Technical Data Sheet

TECHNOMELT® PUR 4663

September 2023

Product description

TECHNOMELT® PUR 4663 provides the following product characteristics:

Technology	Polyurethane
Product type	Hotmelt
Application	Lamination, Assembly
Appearance	Translucent solid

Application areas

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

Product properties

- 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) and cold flexibility
- Excellent water resistance
- Fluorescent (UV-light)

Technical data

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Softening Point, Ring & Ball, °C	~65
Viscosity, Brookfield - 130 °C, mPa.s (cP)	~10 000
Heat resistance, °C according to the Henkel method of increasing temperature	>150
Curing time to final strength, days (depending on substrate)	2 to 5

Directions for use

Preliminary statement

Prior to use it is necessary to read the **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.

Working conditions:

Recommended working temperature	
In the melting container, °C	100 - 140
At the application roller, °C	100 - 140
Recommended application amount (depending on substrate), g/m^2	50 - 400
Recommended room temperature, °C	18 - 35
Recommended humidity, %	30 - 60

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. We recommend for the cleaning of the application equipments TECHNOMELT® PUR CLEANER ME or TECHNOMELT® PUR CLEANER ALL-IN-1. When working with the cleaning agents safety instructions must be considered. Follow also strictly 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 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 safety data sheet.

Storage

Store in the original tightly closed packaging in a cool, dry place.

Shelf life

Shelf-life (in unopened original packaging), months	12
(2 kg container for up to 9 months)	

Classification
Please refer to the corresponding **Safety Data Sheets** for details on:

- **Hazards identification**
- **Transport information**
- **Regulatory information**

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