

TECHNOMELT PUR 34-858B

Known as PUR-FECT LOK 34-858B
April 2023

PRODUCT DESCRIPTION

TECHNOMELT PUR 34-858B provides the following product characteristics:

Technology	Polyurethane
Product Type	Hotmelt
Application	Bonding of automotive exterior lighting

TECHNOMELT PUR 34-858B is a 100% solids, moisture-curing hot melt adhesive designed to provide excellent adhesion to difficult surfaces, such as polycarbonate and acrylic polymers, BMC, nylon and treated polypropylene.

TECHNOMELT PUR 34-858B delivers strong handling bonds rapidly, and cures to provide excellent heat resistance and water resistant durability.

Application Areas:

This product is normally applied by extrusion equipment adapted for reactive hot melts but can be slot coated. The recommended operating temperature range for TECHNOMELT PUR 34-858B is 130°C (265°F) – 141°C (285°F). Adhesive temperatures above 149°C (300°F) should be avoided. All users of RHM products should maintain an ongoing industrial hygiene program. This program should include contingency provisions in the event of ventilation failure as well as MDI monitoring. Combine parts as rapidly as possible to for maximum wetting of bonding surfaces.

NOTE: Use only with adequate forced ventilation.

Lamp Bonding:

Most curing hot melts produce excessive gas bubbles during cure. TECHNOMELT PUR 34-858B is designed to cure void free making it an ideal adhesive sealant for automotive lampbonding. Lamps can be quality tested as soon as bond lines reach ambient temperature (typically less than 5 minutes). NOTE: If processing takes place under dry conditions (i.e., with relative humidity below 50 %), it is suggested to fog the coated surface with moisture to provide adequate moisture to cure the adhesive.

Product Properties:

- Reactive hotmelt adhesive system based on polyurethane
- High initial strength

- Chemical cross-linking within a few days
- High final bond strength
- Excellent water resistance

TECHNICAL DATA

Appearance	Pigmented black solid
Solids content, %	100
Viscosity (121° C), cPs	22,000

DIRECTIONS FOR USE

Preliminary Statement:

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Processing:

Since the product will cure when it is exposed to moisture, storage and application must be done under dry conditions. For this reason, the product is delivered in airtight containers

Cleaning:

Flushing the system with TECHNOMELT PUR CLEANER 2 periodically or prior to changing to an alternative reactive hot melt will reduce internal build-up of adhesive residue. Application devices such as wheels and rolls that expose reactive adhesive to the air should be thoroughly flushed at the end of a production run or at anytime when there is build-up and gelling. Cured PUR hot melt can only be removed by softening with an appropriate solvent such as N-ethylpyrrolidone (NEP) and then using a non-abrasive scraper. Strictly follow the instructions of the machine manufacturer.

Safety:

The product contains diphenylmethanediisocyanate. Even if the product is applied within the range of the recommended working temperature, the diisocyanate has a detectable vapour pressure. When the recommended working temperature is considerably exceeded, hazardous decomposition products may be formed in the application unit. Therefore, measures to draw off the vapours need to be



taken, e.g. through the provision of extraction equipment. In case of skin contact with the hotmelt, do not try to remove the adhesive from the skin by force. Consult a doctor. Observe the material safety data sheet.

Classification:

Please refer to the corresponding **Material Safety Data**

Sheets for details on:

Hazards identification

Transport information

Regulatory information

Storage:

Frost-sensitive	no
Recommended storage temperature, °C	5 to 25
Shelf-life (in unopened original packaging), 6 months	

ADDITIONAL INFORMATION

Disclaimer

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 our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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