TECHNOMELT

Technical Data Sheet

TECHNOMELT PUR 9350

Known as Terorehm MC 9350
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PRODUCT DESCRIPTION

TECHNOMELT PUR 9350 provides the following product characteristics:

Technology	Polyurethane
Product Type	Hotmelt
Application	Bonding

TECHNOMELT PUR 9350 is a high performance, moisture curing hot melt adhesive based on polyurethane. The uncured product is wax-like and demonstrates the following characteristics:

- Very good application properties.
- Good wetting properties of the molten mass to many substrates.
- High initial strength after solidification.

TECHNOMELT PUR 9350 cures by **moisture** forming a duroplastic material, demonstrating the following characteristics:

- High softening point above 100°C.
- Excellent flexibility at low temperatures.
- Good chemical resistance (e.g. to fuel-oil mixture, numerous plasticizers, solvents, aqueous surfactants, salt spray).
- Adhesión to shaped fibre materials, Wood, foils (soft PVC, TPO), textiles, thermoplastics (e.g. ABS, ABS/PC, PA, etc.) and - after pretreatment - also to nonpolar plastics (e.g. PE, PP, etc.).

Application Areas:

TECHNOMELT PUR 9350 is primary used for headlamp bonding. It can be also used for assembling areas at interior parts for the automotive industry and sub-contractors.

TECHNICAL DATA

(as supplied)
Uncured:

Colour	black
Odour	weak
Density	1.18 to 1.28 g/cm³
Solid content, %	100
Viscosity (at 130 °C)	12.500 ± 3.500 mPa.s
Equipment	rotation viscosimeter Brookfield
Measuring system	Thermosel SP 27
Speed, rpm	5
Softening point, °C DIN 52011	~65 °C
Open time	approx. 60 s (depending on mode of application, layer thickness and the substrates)
Application temperature (*)	90 to 140°C (maximum 150°C for a short period of time)

After curing:

Shear strength at 20°C
(based on DIN EN 1465):

In service temperature range	-40 to 120°C
Short exposure (up to 1 h)	130°C

* Application temperature among other things also depends on the substrate to be boned. Because many common plastics contain internal accessory agents (slip additives, reléase agents, binding agents, etc.), they very often can only be bonded safely at very high temperaturas (>150°C).

We urgently recommend trials prior to bonding!

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 9350 can be applied from heatable cartridge guns, from usual tank melting equipment and from drums or hobbocks, using heatable equipment.
The material may be applied by nozzle, roller, foamable and sprayable systems.

Curing:
TECHNOMELT PUR 9350 cures exclusively by moisture and gains its final strength after 4 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 in the rooms for application and storage (assure possibility of humidity access; the adhesive will react extremely slowly with parts being wrapped in plastic foils!)

- humidity of the substrates (carrier and decor)

- permeability of the substrates to be bonded

- application weight/layer of the adhesive film

If required, we will assist you to determine your specific process data.

Cleaning:
As long as TECHNOMELT PUR 9350 is not cured application equipment can be cleaned with Purmelt Cleaner 02. (See separate Technical Data Sheet). Cured adhesive can only be removed mechanically.

Storage:

Frost-sensitive	no
Recommended storage temperature, °C	10 to 25
Shelf-life, months (in unopened original packaging)	12 months

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

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.

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