TECHNOMELT

Technical Data Sheet

TECHNOMELT PUR 9622-02

April 2015

PRODUCT DESCRIPTION

TECHNOMELT PUR 9622-02 provides the following product characteristics:

Technology	Polyurethane
Product Type	Hotmelt
Application	Bonding and lamination of interior parts
Appearance	light ivory

Application Areas

- Lamination of exterior rear view mirrors, doors and pillars
- Lamination of textile compounds
- Bonding of retainer and other mounted parts

Product Properties

- Reactive hotmelt adhesive system based on polyurethane
- High initial strength
- Chemical cross-linking within a few days
- Forms an insoluble, thermoset film
- High final bond strength
- Very high heat resistance (> 150° C/> 302° F) and cold flexibility
- Excellent water resistance

TECHNICAL DATA

TECHNOMELT PUR 9622-02 :

Softening Point, Kofler, °C	~64
Viscosity, Brookfield-, 130° C, mPa.s	~45,000
Heat Resistance, °C	>150
Tested with 0.6 mm oak veneer using the Henkel method of increasing temperature.	
Curing Time to final strength, days	2 to 5

DIRECTIONS FOR USE

Preliminary Statement:
Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use

Working Temperature
Recommended working temperature:

in the melting container, °C	120 to 140
at the application roller, °C	120 to 140

Processing
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
Flushing the system with TECHNOMELT PUR CLEANER 2 periodically or prior to changing to an alternative reactive hot melt will reduce internal build-up of adhesive residue. Application devices such as wheels and rolls that expose reactive adhesive to the air should be thoroughly flushed at the end of a production run or at anytime when there is build-up and gelling. 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.

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.

Storage
Store in a cool, dry place in the unopened original container for up to 12 months.

Classification
Please refer to the corresponding **Material Safety Data Sheets** for details on:
Hazardous Information
Transport Regulations
Safety Regulations

ADDITIONAL INFORMATION

Disclaimer

Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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