

### TYPE

PUR Hotmelt Adhesive for Lamination and Assembly

### CHARACTERISTICS

Reactive hotmelt adhesive system based on polyurethane. High initial strength. Chemical cross-linking within few days. Bond joint turns into a thermoset. Very high heat resistance (> 150 °C/> 302 °F) and cold flexibility. Excellent water resistance. Resistant to most solvents.

### FIELDS OF APPLICATION

Lamination, General assembly work, Assembly bonding of wooden parts and Gluing of textiles and plastics

### TECHNICAL DATA

Softening point (Kofler): approx. 55 °C (131 °F)

Viscosity (Brookfield): approx. 10 000 mPa·s/130 °C (266 °F)

Curing time to final strength: 2-5 days depending on substrate

Heat resistance: > 150 °C (302 °F)

*according to the DORUS method of increasing temperature*

### INSTRUCTIONS FOR USE

Recommended working temperature in the melting container: 100 - 140 °C (212 - 284 °F) at the application roller: 100 - 140 °C (212 - 284 °F). Recommended application amount: 50 - 400 g/m<sup>2</sup> depending on substrate. Since the product will cure when it is exposed to moisture, storage and application must be done under dry conditions. For this reason, the product is delivered in airtight containers.

### CLEANING

Cleaning the system periodically or prior to changing to an alternative reactive hot melt will reduce internal buildup of adhesive residue. Application devices such as wheels and rolls that expose reactive adhesive to the air should be thoroughly flushed with *Purmelt Cleaner 3* at the end of a production run or at anytime when there is build-up and gelling. For cleaning the melting unit with *Purmelt Cleaner 4* is recommended. Cured PUR hot melt can only be removed by softening with an appropriate solvent such as N-ethyl-pyrrolidone (NEP) and then using a non-abrasive scraper. Strictly follow the instructions of the machine manufacturer.

### DELIVERY FORM

Blocks in aluminium laminated flexible packaging (Peelable Bag)

### STORAGE

Store in a cool, dry place in the unopened original container for up to 12 months (2 kg container for up to 9 months).

### LABELLING

The safety datasheet should be respected!

### SAFETY

The product contains diphenylmethanediisocyanate. Even if the product is applied within the range of the recommended working temperature, the diisocyanate has a detectable vapour pressure. When the recommended working temperature is considerably exceeded, hazardous decomposition products may be formed in the application unit. Therefore, measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment. In case of skin contact with the hotmelt, do not try to remove the adhesive from the skin by force. Consult a doctor. Observe the material safety data sheet.

### Note

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