



GENERAL DESCRIPTION

Purmelt® QR 862A is a 100%-solids, moisture-curing hot melt adhesive. This product is designed to provide highly aggressive tack, combined with very fast handling strength. This allows for parts to be moved, trimmed, and even routed, in minutes rather than hours. The distinctive feature of this product is that it combines two, often un-linked, properties - good working assembly time and high green strength. Purmelt® QR 862A is formulated with patented technology to provide fast cure. Purmelt® QR 862A contains UV dye for improved visibility under ultraviolet source.

TYPICAL PROPERTIES

Appearance	Translucent in Melt State, contains UV indicator
Weight/Gallon	Approx. 8.8 lbs.
Solids	100%
Containers	55 gallon drum 05 gallon pail
Viscosity, Thermosel	Approx. 12,000 cps @ 275°F

APPLICATION

NOTE: Use only with adequate forced ventilation. Bond strength of Purmelt® QR 862A depends to a large extent on the coating weight and the nip pressure. For applications like panels assembly, a coating weight of 8-12 grams/square foot is recommended. Coating weight may vary depending on the nature of substrates. Coating weight needs to be checked frequently throughout a production day. A good nip pressure is essential to achieve a strong bond. **Consult with your Henkel technical service representative for the proper coating weight range and nip roller settings that suit your applications the best.**

Purmelt® QR 862A can be applied by roll coater, or slot coater adapted for reactive hot melts at material temperatures between 250°F and 275°F. Depending on the processing and performance needs of the application, temperatures may vary between these values. Adhesive temperatures above 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. The open time of Purmelt® QR 862A will vary depending to a large extent on thermal conductivity of the substrate being coated. With surfaces that are good insulators (such as wood, polystyrene, and high pressure laminate), the

open time may be as long as 6 minutes. With metals, open time may be as short as 2 minutes. **READ PRECAUTIONS ON BEFORE USING ADHESIVE**

SHELF LIFE

9 mos. @ 77°F max from date of manuf. in unopened container

ASSEMBLY BONDING

Depending on the substrates and the application, Purmelt® QR 862A may be applied as a globule or in a bead 1/8" or more in diameter. Parts should be combined with pressure applied by nip rolls, pneumatic clamps or a cold press. A handling bond is attained as soon as the adhesive cools.

PANEL BONDING

Apply Purmelt® QR 862A to one piece of substrate at between 8 and 12 grams/square foot. Assemble parts and pass through a nip roller or cold press for 5 seconds and then dead stack overnight.

VINYL LAMINATING

Coat either the vinyl film or the other substrate at 1.5 to 2.0 wet mils. A handling bond develops immediately after nipping or pressing. Full cure will take place in 3 – 7 days.

NOTE: If processing takes place under dry conditions (i.e., with relative humidity below 50%), it is recommended to fog the coated surface with moisture to provide adequate moisture to cure the adhesive.

CLEAN-UP

Flush system by running non-reactive hot melt such as Purmelt® Cleaner 3182 through equipment. Since 3182 will flow at 250-275°F, there is no need to change platen or hose temperature while flushing the system. Do not allow Purmelt® QR 862A to cure on equipment. Cured adhesive requires special solvent for removal (e.g., n-methyl pyrrolidone) if necessary.

CAUTION

Purmelt® QR 862A is a product which contains minor amounts of organic isocyanates. Health hazards have not been fully evaluated. **Use only in equipment intended for reactive hot melts. Do not use in conventional hot melt equipment. Forced ventilation must be provided over applicator and melting equipment to remove any small amount of isocyanate vapors to the outside.** Store in original unopened containers and use within 9 months (270 days) from date of manufacture. Rotate stock and use oldest material first. Do not expose to the atmosphere or otherwise contaminate with moisture. Moisture contamination will cause a sharp viscosity increase or



cure. Containers must be used completely after opening. Do not attempt to reseal.

Do not heat to melting without proper forced ventilation. Vapor is harmful if product is overheated. Prevent breathing of vapor. Prevent contact with skin. Do not take internally. Material is applied hot. Appropriate clothing and eye protection should be used to prevent severe burns. Do not mix with other adhesives except to flush system as noted above. **USE ONLY WITH ADEQUATE VENTILATION.**

NOTE

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

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2/2010 csw
09/30/2008 JM