

PRODUCT DESCRIPTION

TECHNOMELT PUR 963A is a 100%-solids, moisture-curing hot melt adhesive designed for immediate handling strength, fast setting speed and good deflection-resistance. This product runs cleanly at a low application temperature. TECHNOMELT PUR 963A is formulated with our patented fast cure technology for high heat resistance and bond strength in hours rather than days. Also, TECHNOMELT PUR 963A contains UV dye for improved visibility under a UV light source. TECHNOMELT PUR 963A has achieved UL723 approval from the Underwriter's Laboratories with a 0/0 rating for flame propagation and smoke generation.

TYPICAL PROPERTIES

Appearance	Translucent solid
Solids	100%
Viscosity, Thermosel	Approx. 14,000 cps @ 250°F
Weight/Gallon	Approx. 8.8 lbs.
Containers	55 gallon drum, unlined
Shelf Life	9 months @ 77°F maximum from date of manufacture in unopened container.

APPLICATION

Can be applied by roll coater or slot coater adapted for reactive hot melts at material temperature of 250°F. **NOTE: Use only with adequate forced ventilation.** The recommended operating temperature range for TECHNOMELT PUR 963A is 250°F - 275°F. 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 TECHNOMELT PUR 963A will vary depending to a large extent on thermal conductivity of the substrate being coated. With surfaces that are good insulators (such as wood, foamed plastics and high pressure laminate), the open time may be as long as 7 minutes. With metals, open time may be as short as 3 minutes.

READ PRECAUTIONS ON PAGE 2 BEFORE USING ADHESIVE

ASSEMBLY BONDING

Depending on the substrates and the application, TECHNOMELT PUR 963A 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 TECHNOMELT PUR 963A to one substrate at about 6-10 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 nip-ping 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 suggested 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 TECHNOMELT PUR CLEANER through equipment. Since CLEANER will flow at 250-275°F, there is no need to change platen or hose temperature while flushing the system. Do not allow TECHNOMELT PUR 963A to cure on equipment. Cured adhesive requires special solvent for removal (e.g., n-methyl pyrroli-done) if necessary.

CAUTION

TECHNOMELT PUR 963A is a product which contains minor amounts of organic isocyanates. Health hazards have not been fully evaluated. **Use only in equipment in-tended 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

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