



**TECHNICAL DATA SHEET**

**HOT MELT ADHESIVE**

**DESCRIPTION**

This product is a hot melt adhesive that has a long open time, excellent hot tack, and high as well as low temperature resistance. It shows good adhesion to metal. It is suitable for bonding fiberglass insulation to metal as well as many other general assembly type applications. This product has good initial handling strength and reaches its ultimate strength in about 72 hours.

FDA STATUS: A letter is available upon request.

**TYPICAL PHYSICAL PROPERTIES and GENERAL INFORMATION**

<b>Property</b>	<b>Value</b>
APPLICATION TEMPERATURE	350,400 deg. F
COLOR GARDNER INDEX	3 - 9
SHELF LIFE	365 day
SPECIFIC GRAVITY	0.93
SPEED OF SET	SLOW
STATIC ADHESION FAILURE TEST TEMPERATURE	190 - 240 deg. F
VISCOSITY @ 325F (9.8)	6,300 cP
VISCOSITY @ 350F (9.8 RVT SC4-27/20/350 F)	3,700 - 6,100 cP
VISCOSITY @ 375F (9.8)	3,000 cP

**CLEANUP INSTRUCTIONS**

Consult the equipment manufacturer for cleanup procedures. After clean-up, flush the applicator thoroughly with hot melt adhesive to purge the system.

**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 above 400F. Prevent the build-up of vapors. Extinguish all sources of ignition during hot melt use.



**H.B. Fuller**

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**HL-6369**  
PRODUCT NUMBER

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**UNDERWRITERS LABORATORIES RECOGNITION INFORMATION**

This adhesive is intended to secure insulation materials to metal panels of warm air heating appliances, blowers, air conditioning equipment and similar devices. It has been investigated under the Recognition Program, category Insulation Adhesives (MAGW2), and found to comply with the requirements included in the current editions of UL 1995, Standard for Heating and Cooling Equipment, and UL 727, Standard for Oil-Fired Central Furnaces, etc. The Underwriters Laboratories Inc. reference file is MH7871, Volume 3, Section 1.

**FIRE HAZARD TESTING:** Samples consisted of HL-6369-X applied at 1200 sq ft/gal to 1/4" thick sterling board. The test was conducted in accordance with Underwriters Laboratories Standard Test for Surface Burning Characteristics of Building Materials (UL 723) yielding the following results:

**FLAME SPREAD:** 2.4

**SMOKE DEVELOPED:** 4.9



**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.

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**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.