Bostik

PRODUCT DATA

FM 1696
ISO 9001

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Information Sheet No.: B0437-10

GLUESTICKS 6370

HOT MELT ADHESIVE

BOSTIK GLUESTICKS 6370 consist of a high performance, hot melt adhesive supplied in sticks 300 mm long and approximately 11.5 mm in diameter. They are designed for application by appropriate glue guns and can be used for bonding a wide range of substrates. Typical applications include: carton sealing, especially carton sealing of packaged consumer goods such as gifts and confectionery where an attractive finish is required; carton tray forming and wrap around case manufacture; pallet stabilisation and food packaging applications, as well as applications within the furniture industry.

The gluestick adhesive has an extended open working time and the applied adhesive coating can also be heat reactivated.

The ingredients of these gluesticks are approved under section 175.105 of the USA FDA Regulations for use in food packaging adhesives.

BOSTIK GLUESTICKS 6370 also meet the requirements of U.K. Ministry of Defence Specification TS 10155: ADHESIVE, HOT MELT NO 1, FOR PACKAGING PURPOSES.

RECOMMENDED USE

BOSTIK GLUESTICKS 6370 are suitable for use in the production of a wide variety of packaging materials including paper, board, hardboard, wood, textiles, leather, rigid PVC and certain other plastics. Users should first carry out tests to determine suitability.

BONDING INSTRUCTIONS

1. Ensure that the surfaces to be bonded are clean and dry and free from grease and dust.

2. Using an appropriate BOSTIK HOT-GLUE GUN* (which has a factory pre-set temperature to ensure the optimum results with this formulation) apply the adhesive to the surface, when applicable, which is the more difficult to bond (in general, hard smooth surfaces are more difficult to bond than rough porous surfaces).

*   Use the BOSTIK "TG4" GLUE GUN or "HEAVY DUTY" GLUE GUN for continuous production work.

Use the BOSTIK "DIY HOT MELT" GLUE GUN or "MULTIPURPOSE" GLUE GUN or "CORDLESS" GLUE GUN for DIY or intermittent work.

3. Join the two mating surfaces together (using the highest pressure practicable) as quickly as possible after adhesive application in order to obtain the results

NOTE: The open working time is up to 30 seconds, depending on the nature of the substrate, application temperature, volume and cross section of applied adhesive and closing pressure.

Do not move or adjust surfaces after contact has been made, as inferior bond strength will result.

As a general guide, a properly formed bond will, after joining, achieve:-

Handling strength:	Within 1 minute
Full strength:	75% within 1 hour
	100% within 2 hours

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<u>CLEANER:</u>   Use CLEANER 7 or CLEANER 2 for surface preparation and equipment cleaning BUT DO NOT CLEAN HOT APPLICATION EQUIPMENT WITH THESE SOLVENTS.

TYPICAL CHARACTERISTICS

Physical Form:	Flexible solid cylindrical sticks 200 and 300 mm long, approximately 11.5 mm diameter
Colour:	Translucent water white
Chemical Type:	Ethyl vinyl acetate
Viscosity:	10-13 Pa s (100-130 poise) at 177°C
Solids Content:	100%
Specific Gravity:	1.0
Softening Point Ball & Ring:	85 – 90°C
Temperature Resistance:	-40 to +70°C approximately
Water Resistance:	Good
Solvent, Oil, Fat & Plasticiser Resistance:	Not resistant.

Shear Strength at 20°C:	<u>Substrate to itself</u> Beechwood	<u>MP a</u> 1.4-2.0	(psi) (200-300)
Peel Strength at 20°C	<u>Substrate to itself</u> Canvas	N/mm 1.75	(lb/in) (10)

PACKAGING
Please refer to Customer Service Department for current package sizes.

STORAGE
Store under dry conditions between 5 and 25°C. Keep dry during transportation.

SHELF LIFE
At least 2 years from date of manufacture, under the above conditions of storage.

MATERIAL SAFETY DATA
For further information refer to the relevant Health and Safety Data Sheet.

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