



## TECHNICAL DATA SHEET

# Thermogrip® 6390

# HOT MELT ADHESIVES

## Product Description

Bostik® Thermogrip® 6390 is a general purpose, medium open time hot melt which exhibits good shear strength and good adhesion to a variety of plastics, wood and porous materials.

This product may be compositionally compliant to one or more FDA regulations for food packaging. Please contact the Bostik Regulatory Department for up-to-date FDA compliance information.

## Product Benefits

- Medium open time means more assembly time
- Wide temperature service range
- Excellent bonds to a wide range of materials

## Product Applications

- Furniture and cabinet industry
- Displays—plastic-to-cardboard
- Carpet to cardboard
- Decorative overlays
- Fabric-to-particle board

## Application Information

1. All surfaces should be clean and free of contaminants. If necessary, clean surfaces with solvent.
2. Apply the adhesive to the more difficult-to-bond surface. In general, hard, smooth surfaces are more difficult to bond than rough, porous surfaces.

**Metals should be pre-warmed up** to 200°F (95°C) for optimum results.

3. Open-time varies depending on application temperature, amount of adhesive applied, type of substrate and ambient temperature conditions.
4. Mate the surfaces to be bonded as quickly as possible after adhesive has been applied for optimum bond strength.
5. Use firmest pressure practical for object being bonded. Do not move or adjust surfaces after contact has been made, as inferior bond strength will result.

## Application Information (...continued)

6. Typically, a properly formed hot melt adhesive bond will achieve 50% of its strength after 1 minute, 75% after 1 hour, and 100% after 1 day.

## Typical Physical Properties\* (After 24 Hour Cure)

Color:	Light straw
Size (dia. x length):	1/2" x 4"**, 1/2" x 15"
Odor:	Slight
Softening Range (R&B):	172°F to 190°F (78°C to 88°C)
Viscosity, cps:	
@ 350°F (177°C):	12,500
Open Time:	40 secs.
Melting Point (R&B):	192°F to 203°F 89°C to 95°C
Temperature Resistance:	-40°F to 160°F (-40°C to 76°C)

## Bond Characteristics

Bond Strength, Shear, lbs.:	
Phenolic board:	460
ABS:	350
Lexan:	390
Preheated aluminum:	485
Polyethylene:	360
Plywood:	420

## Storage and Handling

Shelf Life:	999 days @ 73.4°F (23°C)
Shipping and storage:	Between 40°F to 95°F (4°C to 35°C)
Further Information:	Please refer to MSDS for complete details.

\* Values given are not intended to be used in specification preparation.

\*\* 4" length available by special order only.

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