



## TECHNICAL DATA SHEET

### HOT MELT ADHESIVE

#### DESCRIPTION

This is a general purpose pressure sensitive adhesive with excellent adhesion to a wide variety of substrates.

FDA STATUS: A letter is available upon request.

#### TYPICAL PHYSICAL PROPERTIES and GENERAL INFORMATION

RAW MATERIAL BASE .....	SYNTHETIC RESIN
90 DEGREE PEEL TEST .....	3.2 LBS/LIN IN
180 DEGREE PEEL (60 SEC/75F, 1 MIL) .....	7.3 LBS/INCH
MOLTEN GARDNER COLOR .....	7
POLYKEN TACK .....	1,100 GRAMS
LOOP TACK .....	130 OUNCES
VISCOSITY @ 300F .....	40,000 cP (mPa.s)
VISCOSITY @ 350F .....	9,000 cP (mPa.s)
WEIGHT PER GALLON .....	7.72 POUNDS
SAFT (500 GMS/IN <sup>2</sup> LOAD) .....	175 DEGREES F.
SHELF LIFE .....	ONE YEAR
FORM & PACKAGING .....	PILLOW, DRUM
RECOMMENDED APPLICATION TEMPERATURE .....	325 F

#### APPLICATION AND CLEANUP

An inert gas blanket is recommended while the adhesive is molten to ensure the best retention of physical properties. Consult the equipment manufacturer for cleanup procedures, or flush the unit with mineral oil at 250F. Flush the applicator thoroughly with hot melt to purge the system.

#### SAFETY

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.



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**HM-1597**  
PRODUCT NUMBER

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#### **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.

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**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.