

TECHNOMELT® PUR 608C

December 2023

Product description

TECHNOMELT® PUR 608C provides the following product characteristics:

Technology	Polyurethane
Application	Assembly
Appearance	Off white solid

Product properties

TECHNOMELT® PUR 608C 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 608C can be used for assembly of wood, lauan, fiberboard, particleboard, plywood, FRP, EPS foam, PU foam, and surface-treated metals. It can also be used to laminate and assemble soft plastics and other flexible substrates. Difficult-to-bond substrates such as corrugated PP need to be surface treated in order to achieve good bonding strength.

Technical data

TECHNOMELT® PUR 608C:

Solids content, %	100
Viscosity, mPa.s (cP) at 250°F	Approx. 10000
Open time, seconds	Approx. 50

Open time will vary depending to a large extent on the thermal conductivity of the substrate being coated. With surfaces that are good insulators (such as wood, foamed plastics and high pressure laminate), the open time may be extended; while with metals, open time may be shortened.

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

TECHNOMELT® PUR 608C can be applied by roll coating, slot die coating, extrusion or swirl spray systems adapted for reactive hot melts. Deposition rate can vary from 10 to 20 g/sft, depending on substrate porosity. Surface must be free of oil, grease, lubricants, dust, and any other contaminants. Aluminum or other metals must be conversion coated or primed for best adhesion. Difficult-to bond substrates need to be surface-treated to achieve structural bonding strength. Always test any new substrates before switching.

Application temperature

Recommended application temperature is 250 - 275 °F.

Depending on the processing and performance needs of the application, temperatures may vary. However, Adhesive temperatures above 300 °F should be avoided. NOTE: Use only with adequate forced ventilation. READ PRECAUTIONS BEFORE USING ADHESIVE.

Processing

Reactive hotmelt adhesives have a limited thermal stability even when working at the specified working temperatures. Therefore, we recommend that a period of 4 hours without production, that the unit is either switched off, or the set temperatures on the unit be reduced to 60 °C.

Curing

Full cure will take place in approximately 2 - 5 days.

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

Henkel offers a selection of TECHNOMELT®PUR Cleaners to facilitate the removal of cured and uncured materials. To clean hoses and nozzles, use TECHNOMELT®PUR Cleaner 2, Cleaner 4, Cleaner ME or Cleaner All-In-One. To clean uncured material from the rolls of roll coaters, use Cleaner 785A. To facilitate removal of cured material from the rolls of roll coaters, use Cleaner 7. TECHNOMELT®PUR Cleaner 3030 and M-O-C may be used to remove uncured hot melt from surfaces. Some cured material may require removal by mechanical means or the use of a special solvent for removal (e.g., n-methyl pyrrolidone) if necessary.

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

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Reference 1

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