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Bostik®

CONSUMER DIVISION

Reading, Pa. 19605

EMHART

PRODUCT DATA: THERMOGRIP[®] BRAND 6360/6361 HOT MELT ADHESIVE

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PRODUCT DESCRIPTION

A general purpose polyethylene based hot melt adhesive in stick form, provided in two lengths. It is designed for use in the Thermogrip Glue Guns and has excellent bonding characteristics for assembly and spot repair work involving wood, some metals, paper, fabrics, ceramics, leather and plastics such as polyethylene, polystyrene and polyurethane foam products. THERMOGRIP 6360/6361 are manufactured in accordance with F.D.A. Regulation 21 CFR 175.105 for Food Packaging Adhesives.

ADHESIVE CHARACTERISTICS

Form:	Cylindrical stick 1/2 inch diameter in two lengths 4 inches long designated Thermogrip 6360 2 inches long designated Thermogrip 6361
Color:	Cream
Odor:	Slight
Softening Range: (ASTM E 28):	75° C to 92° C (167° F to 197° F)
Specific Gravity:	0.98
Viscosities (Brookfield Thermosel) (ASTM D 3236):	13,000 cps @ 192° C (375° F) 10,125 cps @ 205° C (400° F)
Storage Life:	No significant chemical change up to 12 months. Blocking of adhesive to itself may occur at temperatures above 44° C (110° F).

BOND CHARACTERISTICS

Service Temperature Range:	-29° C to 52° C (-20° F to 125° F)
Chemical Resistance:	
Water	Good
Weak Acids & Alkalies	Fair
Fats and Oils	Poor
Solvents	Poor
Bond Strength:	Plywood @ 21° C (70° F)
Shear	565 psi (40 kg/gm ²)
Recommended Bonding Temperature	375° F to 425° F

APPLICATION INFORMATION

1. All Surfaces should be clean and free of loose elements. If necessary, wipe plastic or metal surfaces with solvent.
2. Apply the adhesive to the more difficult to bond surface. In general, hard, smooth surfaces are more difficult to bond than rough, porous surfaces.
3. Mate the surfaces to be bonded as quickly as possible after adhesive has been applied, for optimum bond strength.
4. Use firmest pressure practicable for object being bonded. Do not move or adjust surfaces after contact has been made, as inferior bond strength will result.
5. As a rule of thumb, a properly formed hot melt adhesive bond will achieve about 50% of its strength after 1 minute, 75% after 1 hour and 100% after 1 day.
6. Bonding is enhanced by pre-warming the surfaces. Metals should be pre-warmed to at least 95° C (200° F) for optimum effect.

OPEN TIME

15 to 20 seconds, but variable, depending upon the nature of the substrate, application temperature, thickness of adhesive applied, and closing pressure.

DANGER—THERMOGRIP Adhesive is extruded as a molten thermoplastic material with temperatures ranging up to 232° C (450° F) **DO NOT TOUCH** the molten adhesive. Bodily contact can cause serious burns.

SOLUBILITY

Use common dry cleaning solvents, or an oil base solvent, along with brushing and/or scraping action to remove spillage.

CATALOG NUMBERS

219 4 inch boxes
229 4 inch cards
22219 4 inch bulk case

212 2 inch boxes
220 2 inch cards
22020 2 inch bulk case

IMPORTANT NOTICE

1. All statements and technical data contained herein are based on tests we believe to be reliable, but the accuracy of completeness thereof is not guaranteed.
2. The buyer must test this product to determine its suitability for his application before use.
3. Do not use this product until after consulting instructions on this Data Sheet for this product.
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