

SikaMelt[®]-9171

Technical Product Data

Chemical base	Polyolefine
Colour	Honey
Cure mechanism	Physical hardening
Density (CQP ¹ 006-7)	0.9 kg/l
Solid content	100%
Viscosity at 180 °C (355 °F) (Brookfield Thermosel)	27000 mPas approx.
Softening Temperature (CQP 538-5)	160 °C (320 °F) approx.
Application temperature	170 - 190 °C (340 - 375 °F) short term 200 °C (390 °F)
Open time (CQP 559-1)	25 sec. approx.
Shore A hardness (CQP 023-1 / ISO 868)	80 approx.
Tensile strength (CQP 036-3)	3.5 N/mm ² approx.
Elongation at break (CQP 036-3)	600% approx.
Heat resistance (CQP 569-1)	110 °C (230 °F) approx.
Shelf life (storage below 25 °C / 75 °F in sealed container)	12 months
An excess of the recommended storage temperature during transport is not critical	after production

¹⁾ CQP = Corporate Quality Procedure

Description

SikaMelt[®]-9171 is a multipurpose, thermoplastic hot melt assembly adhesive with high green strength. SikaMelt[®]-9171 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the responsible care program.

Product Benefits

- High green strength
- Good adhesion on non polar and some polar substrates
- High strength and flexibility over a wide temperature range
- Excellent ageing and heat resistant
- Not corrosive

Areas of Application

SikaMelt[®]-9171 has excellent adhesion properties on non polar olefinic substrates like polypropylene. Therefore it is suitable for permanent bonding on non polar polymers and wood, textiles, non-woven materials and foams. On the polar polymeric substrates ABS, PVC, ABS/PC and PA shows SikaMelt[®]-9171 good adhesion results.

This product is suitable for professional experienced users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Industry



Cure Mechanism

SikaMelt®-9171 is a physically hardening adhesive.

Chemical Resistance

SikaMelt®-9171 is resistant to aqueous surfactant solutions, weak acids and caustic solutions. It is temporarily resistant to fuels, solvents and mineral oils. As the chemical resistance depends on type and condition of the substrate, chemical concentration, exposure duration and temperature, a project adapted adhesive performance test is strongly recommended.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

Method of Application

Surface preparation.

Bonding area must be clean, dry and free from grease, oil and dust. Advice on specific applications is available from the Technical Service Department of Sika Industry

Application

SikaMelt®-9171 can be applied by appropriate melting equipment out of containers as film, spot, bead or as sprayed layer. For automated application a suitable filter system is required.

The adhesive viscosity is dependent on the temperature. For application the adhesive viscosity can be adjusted by changing the temperature (see diagram 1).

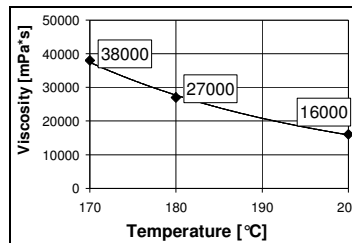


Diagram 1: Viscosity of SikaMelt®-9171 as a function of temperature

For advice on selecting and setting up a suitable pump system please contact the System Engineering Department of Sika Industry.

Removal

Application tools and equipment can be cleaned with SikaMelt®-9901 (see also manual "Cleaning procedure of SikaMelt® application equipment")

SikaMelt®-9171 may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent.

Hands and exposed skin should be washed immediately using Sika® Handclean Towel or a suitable industrial hand cleaner and water. Do not use solvents!

Further Information

Copies of the following publications are available on request:

- Material Safety Data Sheets

Packaging Information

Box	7 kg
Box	10 kg

Value Bases

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

Health and Safety Information

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

Legal Notes

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

Further information available at:
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