

TECHNICAL DATA SHEET

Thermogrip® 6363

HOT MELT ADHESIVES

Product Description

Bostik® Thermogrip® 6363 is a general purpose, medium open time hot melt which provides effective bonds to a wide variety of materials including wood, metal, paper, fabrics, leather, ceramics, many plastics and some rubbers.

This product may be compositionally compliant to one or more FDA regulations for food packaging. Please contact the Bostik Regulatory Department for up-to-date FDA compliance information.

Product Benefits

- Medium open time means more assembly time
- Bonds to a wide range of materials
- Aggressive tack

Product Applications

- Furniture repair and assembly
- Leather products—reinforcement and repair
- Component staking PC boards
- Automotive assembly or repair

Application Information

1. All surfaces should be clean and free of contaminants. If necessary, clean surfaces with solvent.
2. Apply the adhesive to the more difficult-to-bond surface. In general, hard, smooth surfaces are more difficult to bond than rough, porous surfaces.

Metals should be pre-warmed up to 200°F (95°C) for optimum results.

3. Open-time varies depending on application temperature, amount of adhesive applied, type of substrate and ambient temperature conditions.
4. Mate the surfaces to be bonded as quickly as possible after adhesive has been applied for optimum bond strength.

(continued...)

Application Information (...continued)

5. Use firmest pressure practical for object being bonded. Do not move or adjust surfaces after contact has been made, as inferior bond strength will result.
6. Typically, a properly formed hot melt adhesive bond will achieve 50% of its strength after 1 minute, 75% after 1 hour, and 100% after 1 day.

Typical Physical Properties* (After 24 Hour Cure)

Color:	Off White
Size (dia. x length):	1/2" x 4" **
	1/2" x 15"
Odor:	Slight
Softening Range:	167°F to 197°F (75°C to 92°C)
Specific Gravity:	0.98 gms/cc
Viscosity, cps:	
@ 350°F (177°C)	20,500
Open Time:	
1/8" dia. bead	40 secs.
1/4" dia. bead	Up to 100 secs.
Temperature Resistance:	-20°F to 125°F (-29°C to 52°C)

Bond Characteristics*

Bond Strength, Shear, psi :	
Plywood	565
Chemical Resistance:	
Water	Good
Acids & Alkalies	Fair
Fats & Oils	Poor
Solvents	Poor

Storage and Handling

Shelf Life:	999 days @ 73.4°F (23°C)
Shipping and storage:	Between 40°F to 95°F (4°C to 35°C)
Further Information:	Please refer to MSDS for complete details.

* Values given are not intended to be used in specification preparation.
** 4" length available by special order only.

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