

HOT MELT TECHNICAL DATA

BULK HOT MELTS

PRODUCT	COLOR	FORM	ODOR	SOFTENING RANGE	TYPICAL VISCOSITY @ 400°F	TEMPERATURE RESISTANCE	OPERATING TEMPERATURE	MAX** OPEN TIME	FEATURES
4101	Amber	¼ in. Pellet	None	233° to 262°F	96,000 cps	-50° to 200°F	375° to 450°F	7 sec.	Excellent plasticizer resistance. <input type="checkbox"/> Excellent resistance to solvents, heat and oil. <input type="checkbox"/> High performance adhesion.
4165	Cream	¼ in. Pellet	None	304° to 320°F	61,000 cps	-50° to 250°F	400° to 475°F	2 sec.	Provides excellent bonds on vinyls and woven or non-woven fabrics. <input type="checkbox"/> Excellent plasticizer resistance. <input type="checkbox"/> Excellent heat resistance.
4252	Light Amber	¼ in. Pellet	None	251° to 272°F	2,200 cps	-20° to 250°F	350° to 425°F	10 sec.	High heat resistance. <input type="checkbox"/> Low operating viscosity. <input type="checkbox"/> Bonds many porous substrates.
4315*	Light Amber	¼ in. Pellet	None	225° to 235°F	17,000 cps	-40° to 185°F	325° to 425°F	6 sec.	General purpose adhesive. <input type="checkbox"/> Bonds many packaging and porous materials.
4342*	Amber	¼ in. Pellet	None	230° to 240°F	30,000 cps	-20° to 165°F	375° to 425°F	5 sec.	Good adhesion to high pressure laminates. <input type="checkbox"/> Excellent edgbanding adhesive. <input type="checkbox"/> Bonds wood and particleboard.
7102	Light Tan	Granular	None	200° to 225°F	50,000 cps	-15° to 165°F	350° to 450°F	7 sec.	Good plasticizer resistance. <input type="checkbox"/> Bonds plastics, wood and paper. <input type="checkbox"/> Particularly suited for vinyl.
7116	Light Tan	Granular	None	259° to 277°F	20,000 cps	-20° to 250°F	375° to 450°F	3 sec.	High performance. <input type="checkbox"/> Bonds fabrics, PVC, films and foils. <input type="checkbox"/> Excellent for vinyl edge folding.
7210	Light Amber	Granular	None	225° to 250°F	2,500 cps	-20° to 180°F	350° to 400°F	15 sec.	Low operating viscosity. <input type="checkbox"/> Good heat and chemical resistance. <input type="checkbox"/> Bonds a broad range of materials.
7213	Amber	Granular	None	340° to 347°F	5,000 cps	-40° to 270°F	400° to 450°F	3 sec.	Excellent temperature resistance. <input type="checkbox"/> Designed for electrical potting applications. <input type="checkbox"/> Low viscosity.
7228	Amber	Granular	None	355° to 365°F	10,000 cps	-20° to 300°F	400° to 450°F	2 sec.	Exceptional heat resistance. <input type="checkbox"/> Bonds non-wovens and filter material. <input type="checkbox"/> Low viscosity.
8330*	Clear	Pellets	None	153° to 176°F	12,000 cps	-40° to 140°F	325° to 400°F	60 sec.	High performance, versatile adhesive. <input type="checkbox"/> Good bonds on metal and polyolefins. <input type="checkbox"/> Very flexible, long open time.
8363*	Off White	Pellets	Slight	167° to 197°F	10,000 cps	-20° to 125°F	325° to 400°F	40 sec.	General purpose adhesive. <input type="checkbox"/> Bonds a broad range of materials. <input type="checkbox"/> Designed for use in bulk applicators.
8384*	Trans-lucent	Pellets	Slight	165° to 200°F	9,500 cps	-20° to 125°F	325° to 400°F	40 sec.	Bonds wide range of materials. <input type="checkbox"/> Economical. <input type="checkbox"/> Designed for use in bulk applicators.
8386*	Light Amber	Slats	Slight	179° to 184°F	@ 350°F 1,000 cps	-20° to 150°F	320° to 360°F	15 sec.	High performance packaging. <input type="checkbox"/> Bonds coated and wax substrates. <input type="checkbox"/> Good adhesion at low temperature.
8387*	Light Yellow	Slats	Slight	199° to 207°F	@ 350°F 1,800 cps	-20° to 160°F	320° to 360°F	5 sec.	General purpose packaging. <input type="checkbox"/> Economical. <input type="checkbox"/> Use for case and carton sealing.

ROPE FORM HOT MELTS

PRODUCT	COLOR	FORM	ODOR	SOFTENING RANGE	TYPICAL VISCOSITY @ 400°F	TEMPERATURE RESISTANCE	OPERATING TEMPERATURE	MAX** OPEN TIME	FEATURES
1165	Cream	¼ in. Profile	None	304° to 320°F	61,000 cps	-50° to 250°F	400° to 475°F	2 sec.	Exceptional plasticizer resistance. <input type="checkbox"/> Excellent heat resistance. <input type="checkbox"/> Provides excellent bond on vinyls and woven or non-woven fabrics.
1252	Light Amber	¼ in. Profile	None	251° to 272°F	2,200 cps	-20° to 250°F	350° to 425°F	10 sec.	High heat resistance. <input type="checkbox"/> Low operating viscosity. <input type="checkbox"/> Bonds many porous substrates.
1315*	Light Amber	¼ in. Profile	None	225° to 235°F	17,000 cps	-40° to 185°F	325° to 475°F	6 sec.	General purpose adhesion. <input type="checkbox"/> Bonds many packaging materials.
1323	Off White	¼ in. Profile	None	225° to 240°F	32,000 cps	-50° to 170°F	400° to 450°F	3 sec.	Good heat and cold resistance. <input type="checkbox"/> Good adhesion to metals and plastics. <input type="checkbox"/> High performance.
1372*	Light Amber	¼ in. Profile	None	186° to 192°F	2,000 cps	-20° to 160°F	325° to 375°F	5 sec.	Designed for carton closing applications. <input type="checkbox"/> Good heat and cold resistance.

*In compositional compliance with FDA regulation 21 CFR 175.105, adhesives. Some products are in compliance with additional FDA regulations. Contact Bostik for technical assistance.

**Will depend on application temperature, cross section of applied adhesive and closing pressure. Maximum is for bonds with Kraft paper with a .125 x .0035 inch glue line.

HOT MELT GLUE CARTRIDGES — 1" DIAMETER × 3" or 12" LENGTHS

PRODUCT	TYPICAL VISCOSITY		MAXIMUM OPEN TIME	TEMPERATURE RESISTANCE	FEATURES
	@ 375°F	@ 450°F			
2240 Amber	6,750 cps	1,600 cps	30 sec.	0°F to 300°F	High heat resistance. <input type="checkbox"/> Good flow properties. <input type="checkbox"/> Good electrical properties.
2315 Lt. Amber	31,000 cps	10,000 cps	6 sec.	-50°F to 170°F	Packaging applications. <input type="checkbox"/> Good temperature resistance. <input type="checkbox"/> Fast setting.
2323 Cream	10,000 cps	3,500 cps	50 sec.	-20°F to 140°F	Long open time. <input type="checkbox"/> Recommended for bonding metals, plastics.
2370* Clear	9,000 cps	1,850 cps	30 sec.	-40°F to 160°F	High performance. <input type="checkbox"/> Good shock resistance. <input type="checkbox"/> Good all-purpose adhesion in a clear product.
2385* Amber	5,400 cps	2,800 cps	50 sec.	-20°F to 150°F	General purpose bonding of paper, wood, cardboard, foam and fabrics.
2391* Tan	1,450 cps	525 cps	40 sec.	-20°F to 160°F	Versatile packaging product. <input type="checkbox"/> Good "hot tack."

HOT MELT GLUE STICKS — ½" DIAMETER

PRODUCT	FORM	TYPICAL VISCOSITY @ 400°F	MAXIMUM OPEN TIME	TEMPERATURE RESISTANCE	FEATURES
6323* Straw	4 in. 15 in.	6,000 cps	50 sec.	-20°F to 140°F	Long open time. <input type="checkbox"/> Good adhesion to metal and plastics. <input type="checkbox"/> High performance.
6330* Clear	4 in.	12,000 cps	60 sec.	-40°F to 140°F	High performance, versatile adhesion. <input type="checkbox"/> Good bonds on metals and polyolefins. <input type="checkbox"/> Very flexible, long open time.
6363* Off White	4 in. 15 in.	10,000 cps	40 sec.	-20°F to 125°F	Good general purpose characteristics. <input type="checkbox"/> Bonds a broad range of materials.
6368* Light Amber	4 in. 15 in.	17,000 cps	6 sec.	-50°F to 170°F	Designed for packaging. <input type="checkbox"/> Good temperature resistance. <input type="checkbox"/> Fast setting.
6370* Clear	4 in. 10 in. 15 in.	6,000 cps	60 sec.	-40°F to 140°F	Very flexible. <input type="checkbox"/> Bonds wide range of floral, craft, and upholstery materials. <input type="checkbox"/> Economical.
6384* Translucent	4 in. 15 in.	8,500 cps	40 sec.	-20°F to 125°F	General purpose characteristics. <input type="checkbox"/> Bonds plastics, wood, porous materials. <input type="checkbox"/> Economical.
6390* Light Straw	4 in. 10 in. 15 in.	9,000 cps	40 sec.	-40°F to 160°F	Good heat resistance. <input type="checkbox"/> Bonds plastics, wood, porous materials. <input type="checkbox"/> Economical, general-purpose adhesion.

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