



ASKOBOND HM PO MC 500

Thermoplastic hotmelt adhesive for cores and molds made from sand.

Product Properties

Polyolefin

ASKOBOND HM PO MC 500 is a special hotmelt adhesive for cores and molds in foundry operation. The adhesive offers a long working time, good adhesive power, high heat resistance and superior anti-oxidation and color stability in the melt. ASKOBOND HM PO MC 500 is suitable for gluing cores made with the cold box, resol- CO2 and shell sand methods but can also be used for gluing firebricks. For the processing of hot-melt adhesives, we can recommend processing by automatic systems and hand guns, which are adapted to the respective application and the scope of the bonding. The processing temperature should be 160-180° C. The minimum temperature of the materials and the environment should not fall below 18°C. The processing time is 15 - 25 seconds, depending on the temperature of the environment and the substrate.

Analytical values

- Viscosity at 160°C (mPas): ~ 930-1.230 (Brookfield / spindle 27 / 100 RPM)
- Density (g/cm³): ~ 0,96
- Softening range (°C): ~ 111
- Melting point (°C): ~ 106 – 116 (ring and ball)
- Color: white

Storage & Handling

Packaging: 20kg pellets packed in PE-bag

Product Storage: 12 months if stored dry between 10 and 30°C.

Handling of ASKOBOND HM PO MC 500

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

Labelling: Please refer to the Safety Data Sheet