



EH9672

Reactive Hot Melt

Material Description

EH9672 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. It has optimum adhesion to a wide range of substrates including aluminum, stainless steel and especially to common engineered plastics such as polycarbonate, ABS, and Nylon.

EH9672 may also be easily reworked by heating the bonded assembly to 80-90°C, allowing damage-free disassembly. The cured product can then be easily removed, leaving minimal residue.

Features & Benefits

- Good adhesion to a wide range of substrates: metals, ceramics, plastics, coated wires – even woven fabrics. No need for primers.
- Easy rework and removability at temperatures exceeding 75°C, with minimal residue.
- Dispenses like a one-part hot-melt adhesive, but reacts when exposed to moisture to form a strong cross-linked network like a tough urethane polymer.
- Greater than 50% of full cure strength achieved within 4 hours of dispensing, depending on ambient humidity and temperature.
- Low melt temperature (110-125°C) before cure allows application and bonding to a wider range of heat sensitive materials.
- Designed for use with automated heating dispensing without stringing.
- Open time up to 15 minutes, allowing for extended assembly time.

Typical Uncured Properties	
Property	Value
Color	Light yellow
Specific Gravity	1.11
% Solids	100
Viscosity at 120°C (cPs)	2900 ± 500
Application Temperature (at hot melt dispenser)	110°C - 125°C
Open Time (minutes)	15

Typical Physical Properties of Cured Material		
Property	Test Method	Value
Hardness, Shore D	ASTM D2240	32
Elongation at Break (%)	ASTM D638	750
Lap shear strength after 24 hours of cure, PC-PC (psi)	ASTM D1002	1150

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Application

EH9672 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 EH9672 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

EH9672 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.

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