhesive for smooth and shiny surfaces.  |      |      | •      |    |      |
| 267               | High heat resistant, medium open time, product assembly adhesive.  |      |      | •      |    |      |
| 2169              | Peelable adhesive, low tack, non-migrating, CD & credit card attachment, glue dots.                                |      |      |        | •  | •    |
| 342               | High viscosity, fast setting, white adhesive.  | •    |      | •      |    |      |
| 410               | Pallet stabilisation spray adhesive  |      |      | •      |    |      |
| 420               | General purpose spray adhesive.  |      |      | •      |    |      |
| 425               | High delivery, high performance, spray adhesive.   |      |      | •      |    |      |
| 430               | High performance, long open time spray adhesive.   |      |      | •      |    |      |
| 4741              | Full pressure sensitive, very aggressive, multipurpose, paper & plastic materials.                                 |      |      |        | •  | •    |
| 7718              | Coloured, low viscosity, potting, encapsulation & knot filling / wood repair polyamide adhesive.                   | •    | •    |        |    |      |
| 7784              | High temperature resistant multipurpose polyamide adhesive.  | •    | •    | •      |    |      |
| 7785              | High temperature & chemical resistant multipurpose polyamide adhesive.   | •    | •    | •      |    |      |
| 9010              | Reactive hotmelt. Heat & chemical resistant bonds, rigid bond, once set does not reactivate with heat.             |      |      |        | •  |      |
| 9030              | Reactive hotmelt. Heat & chemical resistant bonds, flexible bond, once set does not reactivate with heat.          |      |      |        | •  |      |
| LM44              | Lowmelt, fast setting, high performance, white adhesive.   | •    |      | •      |    |      |

**Storage** Store in a clean dry place at temperatures between 41°F and 86°F with boxes closed. Do not expose to direct sunlight or localised heat sources such as radiators or hot pipes.

**Removal of glue** Assembled components can be separated by heating assembly to a temperature slightly above the heat resistance figure.

EVA & Polypropylene: Residues of EVA and polypropylene based hotmelts can be removed from components with white spirit.

Polyamide: Residues of polyamide based hotmelt can be removed from components with acetone.

PUR: Prior to cross linking adhesive can be removed with white spirit or ketone. Once fully cross linked the adhesive cannot be easily removed.

**Please note** The information contained on this data sheet is for guidance only. It is the result of careful laboratory evaluations by trained and qualified staff using British Standard or similar test methods. However, no warranty is expressed or implied regarding the accuracy of the data or the suitability of the adhesive for any specific purpose. In every case, we strongly recommend that the user shall make their own test to determine to their own satisfaction the suitability of the adhesive for their particular purpose. Neither the seller nor manufacturer shall be liable for any injury, loss, damage, direct or consequential arising out of the use or inability to use the product. Further information is always available to help solve your adhesive problems. Should you require any further information on our adhesives please contact your nearest distributor.