



# EH9650

## Reactive Hot Melt Adhesive

### Material Description

EH9650 is a fast setting reactive hot melt adhesive and sealant. It is a 100% solid, one-component material, which cures in the presences of moisture. The material is applied warm and sets immediately, allowing handling without the need for heat curing.

EH9650 has optimum adhesion to a wide range of substrates including glass, aluminum, stainless steel, plastic coated wires, common engineered plastics (ABS, PET, PP, vinyl) and woven fabrics, without need for primers.

### Features & Benefits

- Designed for use with automated heating dispensing without stringing
- Convenient low application temperature (100-125°C) allows application and bonding to a wider range of heat sensitive materials
- Develops more than 60% of cure strength within 4 hours of dispensing depending on RH and temperature
- Open time of 4 minutes allowing for extended assembly time
- High green strength allows immediate handling, processing and testing
- Forms into a tough polymer bond resulting in excellent bond strength and good impact resistance
- Dispenses like a one-part hot-melt adhesive, but reacts over time to form a strong cross-linked network like a tough urethane polymer

### Typical Uncured Properties

Property	Blend
Color	Light white
Specific Gravity	1.11
Viscosity at 95°C (cPs)	7,000 ± 3,000
Viscosity at 110°C (cPs)	3,700 ± 2,000
Application Temperature	110-125°C
Open Time at 25°C (minutes)	4

### Typical Physical Properties of Cured Material

Property	Test Method	Value
Hardness, Shore D	ASTM D2240	35
Tg (°C)	DMA	-25
Elongation at break (%)	ASTM D0638	750
Young's Modulus (MPa)	ASTM D0638	36
Lap shear strength at 24hours, PC-PC (MPa)	ASTM E0831	8.9

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## Application

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EH9650 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.

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## Cure

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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.

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## Clean-Up

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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 EH9650 should be purged with a dry inert gas and resealed between uses.

Please consult your HB Fuller technical representative for additional recommendations.

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## Storage & Shelf Life

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EH9650 should be stored in its original sealed foil bag in a dry location that maintains temperatures between 15°C to 40°C.

Shelf life in these conditions is six months in original unopened (sealed) foil bag,

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## Health & Safety Precautions

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

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