

Product Information Sheet

CP-0605

PUR HM

Application Temperature(s): 120-140°C
 Color: White
 Freeze Thaw Stable: N/A
 Min Use Temperature:
 Shelf Life: See storage
 Solids (~):
 Specific Gravity (~): Density: approx. 1.1 g/cm³
 Viscosity: (on the day of production) -
 Brookfield HBTD 10 Upm: at
 120°C: 25.000±8.000 mPa s at
 140°C: 15.000±5,000 mPa s



Characteristics:

Base: Polyurethane

Reactive hot melt based on polyurethane (PUR) for interior finishing of motor vehicles.

Advantages: Low melting temperature, creep strength is achieved quickly, good adhesion to many plastics (e.g. ABS), wood, wood fibre boards, aluminum, no stringing, good bead stability on slanted surfaces.

Properties of the bond: Extremely high joint strength after curing, excellent resistance to heat, to more than 100°C (depending upon the material used), cold resistance down to -40°C (depending upon the material used)

Packaging: carton with 12 cartridges, 300 g net each, carton with 4 aluminum tins, 2 kg net each, metal drum, 18 kg, metal drum, approx. 200 kg

Applications:

Fields of application: Door paneling; e.g. bonding retainers and clips, Highly resistant assembly bonding, Laminating cloth/carpet or PVC foils to wood based materials or plastic substrates.

Directions:

Is supplied in factory sealed metal containers suitable for use in melting devices. The hot melt applicators should be designed to protect the hot melt from being directly exposed to humidity. Special care is to be taken for precise temperature control of the equipment, (record start operation data of the machine). The adhesive is usually applied to the substrate with nozzles from cartridges or robots. The application temperature ranges between 120-130°C. The creep strength depends on material and glue quantity applied and begins at 60 seconds upwards. Cross-linking of the adhesive film occurs within 1-3 days, depending on the humidity supply. Chemical cross linking of PUR hot melts requires moisture. Therefore sufficient air humidity has to be present during processing.

Assembly bonding: It is applied with a hand applicator from a cartridge (smallest packing size), or for higher quantities from 2 kg metal tins, 18 kg or 200 kg metal drums. Appropriate melting systems are required. It is also possible to apply the adhesive with the swirl-spray method.

Cloth and foil lamination to wood and plastic substrates: It can be applied by application rollers, spray nozzles or other nozzles onto wood or foil materials. The application temperature is from 120°C to 130°C. After the adhesive has been activated (infra-red light), lamination is carried out in a form press or in a vacuum press.

Application temperature: 120-140°C

Open time: up to 30 seconds for a bead thickness of 2 mm on chipboard. The open time is influenced by substrates, working temperature, temperature of material, as well as the method of application (swirl-sprayed or not)

Pressing time: from 3 seconds onwards

The better the heat dissipation, the shorter the pressing time.

Clean Up and Storage:

When having finished work, empty the applicator, draw off the residual hot melt and insert cleaning compound, melt the cleaning compound and flush until the last residues of PUR hot melt have been removed. Cured hot melt can only be removed mechanically.

Can be stored in factory sealed containers as follows: cartridges and aluminum cans and drums for approx. 1 year, pails for approx. 9 months. Protect from humidity!

Key warnings:

Identification: identification required according to the German hazardous substances regulations GefStoffV: contains diphenylmethane-4,4'-diisocyanate (see our safety data sheet)

When hot melt adhesives are melted and applied, vapours are set free and an unpleasant odour can occur, even if the recommended working temperature has been observed. Moreover if the prescribed working temperature is exceeded over a longer period, harmful decomposition products can develop. Precautions should be taken to eliminate the vapours, e.g. by using a suitable ventilation system.