

**TECHNICAL DATA SHEET**

**HOT MELT ADHESIVE**

**DESCRIPTION**

This is a high performance polyamide resin adhesive especially designed for bonding applications where rapid set and high temperature resistant bonds are required. It offers good chemical resistance, fairly good flexibility, and a smooth, tack-free surface. It does not adhere to metals, glass, most plastics, or dense surfaces in general. With these properties it is a candidate for many types of assembly operations involving fibrous or porous substrates.

**TYPICAL PHYSICAL PROPERTIES and GENERAL INFORMATION**

RAW MATERIAL BASE .....	SYNTHETIC RESIN
STATIC SHEAR 2 PSI LOAD (10F/HR) ...	273 DEGREES F
METTLER SOFT. POINT (ASTM D3461) ...	352 F
STRESS/STRAIN ELONG. AT BREAK .....	610 PERCENT
STRESS/STRAIN ULT. TENSILE STR .....	1,655 PSI
T-PEEL @ 77F .....	1 LBS/IN WID
TENSILE LAP SHEAR STR. ALUM @ 77 F .	1,780 PSI
VISCOSITY @ 375F .....	9,500 cP (mPa.s)
WEIGHT PER GALLON .....	8.16 POUNDS
SHELF LIFE .....	ONE YEAR
FORM & PACKAGING .....	PELLET
RECOMMENDED APPLICATION TEMPERATURE	400 F
RING & BALL SOFTENING-HM POLYAMIDES	354 DEG.F.
VISCOSITY OF HM POLYAMIDES @ 400F. .	6,000 CP
ACID NUMBER FOR HOT MELT POLYAMIDES	6
AMINE NUMBER FOR HOT MELT POLYAMIDE	1

**EQUIPMENT SUGGESTIONS**

Any reservoir type of hot melt application equipment capable of maintaining the suggested adhesive temperature noted above, at the required melt rates. A nitrogen blanket is suggested to prolong adhesive pot life if maximum pot life is desired.

**DIRECTIONS FOR USE**

1. Purge the previous hot melt adhesive from the equipment.
2. Set the equipment temperature and line speed to the above suggested settings.
3. Adjust the pump pressure for the desired bead diameter.
4. The open and set time characteristics may be modified with small adjustments to the bead diameter and equipment temperature settings.

**CLEANUP INSTRUCTIONS**

Consult the equipment manufacturer for cleanup procedures. Scrape the unit manually with spatulas and then flush with fresh hot melt adhesive.

**STORAGE AND HANDLING**

We suggest that this product not be stored in areas where the ambient temperature will exceed 100 F. Storage of this product at temperatures exceeding 100 F may cause the product to block together, creating handling difficulties.

**SAFETY INSTRUCTIONS**

To minimize the risk of burns, we recommend the use of eye protection and protective clothing when working near a hot melt applicator. To minimize the risk of flammable vapors, do not exceed a melt temperature of 400 F. Prevent the buildup of vapors. Extinguish all sources of ignition during hot melt use. Consult the Material Safety Data Sheet for further information.

CAUTION: EXTREME CARE SHOULD BE EXERCISED WHEN WORKING WITH HOT MELTS IN THEIR HOT, FLUID STATES. Severe burns will result if skin contact occurs. When moving a hot melt pot from one location to another, it is suggested that protective gloves be worn. If skin contact occurs, immediately immerse contact area in cold, clean water for at least 30 minutes. Cover contacted area with a wet, clean compress and see a physician immediately.

**LIMITED WARRANTY AND TERMS**

H.B. Fuller Company ("Fuller") warrants that, for a Warranty Period of one year (or the period specified on the applicable Technical Data Sheet, whichever is less) from the date of shipment from Fuller to the Initial Purchaser, that this Fuller product was manufactured in accordance with Fuller's specifications in effect on the date of manufacture. These specifications are available upon request. This Warranty does not cover test data, or any defects, damages or other harms caused to any extent or in any way by failure to follow applicable Fuller instructions, if any, or abuse or misuse of the product.

**WARRANTIES DISCLAIMED** -- THE WARRANTY STATED IN THE PARAGRAPH ABOVE IS IN PLACE OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. Fuller EXPRESSLY DISCLAIMS ANY OTHER WARRANTIES, INCLUDING WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. ALTHOUGH Fuller MAY HAVE SUGGESTED THE PRODUCT OR DEVELOPED THE PRODUCT AT THE PURCHASER'S REQUEST, IT IS THE PURCHASER'S RESPONSIBILITY TO TEST AND DETERMINE THE SUITABILITY OF THE PRODUCT FOR THE PURCHASER'S INTENDED USE AND PURPOSE, AND PURCHASER ASSUMES ALL RISK AND LIABILITY WHATSOEVER REGARDING SUCH SUITABILITY.

**LIMITATIONS OF REMEDIES AND DAMAGES** -- FOR ANY VALID CLAIM PRESENTED UNDER THE LIMITED WARRANTY, Fuller WILL REPLACE THE PRODUCT, OR AT ITS OPTION, REFUND THE PURCHASE PRICE. THIS REPLACEMENT/REFUND REMEDY IS THE PURCHASER'S SOLE AND EXCLUSIVE REMEDY AGAINST Fuller. THE PURCHASER AGREES THAT NO OTHER REMEDY (INCLUDING BUT NOT LIMITED TO LOST PROFITS, LOST SALES, INJURY TO PERSON OR PROPERTY OR ANY OTHER INCIDENTAL OR CONSEQUENTIAL LOSS) SHALL BE AVAILABLE TO PURCHASER FOR CLAIMS ARISING OUT OF ANY USE OF THE PRODUCT REGARDLESS OF THE LEGAL THEORY (CONTRACT, TORT OR OTHER). IN NO EVENT WILL Fuller BE OBLIGATED TO PAY DAMAGES TO PURCHASER IN ANY AMOUNT EXCEEDING THE PRICE THAT THE PURCHASER PAID FOR THE PRODUCT.

**LIMITATION OF ACTIONS AND VENUE** -- Any claim made or action commenced by Purchaser under Fuller's limited warranty as set forth herein must be brought within one year from the date of shipment from Fuller to the Purchaser. Purchaser agrees that all disputes arising from Fuller's sale of product to Purchaser shall be brought, if at all, in and before a court located in the State of Minnesota, to the exclusion of the courts of any other state.

**CONDITIONAL ACCEPTANCE** -- Fuller's acceptance of Purchaser's order for this product is expressly conditional on Purchaser's assent to terms and conditions set forth herein.

---

**ADEQUATE TESTS:** The information contained in this bulletin we believe is correct to the best of our knowledge and tests. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that adequate tests be made in your laboratory or plant to determine if this product meets all of your requirements.