



HMC-1 Hot Applied Synthetic Elastomer Sealant

HMC-1 is a blend of select polymers formulated for use in door and deck lid weather-strips. The sealant is homogeneous and completely resistant to moisture.

Technology / Base	Butyl/Synthetic Elastomer Blend
Type of Product	Hot Applied Sealant
Appearance / Color	Neutral
Consistency	Hot Melt

Features and Benefits

- Has good adhesion to rubber weather-strips and basecoat/clearcoat paint systems
- It exhibits excellent heat aging resistance and long term weathering
- Offers low insertion forces within a range of temperatures
- Remains static within the weather-strip during shipping and handling
- Will not stain basecoat/clearcoat paint systems
- Is fabric dry cleanable
- Moisture resistant

Technical Data

Property	Typical Value	Test Method
Specific Gravity	1.3	ASTM D1875
Solids Content	99.5%	
Thermoset Viscosity (120° C)	35,500 cps	ASTM B3236
Sag Resistance	No movement	GM9899P
Insertion Force not to exceed maximum values of:		GM9899P
6 N @ 38°C (100°F)	2.2 N @ 38°C(100°F)	
8 N @ 21°C (70°F)	2.7 N @ 21°C (70°F)	
14 N @ 4°C (40°F)	3.2 N @ 4°C (40°F)	
28 N @ -18°C (0°F)	21.2 N @ -18°C(0°F)	
Odor	No objectionable odor	ASTM D4339
Temperature Stability	No deleterious effects after 72 hours at 54°C (129°F)	
Florida/Arizona Exposure	No loss of adhesion, staining, drying, oil bleed, cracking, shrinking, or separation after 3 months exposure	GM9031P
Heat Aging 14 days @ 70°C (158°F)	No loss cohesive/adhesive strength	
Application Temperature Range	65°C to 121°C (150°F to 250°F)	



Typical Applications

HMC-1 is typically used for weatherstrip seal applications.

General Instructions

HMC-1 can be applied by a manual or robotically controlled hot melt gun and airless pump system commonly used to apply hot melts.

Specifications

Meets requirements of:

Chrysler	MS-CD-916 Type B
Ford	ESB-M4G260-A2
GM	9981909

Typical Packaging

HMC-1 Sealant is available in the following standard packages:

- 5 gallon pail
- 55 gallon drum

Storage and Shelf Life

Store material in original unopened packaging at temperatures between 4°C to 38°C (40°F to 100°F). Shelf life is 24 months when stored as recommended.

Safety and Disposal

Prior to working with this or any product consult product label and Safety Data Sheet (SDS) for necessary health and safety precautions and disposal considerations.

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