



TECHNICAL DATA SHEET

Thermogrip® 6327

HOT MELT ADHESIVES

Product Description

Bostik® Thermogrip® 6327 is a medium open time hot melt adhesive for use in Bostik glue guns. It is an economical grade with good shear strength and good adhesion to most plastics and porous substrates.

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

- Adhesive color blends with substrate
- Flexible, no cracking

Product Applications

- Ideal for craft, floral, and hobby applications
- Suitable for haberdashery repairs
- Used in carpet installation and assembly
- Bondable substrates include wood, many plastics, fabrics, felt, ceramics, crafts, floral products, silk flowers and many other porous and non-porous substrates

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.
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.
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:	Colorless, translucent
Size (dia. x length):	1/2" x 4" **, 1/2" x 15"
Odor:	None
Melt Point (R&B):	201°F to 205°F (94°C to 96°C)
Specific Gravity:	0.96 gms/cc
Viscosity, cps: @ 350°F (177°C)	11,000
Open Time:	30 secs. (variable)
Temperature Resistance:	-22°F to 158°F (-30°C to 70°C)

Bond Characteristics*

Bond Strength, Shear, psi:	
ABS to ABS	239
Acrylic to Acrylic	226
Polycarbonate-to-Polycarbonate	146
Polypropylene-to-Polypropylene	186
Beechwood-to-Beechwood	320
Chemical Resistance:	
Water	Good
Weak 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.
** 1/2" x 4" length available by special order only.

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