



HL9647

HL9647 is an isocyanate free hot melt moisture-curing adhesive. HL-9647 forms tough, heat resistant bonds after full cure. Cure time is a function of moisture availability and ambient temperatures. Typical cure times for HL-9647 at relative humidity of 30-60 % and ambient temperatures of 60 to 80 °F vary from 3 to 10 days depending on the substrate and coat weight.

Open time of HL9647 vary depending on the substrate and method of application. In a thin film, open times range from 2 to 10 seconds and bead open time range from 30 to 60 seconds. HL9647 bonds well to nonpolar plastics, metals, paper, and wood.

Technology / Base	Hot Melt Moisture Cure
Type of Product	Polyolefin
Components	One component
Curing	Moisture cure
Appearance / Color	Off White
Consistency	Viscous Liquid (Solid at Room Temperature)

Features and Benefits

- Isocyanate free
- High heat resistance
- High adhesion on a variety of substrates
- High toughness
- 100% solid

Technical Data

Property	Value	Condition/Method
Rheology		
Viscosity	13,000 cPs	at 300 °F
Application Temperature	300 to 350 °F	
Material Properties		
Shelf Life at 25°C	6 months	Thin film
Open Time at 25°C	2 to 10 sec 30 to 60 sec	
Cure Temperature and Time	3 to 10 days	Bead 30 to 60% R.H. and 60 to 80°F
Solids Content	100%	
Density	7.35 to 7.55 lb mass/gal	
Specific Gravity	0.88 to 0.9	



Application Instructions

This adhesive is designed to be used with platen or reservoir type melters that will dispense adhesive from 5 gallon pails and 55 gallon drums. Consult the equipment manufacturer for start-up, shut-down and cleanup procedures. If the equipment is to be shut down for extended periods of time we suggest purging the system with NP-2038L 251. Partially used pails or drums should be purged with a dry inert gas and resealed between uses.

Warning: Moisture contained in the air or from wet surroundings will cure this adhesive. Cured adhesive cannot be melted and may cause equipment damage. Thoroughly clean material from all equipment surfaces.

This product is designed to have less than a two-fold increase in viscosity over 12 hours at normal application temperature in the absence of moisture.

To clean up spilled adhesive, allow the adhesive to cool to room temperature and scrape off heavy deposits with a putty knife. Any uncured residual film may be wiped clean with a common solvent (toluene, MEK). Clean up the adhesive before it cures.

Storage Conditions

In original sealed packaging protected from sun, dust, moisture and high temperatures. Store under clean and dry conditions at constant room temperature.

Safety and Disposal

Please refer to the SDS for product safety and disposal instructions. To cure any residual adhesive, loosen the lid of the container to allow the adhesive to cure over time.

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