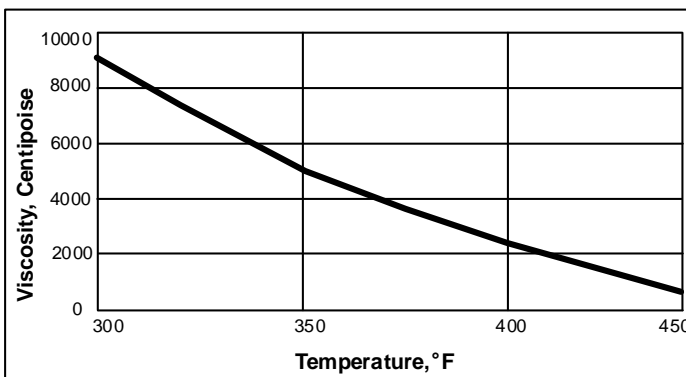


### Description

Technomelt® 1942 hot melt is an EVA-based, medium setting, general purpose adhesive. It exhibits excellent adhesion to wood and many plastics such as; nylon, polycarbonate, PVC, polystyrene, ABS, and acrylic.

Typical Properties	Typical Value
Softening Point, °F, ASTM E 28-67	198
Viscosity @ 350°F, cP, ASTM D 3236	5000
Open Time, seconds	30
Heat resistance, °F, ASTM D 4498	142
Specific Gravity @ 77°F ASTM D 792	0.96
Tensile Strength, psi, ASTM D 638	250
Elongation, %, ASTM D 638	500
Tg, °F ASTM E 1640	7
"T" Peel Aluminum, pli, ASTM D 1876	44

### Viscosity Curve



Electrical Properties	Typical Value
Dielectric Strength, ASTM D149, V/mil	>1100
Dielectric Constant, MIL 1-16923. K	2.9
Dissipation Factor, ASTM D 150	0.026
Volume Resistivity, ASTM D 257	$2.8 \times 10^{16}$
Surface Resistivity, ASTM D 257	$8.9 \times 10^{15}$

### PERFORMANCE OF CURED MATERIAL

**Shear Strength vs. Substrate, ASTM D1002, psi,**  
 cured 5 days at 22°C

	Typical Value
Grit-Blasted Steel	1030
Aluminum	1335
Anodized Aluminum	845
Stainless Steel	1375
Galvanized	1445
Zinc Dichromate	1065
Polycarbonate	280
Nylon	340
G-10 Epoxy	395
LDPE	155
Glass	280

Block Shear, ASTM D4501, (psi)	Typical Value
24 Hour RTC, 68°F/50%RH	
PVC	500
Valox	540
HD Polyethylene	440
Polypropylene	325
ABS	520

### Precautions

Once melted, like any hot liquid, this adhesive can produce severe burns. Care should be taken to avoid getting hot adhesive on the skin. If skin contact occurs, flush the affected area with large amounts of cold water.

### GENERAL INFORMATION

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.**

**For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).**

### Application

Please read the operating instructions for the Hysol Hot Melt Applicator being used. Allow the applicator 5 - 10 minutes to reach operating temperature before applying the adhesive. Squeeze the trigger to dispense hot melt to one of the parts to be bonded. For best results, press the parts as soon as possible; within the hot melt's open time. After use, unplug the applicator and squeeze trigger twice to advance any semi-molten adhesive into the melt chamber. This helps for quick start-up when the applicator is used next. Always use gloves when using the applicator. Henkel offers a complete line of reliable, portable, hand held applicators designed to accurately dispense all shaped hot melt formulations.

### FDA Status

Ingredients in this product are listed under Food and Drug Administration CFR 175.105, Adhesives.

### Storage

Store product in unopened container in a cool dry location. Ideal conditions are within the range 8 to 21 degrees C (46 to 70 degrees F) and are recommended for long term storage. Exposure to higher temperatures (greater than 28 degrees C) for prolonged periods should be avoided as extended exposure to warm conditions can adversely affect product properties. For further specific shelf life information, contact your local Technical Service Center.

### Note

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of

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