



Thermogrip® 6305

HOT MELT ADHESIVES

Product Description

Bostik® Thermogrip® 6305 is an economical, fast setting hot melt adhesive which exhibits excellent bonding characteristics for low, medium, or high temperature packaging applications.

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.

Available in "bulk" form as HMY-1505.

Product Benefits

- Adheres a variety of coated and uncoated board stocks
- Aggressive hot tack
- Short "open time"
- Fast "set time"
- Good heat resistance to prevent pop-open during transit or storage

Product Applications

- Case and carton sealing
- Tray formulation
- At reduced application temperatures, 6305 can bond some rigid or flexible foams to wood or cardboard.

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.
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:	Pale Straw
Size (dia. x length):	1/2" x 15"
Softening Range (ASTM E-28):	230°F to 236°F (110°C to 113.5°C)
Specific Gravity:	0.9 gms/cc
Viscosity, cps: @ 350°F	1,400
Application Temperature:	335°F to 360°F (168.5°C to 182°C)
Open Time:	Short (3 to 8 secs.)
Temperature Resistance:	0°F to 160°F (-18°C to 71°C)

Bond Characteristics

Chemical Resistance	
Water	Good
Weak Acids	Fair
Fats & Oils	Poor
Solvents	Poor

Storage and Handling

Shelf Life:	999 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.

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