

TECHNOMELT PUR 6204-02

Known as Purmelt QR 6204-02

April 2013

PRODUCT DESCRIPTION

TECHNOMELT PUR 6204-02 provides the following product characteristics:

Technology	Polyurethane
Product Type	Hotmelt
Application	Edgebanding Softforming Straightline
Appearance	310 ml aluminium cartridges

Application Areas

- Edgebanding as from feedrates of 15 m/min
- Edging material: solid wood, veneer, melamine, polyester, HPL*, PVC*, ABS*, PP*
- Particularly suitable for softforming

* Suitability depends on the individual characteristics of the edging material and how it is primed. In case of thick edges pre-tests should be carried out for suitability.

Product Properties

- Reactive hotmelt adhesive system based on polyurethane
- High initial strength
- Chemical cross-linking within 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
- Produces tight joints
- Clean working
- Suitable for nozzle application

Technical Data**TECHNOMELT PUR 6204-02:**

Softening Point, Kofler, °C	~64
Viscosity, Brookfield -, 150 °C, mPa.s	~55,000
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 OF USE**Preliminary Statement**

Prior to application 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	135 to 150
at the application roller, °C	135 to 150

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 4 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-ethylpyrrolidone (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 **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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:

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. 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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Trademark usage

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 0.0

Henkel AG & Co. KGaA
73438 Bopfinger, Germany
Phone: +49-7362-81-0

Henkel Corporation
Bridgewater, NJ 08807, USA
Phone: +1-908-685-7000

Henkel (China) Co.Ltd.
201203 Shanghai, China
Phone: +86-21-2891-8000