

Product Data Sheet

Sabamelt 4910



Description

Sabamelt products are hotmelt adhesives based on synthetic polymers, such as APAO, EVA and SIS. These adhesives are characterised by their ease of use, cost-effective use and durable bonds.

Areas of application

Sabamelt 4910 is primarily used in automated gluing machines in the mattress industry for gluing flexible foam components to each other and to the most commonly used upholstery materials, interior springs and pressure distributors, such as felt, non-wovens, jute, coconut fibre, etc.

Advantages

- excellent penetration in foam
- high end-quality due to setting characteristics
- cost-effective use combined with durable bonding
- optimally geared for automatic mattress production machines

Technical data

Properties*	
Base	APAO
Viscosity (EN 12092)	≈ 5700 mPa.s
Density	≈ 0.91 g/ml
Solids content	100%
Coverage	≈ 2 g/m to ≈ 3 g/m
Open time	≈ 2 minutes
Product application temperature	≈ +150°C to ≈ +175°C
Softening point (ring & ball DIN 52011)	≈ +100°C
Maximum final strength	after ≈ 24 hours
Storage and transport temperature	up to +35°C
Cleaning agent	Sabaclean 48 (outside of equipment)
Shelf life	36 months in unopened packaging

* Tested according to SABA Analysis Method unless stated otherwise.

Certificates & test reports

- TÜV Rheinland certified

Equipment

In addition to adhesives, SABA also supplies equipment such as adhesive guns, pressure tanks, pumps, etc. This range was put together by the SABA Tech Center on the basis of extensive testing and many years of practical experience. The right combination of adhesive and equipment gives you the most efficient application and the highest end quality.

Application

Apply adhesive using appropriate hotmelt adhesive equipment.
 Apply the adhesive to one side; create the bond within the open time and apply pressure.
 The time during which pressure is applied influences the speed with which the adhesived parts are available for continued processing.
 A nozzle opening of 1.5 mm is recommended for beads.
 Distance between nozzle and the substrate to be adhesived for automatic beading is approx. 3 cm.
 Apply pressure for as long as the process permits, however, at least 30 seconds for bonds under stress.

Important

APAO, EVA and SIS-based products are not resistant to softening agents.
 SABA offers specific products for the bonding of substrates such as synthetic leather that contain softening agents. Please contact us for further information.
 The open time is significantly affected by the method of application, as well as external factors.
 The open time will be (significantly) shortened for methods of application that involve the use of air (such as swirling and spraying) and methods in which the adhesive is applied as a very thin film (such as rolling).
 External factors, such as draughts (open doors) and very cold substrates or substrates that are highly efficient heat conductors, can shorten the open time.
 For optimal results, the surfaces to be bonded must be clean, dry, free of grease, and at application temperature.

Safety recommendations

It is very important to SABA that our products are used safely and handled responsibly. For more safety information, please refer to the relevant SABA material safety data sheet.

Contact

Our customer service department would be pleased to answer any questions you may have. Please contact your local SABA office.

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