



TECHNICAL DATA SHEET

EH9641 Data Sheet

Electronic Materials Reactive Hot Melt Sealant

May 2013

Material Description

EH9641 is a fast setting reactive hot melt adhesive and sealant. It is a 100% solid, one-component material, with a secondary moisture cure system. The material is applied warm and sets immediately, allowing handling without the need for heat curing. EH9641 has optimum adhesion to a wide range of substrates including glass, aluminum, stainless steel and common engineered plastics such as polycarbonate.

Features & Benefits

- Designed for use with automated heating dispensing without stringing.
- Low application temperature (110-125°C) before cure – allows application and bonding to a wider range of heat sensitive materials.
- Will have more than 60% of cure strength with 4 hours of dispensing depending on RH and temperature.
- Open time of 2.5 minutes allowing for extended assembly time.
- High green strength allows immediate handling processing and testing.
- Adhesive forms a tough polymer bond resulting in excellent impact resistance and strong bonds.
- Dispenses like a one-part hot-melt adhesive, but reacts over time to form a strong cross-linked network like a tough urethane polymer.
- Good adhesion to a wide range of substrates: metals, ceramics, plastics, coated wires – even woven fabrics. No need for primers.

Typical Uncured Properties	
Property	Value
Color	Light white
Specific Gravity	1.11
% Solids	100
Viscosity at 95°C, cps	7000 ± 3,000
Viscosity at 110°C, cps	3700 ± 2,000

Typical Mechanical Properties (Cured)		
Property	Test Method	Value
Young's Modulus, PSI	ASTM D638	TBD
Hardness, Shore D	ASTM D2240	35
Elongation at Break, %	ASTM D638	850
Tensile Lap Shear Adhesion (PC-PC after 24 hours of cure), PSI	ASTM D1002	1200

Typical Application Properties	
Property	Value
Application Temperature, (at hot melt dispenser)	110°C - 125 °C
Open Time: time within which substrates must be bonded (without reheating), in minutes	2.5

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Application

EH9641 can be dispensed using automatic heating, dispensing or dipping systems at temperatures of 115°C +/- 10°C.

Green adhesion will be achieved as soon as the adhesive bond has cooled.

Clean Up

To clean spilled adhesive, allow the adhesive to cool to room temperature and remove heavy deposits. Any uncured residual adhesive can be scraped off using a blade. After scraping, wipe clean with a common polyurethane solvent (toluene, MEK). Clean up the adhesive residue before it cures.

If the dispense equipment is to be shut down for extended periods of time, we recommend purging the system with HB Fuller NP2038L 050. Partially used containers of EH9641 should be purged with a dry inert gas and resealed between uses.

Please consult your HB Fuller technical representative for additional recommendations.

Cure

The chemical reaction that results in cross-linking begins in the presence of low levels of atmospheric moisture. The rate of cross-linking will vary depending on temperature, humidity, and thickness. Please consult with your HB Fuller technical representative for additional recommendations.

Storage & Shelf Life

EH9641 should be stored in its original sealed foil bag in a dry location that maintains temperatures between 15°C to 40°C. Shelf life is six months in original unopened (sealed) foil bag when stored at this temperature range.

Health & Safety Precautions

Please see the Material Safety Data Sheet (MSDS) for proper handling and disposal instructions.

Note

The values noted in this data sheet are typical properties only and are not intended to be used as material specifications. For assistance in writing a material specification please contact HB Fuller Company.

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