



**TECHNICAL DATA SHEET**

**DESCRIPTION**

Polyamide hot melt adhesive designed for cabinet assembly.

**TYPICAL PHYSICAL PROPERTIES and GENERAL INFORMATION**

RAW MATERIAL BASE .....	SYNTHETIC RESIN
HARDNESS .....	75
PROGRAMMED 100 GRAM OVEN PEEL .....	207 DEGREES F
PROGRAMMED OVEN SHEAR .....	270 DEGREES F
METTLER SOFT. POINT (ASTM D3461) ...	292 F
SPECIFIC GRAVITY .....	0.9781
VISCOSITY @ 375F .....	4,400 cP (mPa.s)
SHELF LIFE .....	ONE YEAR
FORM & PACKAGING .....	PELLETS
RECOMMENDED APPLICATION TEMPERATURE	400 F
RING & BALL SOFTENING-HM POLYAMIDES	290 DEG.F.
VISCOSITY OF HM POLYAMIDES @ 400F. .	2,300 CP
ACID NUMBER FOR HOT MELT POLYAMIDES	1
AMINE NUMBER FOR HOT MELT POLYAMIDE	7

**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 adhesive 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.



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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.