



HL3910EI

DESCRIPTION :

HL3910EI is a Hot Melt Moisture Cure product is a one-component polyurethane, 100% solids hot melt adhesive.

APPLICATION FEATURES:

It has characteristics of a pressure sensitive adhesive, but optimal adhesion is achieved from 10 seconds to 1minutes after application. This product has good hot tack and cures in the presence of water to a tough, elastomeric film. It works well in bonding various plastics, woods, metals, and glass substrates.

CHARACTERISTICS :

- Appearance :** Water-white
- Brookfield viscosity:** Approx. 4,500 mPa.s at 130°C
- Film open time:** >3minutes(depends on different operating conditions)
- Coverage:** 40-120 g/m²
- Application Temperature :** ~130°C depending on the operating conditions.
- Application Methods :** Can be run on all standard hot melt roller systems.
- Shelf Life :** 6-12 months

WORKING INSTRUCTIONS :

PRETREATMENT OF BONDING SURFACES
Bonding surfaces have to be clean, dry and free of grease and oil.
Polyolefin materials have to be corona-pretreated or flame-treated.

PREPARATION:

Drum unloader, heating plate, conveyor pump and applicator gun can, as a rule, be set to different

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temperatures. Excessive heat may cause decomposition of the adhesive. Depending on the construction of the equipment, a temperature of up to 160°C is sufficient for the heating plate and the conveyor pump. Due to the short operation time, the application equipment may be run at temperatures of up to 160°C. For tank melters only protective gases with < 5ppm humidity should be used. Positive results have been achieved with nitrogen. Please take care of that packages are used immediately after opening in order to prevent possible reactions with moisture.

ADHESIVE APPLICATION :

This product is either applied in beads or tapes or as a sheet onto one of the bonding surfaces. Bonding is carried out immediately upon application.

SPECIAL ATTENTION :

Final cure is achieved by reaction with ambient moisture or moisture from the substrate. Curing time depends on the access of humidity to the bonding seam, i.e. the humidity of the substrate, substrate permeability, adhesive film thickness, relative air humidity and ambient temperature.

Average curing time for bonding onto wooden materials at a temperature of 20°C and relative humidity of 65% amounts to up to 3-4 days. If large surfaces and/or impermeable materials are bonded under unfavorable climatic conditions, the curing time may be considerably longer.

CURING CONDITIONS :

To obtain complete cure, this product should be exposed to temperatures and relative humidity conditions greater than or equal to 77°F and 50% RH. For adhesive film thicknesses 0.020 inches or less, cure is typically completed in 7 days under these conditions. Complete cure will take longer at lower temperatures and lower RH. Cure rates and completeness of cure will vary with adhesive film thickness and substrate's water-permeability. Consult your H.B. Fuller representative for more information.

CLEAN UP:

To clean spilled adhesive, allow the adhesive to cool to room temperature and scrape off heavy deposits with a putty knife. Any uncured residual film may be wiped clean with common polyurethane solvent (toluene, MEK). Clean

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the adhesive before it cures. Cured adhesive can only be cleaned with extremely high heat (>800°F) or an aggressive solvent such as heated N-methyl-pyrrolidone.

Health & Safety Precautions :

Severe burns will result if skin contact occurs. Wear appropriate gloves and long sleeve garments to protect from burns and skin sensitization. Wear protective eyewear to minimize the risk of eye contact. If skin contact occurs, immediately immerse contact area in cold, clean water for at least 30 minutes. Cover contacted area with a wet, clean compress, and see a physician immediately. Use this adhesive in a well-ventilated area. Local exhaust ventilation should be provided at the point of application and over the pre-melting reservoir. Monitor the level of free methylene bisphenyl diisocyanate (MDI) in the operator's work zone during application. OSHA regulations state that the maximum exposure of the operator should not exceed 20 parts per billion (ppb). The time weighted average exposure over an 8-hour period should not exceed 5ppb. Exceeding the recommended application temperature may increase the levels of airborne MDI. Consult the MSDS for more details.

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