



HL6415XZP

HL6415XZP is a foamable hot melt designed for use as a cabinet sealant in the appliance industry. It features excellent foam density reduction, low application temperature, and easy clean-up from metal and ABS.

Technology / Base	Hot Melt Adhesive
Type of Product	Synthetic Resin
Components	One component
Curing	Non-Reactive
Appearance / Color	Off White
Consistency	Viscous Liquid (Solid at Room Temperature)

Features and Benefits

- Excellent foam density reduction
- Low application temperature
- Good heat resistance
- High toughness
- Easy clean-up from metal and ABS

Technical Data

Property	Value	Condition/Method
Rheology		
Viscosity	4,250 cPs 1,300 cPs	at 275 °F at 300 °F
Material Properties		
Shelf Life at 25°C	24 months	unopen original container
Roll Coater Open Time	45 to 60 sec*	
Solids Content	100%	
Mettler Soft Point	207 °F	ASTM D3461
Application Temperature	265 °F	

**Application Instructions**

When used with foamed hot melt application equipment the temperature settings throughout the system may vary from 250-300 F, depending on the design and output variables. Technical assistance may be required.

Equipment: Any hot melt application equipment capable of maintaining the suggested adhesive temperature noted above at the required melt rates.

Directions:

1. Flush previous hot melt out of equipment following recommended procedures.
2. Adjust application equipment to above suggested temperatures.
3. If pre-melting options are used, set this function at the lowest possible temperature and still be able to maintain the required adhesive temperature and melt rate.
4. The open time of this product may be increased slightly by raising the application temperature and decreased slightly by lowering the application temperature within a small range of temperature changes.
5. Adjust pump pressure for desired bead diameter (line speed and extrusion nozzle orifice affect bead diameter in conjunction with pump pressure).

Precautions:

ZEROPACK film is not compatible with this foamable hot melt sealant. ZEROPACK serves only as a removable container for this product. Slit the ZEROPACK film and empty the pillows into the melt hopper. Inclusion of the ZEROPACK film into the application equipment may result in substandard foam quality

Storage Conditions

Because this is a 100% solids system, the shelf life of this product is classified as 24 months. We suggest that this product be stored in containers in an upright position in areas where ambient temperatures will not exceed 100 F. Storage of this product at temperatures exceeding 100 F may cause the product to block together, creating handling difficulties.

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.

To minimize the risk of burns, we recommend the use of eye protection and protective clothing when working near a hot melt applicator. To minimize the risk of flammable vapors, do not exceed a melt temperature of 400 F. Prevent the buildup of vapors. Extinguish all sources of ignition during hot melt use. Use in a well-ventilated area. Consult Safety Data Sheet for additional information.

CAUTION: EXTREME CARE SHOULD BE EXERCISED WHEN WORKING WITH HOT MELTS IN THEIR HOT, FLUID STATE. Severe burns will result if skin contact occurs. When moving a hot melt from one location to another, it is suggested that protective gloves be worn. If skin contact occurs, immediately immerse contact area in cold, clean water for at least 30 minutes. Cover contacted area with a wet, clean compress and see a physician immediately.

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