

TECHNOMELT® PUR 5013GP

September 2025

Product description

TECHNOMELT® PUR 5013GP provides the following product characteristics:

Technology	Polyurethane
Product type	Hotmelt
Application	Flat lamination
Appearance	Off-white color solid
Cure	Humidity curing

Product properties

TECHNOMELT® PUR 5013GP is a one-component polyurethane reactive hot melt adhesive. It is designed to give aggressive tack, long open time and high green strength. The product cures through reaction with moisture to form a tough, strong, and virtually thermoset polymer.

Application areas

TECHNOMELT® PUR 5013GP can be used for lamination of sandwich panel elements of wood, lauan, fiberboard, particleboard, plywood, FRP, EPS foam, PU foam, surface-treated metals & thermoplastics with thermoplastic foils (vinyl, PET, acrylics), paper, and HPL.

Technical data

TECHNOMELT® PUR 5013GP:

Viscosity, @250°F, mPa.s (cP)	Approx. ~12.000
Viscosity, @290 °F, mPa.s (cP)	Approx. ~ 6.000
Open time, min.	~ 1-2
(variable based on ambient temperature and substrate thermal conductivity)	

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.

Application

Application method

TECHNOMELT® PUR 5013GP is typically applied by roll coating. Deposition rate can vary from 8 - 20 g/sft depending on substrate porosity.

Working temperature

Recommended working temperature: 250 - 290°F.

Substrate preparation

Surface must be free of oil, grease, lubricants, dust, and any other surface contaminants. Aluminum or other metals must be conversion coated or primed for best adhesion.

Curing

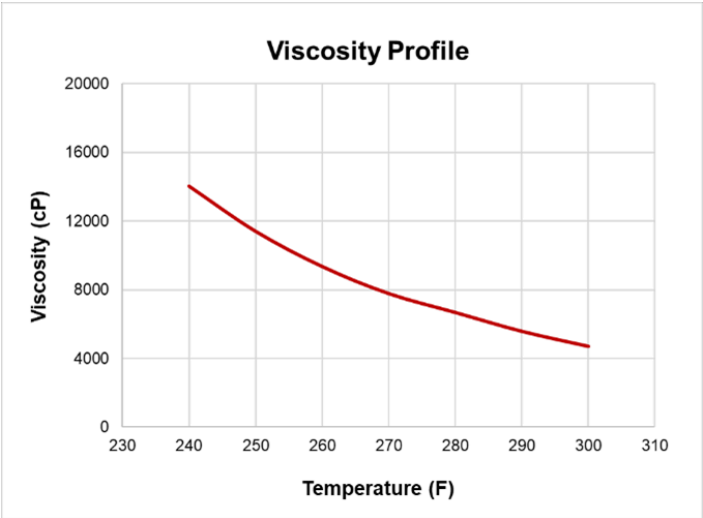
Curing is accomplished through reaction with moisture. The moisture can be provided by the substrate, through absorption from the atmosphere, or a combination of both. Under extremely dry conditions a light water-mist will help the cure. High temperatures accelerate curing.

Cleaning

Flushing the system with TECHNOMELT® PUR CLEANER 4 periodically or prior to changing to an alternative reactive hotmelt 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.

The process may be assisted with use of TECHNOMELT® PURCLEANER ALL-IN-ONE. Strictly follow the instructions of the machine manufacturer.



Handling Information

This product contains isocyanate. Read SDS before handling and using this product. Store in a dry area at 60 - 95°F. Use only in equipment in-tended for reactive hot melts. Do not use in conventional hot melt equipment. Forced ventilation must be provided over applicator and melting equipment to remove any small amount of isocyanate vapors to the outside. All users of RHM products should maintain an ongoing industrial hygiene program. This program should include contingency provisions in the event of ventilation failure as well as MDI monitoring.

Storage Rotate stock and use oldest material first. Do not expose to the atmosphere or otherwise contaminate with moisture. Moisture contamination will cause a sharp melt viscosity increase and a cured skin on top of the container. Containers must be used completely after opening. Do not attempt to reseal.

Shelf life

Shelf-life (in unopened original packaging), months 6

Classification

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

Hazardous Information**Transport Regulations****Safety Regulations****Additional information****Disclaimer**

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.

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Reference 2

Henkel AG & Co. KGaA
40191 Düsseldorf, Germany
Phone: +49-211-797-0

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

Henkel Diadema
Diadema - SP, Brasil
Phone: +55-11-3205-8955

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

Henkel Jebel Ali FZCO
Dubai, UAE
Phone: +971-4-3893333