



EH9652

Reactive Hot Melt Adhesive

Material Description

EH9652 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.

EH9652 has optimum adhesion to a wide range of substrates including glass, aluminum, stainless steel and common engineered plastics such as polycarbonate.

Features & Benefits

- Good adhesion to a wide range of substrates without the need for primers
- Designed for use with automated heating dispensing with no stringing during dispense process
- Convenient low application temperature (110-125°C) before cure – 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	White
Specific Gravity	1.11
Viscosity at 95°C (cPs)	7,500 ± 1,000
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	32
Elongation at break (%)	ASTM D0638	720
Lap shear strength at 24hours, PC-PC (MPa)	ASTM E0831	12.6

NOTE TO USER: by ordering/receiving product you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

IMPORTANT: The information, specifications, procedures and recommendations herein (together "information") are based on our experience and we believe these to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that the information will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

North America
+888-HBFULLER
+888-423-8553

inquiry@hbfuller.com
www.hbfuller.com



H.B. Fuller



Application

EH9652 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.

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.

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 EH9652 should be purged with a dry inert gas and resealed between uses.

Please consult your HB Fuller technical representative for additional recommendations.

Storage & Shelf Life

EH9652 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,

Health & Safety Precautions

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

NOTE TO USER: by ordering/receiving product you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

IMPORTANT: The information, specifications, procedures and recommendations herein (together "information") are based on our experience and we believe these to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that the information will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

North America
+888-HBFULLER
+888-423-8553

inquiry@hbfuller.com
www.hbfuller.com



H.B. Fuller