



TECHNICAL DATA SHEET

Revision date 4/5/23

EVA Hot Melt **ASA-8116-A10**
ASA-8116-B10

Attribute: **Industrial Strength All Purpose Hot Melt Glue Sticks**

Application: **All Purpose Glue Sticks**

Tackiest all-purpose clear hot melt sticks in ASA's product line, ASA-8116 is suitable for manual corrugated case and carton sealing, repackaging, point of purchase display and trade exhibits, furniture, woodworking and product assembly. It is compatible with chipboard, foam, paper, uncoated cardboard and wood materials.

Cross-referenced to 3M 3750AE Clear, ASA-8116's aggressive hot tack rapidly achieves handling strength for packaging and product assembly application. ASA-8116's low viscosity property provides high flow rate to support fast-paced production. The 40 second open time allows for positioning and fit adjustment. ASA-8116 can be applied with a low temperature or a high-temperature hot melt glue gun.

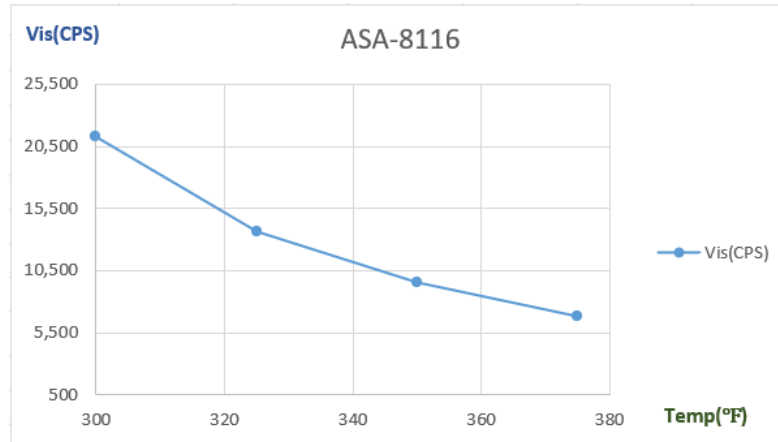
Direction for use: Different types of hot melt adhesives may be incompatible with each other depending on the formulation. Therefore, we recommend to carefully clean the application equipment when changing the product. Further information is available upon request.

The processing characteristics may vary depending on the application technology used as well as at differing feed speeds, which can affect the bonding process.

Customer trials are required.

Typical key data:	Color	Clear white
	Form	Stick
	Softening points	181°F (82.78°C)
	Open time	40 seconds
	Setting time	40 seconds
	Operating temperature	-
	Range of service temperature	-

Specification:



Viscosity 300°F~375°F (ASTM D3236, Brookfield RVDV-II+PRO, Spindle #27)

FDA Status

Meets composition requirements of FDA reg 21 CFR 175.105 for food packaging adhesives.

Requirements for a high-quality bonding process:

The properties (e.g. open time) and the conditioning of the substrates, as well as the processing conditions (e.g. ambient temperature, humidity) will influence the processes of joining and bonding. Customer tests under consideration of everyday product conditions are therefore absolutely necessary to define stable process parameters and to ensure that the product is fit for purpose. For best bonding results, the materials to be bonded should be free of dust, oil, and grease, and be dry. Wood moisture content should be at 8-10%. Ideally, the minimum temperature should be at 64°F (30°C). Avoid draft.

Our adhesive specialists will provide technical data to assist you in your choice of an appropriate product for your requirement.

Cleaning:

Preliminary mechanical cleaning while hot (e.g. with a suitable spatula which does not damage the unit). Remove any residue in the hot melt equipment using the cleaning solution recommended by equipment manufacturer. Paraffin wax may be used in place of the cleaning solution.

Safety considerations:

Like all hot liquids, the product can cause severe burns in the molten state. Please take appropriate precautions to prevent the hot adhesive from coming into contact with the skin (e.g. by wearing appropriate protective gloves). If this does happen, cool the affected area immediately with water. Do not try to remove the adhesive from the skin. Seek medical attention.

Hot melt adhesives may release vapors when processed. It is recommended not to exceed the indicated processing temperature, to keep the formation of vapors as low as possible. Extraction and ventilation are recommended



TECHNICAL DATA SHEET

Revision date 4/5/23

especially if an open application system is used. Use adequate ventilation to remove any hot melt fumes or vapors that are generated.

Packaging:

25lbs carton

Remarks:

For further information concerning safety, handling, transport and disposal, please refer to the safety data sheet.

The information on this data sheet is based on test results from our laboratories as well as on reported experience gained in the field by our customers. It can, however, not cover all the parameters for each specific application and is therefore not binding upon American Standard Adhesives, nor should it be relied upon in lieu of your own required testing. The information given in this TDS does not represent a performance guarantee. Unless otherwise agreed with our customers, the values states in the section "Specification" shall be regarded as the finally agreed upon product properties. No liability may be derived from the information contained herein nor from the information provided by our free technical advisory service.