



# TECHNICAL DATA SHEET

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## Kimbond 2515

### Pressure Sensitive Hot Melt Adhesive

#### Product Description

**Kimbond 2515** is a light yellow colored, high performance, pressure sensitive hot melt adhesive. It's especially recommended for use in the manufacture of jumbo bags. It has excellent cold temperature adhesion to polyethylene as well as many other substrates.

#### General Properties

Type	<ul style="list-style-type: none"> <li>Pressure sensitive hot melt adhesive</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Light white</li> </ul>
Forms	<ul style="list-style-type: none"> <li>Cake wrapped with EVA film (200-500g)</li> </ul>
Features	<ul style="list-style-type: none"> <li>Very aggressive tack</li> <li>High peel adhesion</li> <li>Excellent flexibility and outstanding machining properties</li> <li>Quickly wetting out the substrate under very light pressure</li> <li>Excellent adhesion and cohesion</li> <li>Low viscosity</li> <li>Excellent heat stability</li> <li>Very great wing-up resistance</li> </ul>
Uses	<ul style="list-style-type: none"> <li>Manufacture of jumbo bags</li> </ul>
Odor	<ul style="list-style-type: none"> <li>Slight resinous molten</li> </ul>
Packaging	<ul style="list-style-type: none"> <li>10 Kg Carton Box</li> </ul>

Physical Properties	Nominal Value Unit	Test Method
Viscosity @ 180 °C	1200-2500 cP	ASTM D3236
Ring & Ball Softening Point	75-85 °C	ASTM E28
Rolling Ball Tack (RBT)	5-10 mm	ASTM D3121
Specific Gravity	0.8±0.05 gr/cm <sup>3</sup>	ASTM D792
180° Peel Adhesion (for 15-20 gr/m <sup>2</sup> )	20-30 N/Inch	ASTM D3330
Heat Stability	Excellent	ASTM D4499

#### Storage and Handling

**Kimbond 2515** should be stored in a cool dry place between 5-30°C, away from sources of heat and direct sunlight. Keep product and hot melt units covered to avoid contamination. It must be stored away from any solvents or chemicals. Do not mix with other adhesives.

#### Safety and Health

**Kimbond 2515** is solid at room temperature, so it's not dangerous for handling at these conditions. When it's molten, for protection from burns, wear gloves and a long sleeved shirt during operation. For eyes protection, wear safety goggles. If the burns were occurred, first flush the affected area with large amount of cold water, do not remove adhesive, and then seek for medication immediately.

#### Shelf life

Best used within 24 months from date of manufacture when stored under the above conditions.

#### Operating Conditions

The recommended running temperature range is 150-180 °C (300-360°F). Kimbond 2515 can be applied by using of roller or die-nozzle applicator systems. The cleaning up methods is using of heat, solvent, mineral oil or paraffin.

Issue Date: Nov. 2019

Issue Number: 01