



TECHNICAL DATA SHEET

Thermogrip® 6368

HOT MELT ADHESIVES

Product Description

Bostik® Thermogrip® 6368 is a short open time hot melt adhesive which exhibits good shear strength and good adhesion to porous materials such as paper, cardboard, filter paper and fabric.

This product may be compositionally compliant to one or more FDA regulations for food packaging. Please contact the Bostik Regulatory Department for up-to-date FDA compliance information.

Product Benefits

- Wide temperature service range
- Short open time and quick set up
- Withstands elevated temperatures
- Good cold resistance

Product Applications

- Case and carton sealing
- Foam to fabric applications
- Display boards
- Filter assembly

Specific Information

Electrical Properties

Dissipation Factor:	0.07
Capacitance, PF:	65
Dielectric Constant:	3.5
Dielectric Strength, KV cm-1:	180

Application Information

1. All surfaces should be clean and free of contaminants. If necessary, clean surfaces with solvent.
2. Apply the adhesive to the more difficult-to-bond surface. In general, hard, smooth surfaces are more difficult to bond than rough, porous surfaces. Metals should be pre-warmed up to 200°F (95°C) for optimum results.
3. Open-time varies depending on application temperature, amount of adhesive applied, type of substrate and ambient temperature conditions.
4. Mate the surfaces to be bonded as quickly as possible after adhesive has been applied for optimum bond strength.

Application Information (...continued)

5. Use firmest pressure practical for object being bonded. Do not move or adjust surfaces after contact has been made, as inferior bond strength will result.
6. Typically, a properly formed hot melt adhesive bond will achieve 50% of its strength after 1 minute, 75% after 1 hour, and 100% after 1 day.

Typical Physical Properties* (After 24 Hour Cure)

Color:	Light amber
Size (dia. x length):	1/2" x 4"**, 1/2" x 15"
Odor:	None
Melt Point (R &B):	210°F to 225°F 99°C to 107°C)
Specific Gravity:	0 .95 gm/cc
Viscosity, cps:	
@ 350°F (177°C)	42,500
Open Time, sec.	5 - 10
Temperature Resistance:	-50°F to 170°F (-46°C to 76°C)

Bond Characteristics

Kraft to Itself:	
Fiber Tear @ -50°F (-46°C)	No creep @ 170°F (77°C)
Polyethylene Coated Paper to Itself:	
Film Tear @ -50°F (-46°C)	No creep @ 170°F (77°C)
Chemical Resistance:	
Water	Excellent
Acids & Alkalies	Good
Fats & Oils	Fair
Solvents	Poor

Storage and Handling

Shelf Life:	730 days @ 73.4°F (23°C)
Shipping and storage:	Between 40°F to 95°F (4°C to 35°C)
Further Information:	Please refer to MSDS for complete details.

* Values given are not intended to be used in specification preparation.
** 4" length available by special order only.

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