TECHNOMELT® PUR 9300

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TYPE: HOT MELT ADHESIVE

FIELD OF APPLICATION:
TECHNOMELT® PUR 9300 is a 100% solids, moisture-curing hot melt adhesive designed to provide excellent adhesion to difficult surfaces, such as polycarbonate and acrylic polymers, BMC, nylon and treated polypropylene. TECHNOMELT® PUR 9300 delivers strong handling bonds rapidly, and cures to provide excellent heat resistance and water resistant durability.

This product is normally applied by extrusion equipment adapted for reactive hot melts.

TYPICAL PROPERTIES:

APPEARANCE	Pigmented black solid
SOLIDS	100%
VISCOSITY, Thermosel	Approx. 29,000 cps @ 275°F
WEIGHT/GALLON	Approx. 9.3
CONTAINER	55 gallon drum
ALTERNATE PACKAGES	5 gallon pail 5 gallon foil bag
SHELF LIFE	6 months @ 77°F from date of manufacture in unopened container

HANDLING AND APPLICATION:
NOTE: Use only with adequate forced ventilation.
For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

The recommended operating temperature range for TECHNOMELT® PUR 9300 is 295°F-315°F. **Adhesive temperatures above 315°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.

Surface Treatment
Bonding surfaces must be clean, dry, and free of contaminants. A surface energy of 50 dynes/cm2 or higher is recommended for optimum adhesive bonding.

Lamp Bonding
Most curing hot melts produce excessive gas bubbles during cure. TECHNOMELT® PUR 9300 is designed to cure void free making it an ideal adhesive sealant for automotive head lamp bonding. Lamps can be quality tested as soon as bond lines reach ambient temperature (typically less than 4 minutes). This PURHM was designed to meet OEM adhesive specifications for headlamp bonding. Operators should ensure that this adhesive is uniformly distributed throughout the glue channel.

Combine parts as rapidly as possible to enable the hot melt maximum wetting of bonding surfaces. Typical recommendation is a maximum of 2 minutes after completion of the adhesive dispense cycle.

READ PRECAUTIONS BELOW BEFORE USING ADHESIVE

CLEAN-UP
Flush system by running non-reactive hot melt such as TECHNOMELT® PUR CLEANER 2 through equipment. Since CLEANER 2 will flow at 275-305°F, there is no need to change platen or hose temperature while flushing the system. Do not allow TECHNOMELT® PUR 9300 to cure on equipment. Cured adhesive requires special solvent for removal (e.g., n-methyl pyrrolidone) if necessary.

CAUTION
TECHNOMELT® PUR 9300 is a product which contains very 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 6 months (180 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.

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