



Ellsworth Adhesives  
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## Technical Data Sheet HMS600

Type:	Hot Melt Glue - Ethylene Vinyl Acetate
Solids:	100%
Viscosity <sup>1</sup> :	5000 cps @ 350° (F)
Shear Strength <sup>2</sup> :	423 PSI
Peel Strength <sup>3</sup> :	27 lb/in
Open Time <sup>4</sup> :	40 - 50 seconds
Mettler Softening Point <sup>5</sup> :	185° (F)
Tensile Strength	321 psi
Odor:	Slight
Shelf Life:	Indefinite
Flash Point:	Above 450° (F)

FDA Status: Compositional compliance with FDA Regulation #21-CFR,175.105 for food packaging.

Storage: Common Storage

Application Temperature: 250° (F) to 300° (F)

Suggested Uses: A hot melt adhesive designed for low, high and dual-temperature glue guns. General purpose adhesive, bonds many woods and wood composites. Excellent for woodworking, cabinetry.

Precautions: Do Not Mix with other adhesives  
Severe burns will result if contact is made in molten state.  
Material safety data sheets provide safety precautions that should be observed in handling and storing.

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<sup>1</sup> Brookfield Viscosity – ASTM D3236 using spindle SC4-27

<sup>2</sup> Shear Strength– ASTM D4498

<sup>3</sup> Peel Strength – ASTM D4498 (modified for peel mode) – using 45# Kraft paper substrates

<sup>4</sup> Open Time – ASTM D4497-94 (1999) – using 45# Kraft paper substrates

<sup>5</sup> Mettler Softening Point – ASTM D6493-99