TECHNOMELT

Technical Data Sheet

TECHNOMELT PUR 4663 JC-20

Known as TEROREHM 4663 JC-20
August 2015

PRODUCT DESCRIPTION

TECHNOMELT PUR 4663 JC-20 provides the following product characteristics:

Technology	Polyurethane
Product Type	Hotmelt
Application	Lamination and assembly

TECHNOMELT PUR 4663 JC-20 is a high performance, reactive, moisture curing hotmelt adhesive based on Polyurethane-Prepolymers.

The adhesive is pressure sensitive and gives a special high initial strength instantly after joining the parts.

Therefore it is suitable for substrates with a very high reaction force.

Additionally it has a long open time so that joining is still possible after cooling.

After moisture curing the product has duroplastic properties and a very high heat and cold resistance.

Application Areas:

TECHNOMELT PUR 4663 JC-20 was especially designed for industrial flat lamination but may also be used for assembly application.

The adhesive has a very broad adhesion spectrum and demonstrates also good flexibility.

It can be used to bond wood, plastic, textiles, different films and foams and is also well suitable for bonding pretreated substrates.

TECHNICAL DATA

(as supplied)

Colour	opaque when molten, after cooling light ivory, crystalline in UV-light fluorescent
Odour	weak characteristic
Density, g/cm³	1.13 to 1.23
Solid content, %	100
Viscosity (130 °C), Pa. s	6,000 to 12,000
Equipment	Brookfield
Measuring system	Thermosel SP 27
Open time, s	~90 (depending on mode of application, layer thickness and the substrates)
Application temperature, °C	110 to 140

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.

Pretreatment:

The bonding surfaces must be clean, dry and free of oil and grease.

Substrate temperature should not fall below 20°C during application.

Lower temperatures will lead to an early solidification of the adhesive and thus to a reduced open time, possibly the adhesive might even flake off.

If necessary the substrates may be prewarmed, however, longer open times and thus extended cycle times will have to be taken into consideration at temperatures above 45°C.

Application:

TECHNOMELT PUR 4663 JC-20 can be applied from heatable cartridge guns, from usual tank melting equipment

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and from drums or hobbocks, using heatable equipment.

The material may be applied by nozzle, roller, foamable and sprayable systems.

At longer rest periods melting and application temperatures should be decreased.

Longer exposure to higher temperatures can lead to a viscosity increase.

Curing:
TECHNOMELT PUR 4663 JC-20 cures exclusively by moisture and gains its final strength after 3 to 7 days, but exhibits high handling strength after the physical process of setting.

Curing is a chemical reaction depending on the following parameters:

- humidity of the substrates (carrier and decor)

- humidity in the rooms of application and storage

- permeability of the substrates to be bonded

- application weight/layer of the adhesive film

Cleaning:
As long as TECHNOMELT PUR 4663 JC-20 is not cured application equipment can be cleaned with Purmelt Cleaner 02. (See separate Technical Data Sheet). Cured adhesive can only be removed mechanically.

Classification:
Please refer to the corresponding **Material Safety Data Sheets** for details on:
Hazards identification
Transport information
Regulatory information

Storage:

Frost-sensitive	no
Recommended storage temperature, °C	5 to 25
Shelf-life, months (in unopened original packaging)	12

ADDITIONAL INFORMATION

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