



HL2278

HL2278 is a solvent-free, UL recognized spray grade hot melt adhesive for bonding insulation to painted and unpainted metal. It contains no fillers and provides improved spray characteristics over filled adhesives.

FDA STATUS: A letter is available upon request.

Technology / Base	Hot Melt
Type of Product	Modified Rubber
Components	One component
Curing	Non-curing
Appearance / Color	Light Amber
Consistency	Viscous Liquid (Solid at Room Temperature)

Features and Benefits

- UL recognized.
- Excellent performance for spray application
- Good bond strength on a variety of substrates
- Excellent for bonding insulation to painted and unpainted metal and galvanized metal
- Low/no residue after removal
- Excellent removability

Technical Data

Property	Value
Rheology	
Viscosity	117,500 cPs @ 300 °F 33,500 cPs @ 325 °F 13,750 cPs @ 350 °F
Physical Properties	
Solids Content	100%
Flash Point, Cleveland Open Cup	455 °F
Weight per Gallon	7.9 lb/gal
Shelf Life	12 months
SAFT (500 g/in ²)	200 °F
Container	Drum and Pillows
Recommended Application Temperature	350 °F
Peel Strength: 180 Degree Peel (60s/75°F, 0.001 in)	7 lb/inch
Polyken Tack	1,500 gram
Loop Tack	90 ounces



Application and Clean-up

Coating surface area should be clean and free of any oils, residues, dust or any other contaminants. This product is designed to bond insulation to unpainted metal or painted metal using a spray application. For best results it is suggested that the adhesive be spray applied to the insulation. The adhesive should not be used where service temperature environments exceed 160°F, unless customer testing indicates otherwise. To improve the pot stability of HL2278, an inert gas blanket is recommended while the adhesive is molten to ensure the best retention of physical properties. Consult the equipment manufacturer for cleanup procedures or flush the unit with mineral oil at 250°F. Flush the applicator thoroughly with hot melt to purge the system.

Storage Conditions

Product should be stored in a cool and dry location.

Shelf Life: 12 months from date of manufacture.

Safety and Disposal

Please refer to the SDS for product safety and disposal instructions.

UL Recognition Information

This adhesive is intended to secure insulation materials to metal panels of warm air heating appliances, blowers, air conditioning equipment and similar devices. It has been investigated under the Recognition Program, category Insulation Adhesives (MAGW2), and found to comply with the requirements included in the current editions of UL 1995, Standard for Heating and Cooling Equipment, and UL 727, Standard for Oil-Fired Central Furnaces, etc. The Underwriters Laboratories Inc. reference file is MH7871, Volume 3, Section 1. FIRE HAZARD TESTING: Samples consisted of the hot melt adhesive applied at 1200 sq ft/gal to 1/4" thick sterling board. The test was conducted in accordance with Underwriters Laboratories Standard Test for Surface Burning Characteristics of Building Materials (UL 723) yielding the following results:
 FLAME SPREAD: 4.9
 SMOKE DEVELOPED: 7

Date Modified: 17 April 2003

Connecting what matters.™

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience, and we believe this information to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product 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.

© and ™ are trademarks of H.B. Fuller Company or one of its affiliated entities.



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 this documentation. 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, (1) 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. (2) 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. (3) Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence, death, or personal injury caused by negligence, or for breach of any mandatory implied terms unless permitted by law.