



# REACTIVE URETHANE HOT MELT ADHESIVES

**Hysol**<sup>®</sup>

## Advantages

- Broad Adhesion
- Low Application Temperature (250°F)
- High/Low Temperature Resistance
- High Green Strength
- Crosslinkable to a Thermoset

## Applications

- Door Panels
- Overhead Systems
- Seating
- Package Trays
- Instrument Panels

**REACTIVE URETHANE**  
Hot Melt Adhesives



**Henkel**

## REACTIVE URETHANE Hot Melt Adhesives

PRODUCT	APPEARANCE	OPEN TIME	VISCOSITY	DISPENSE TEMPERATURE	RING & BALL	TEMPERATURE CREEP RESISTANCE	KEY FEATURES	AVAILABLE PACKAGES SIZES
Purmelt® R-513C™ Hot Melt Adhesive	Off White	3 to 4 min.	12,000 cps @ 250°F (121°C)	250°F (121°C)	N/A	N/A	Proven winner! With aggressive tack and 3 to 4 minute open time, this adhesive provides high green strength and is designed for general purpose. Best for garage door and RV, as well as other laminations. If Purmelt® R-513C™ green strength is too strong, test Purmelt® R-600™.	55 gal. Poly Steel Drum 55 gal. OH SS Steel Drum 4 lb. Foil Pack 5 gal. Metal Pail
Purmelt® R-508B™ Hot Melt Adhesive	Off White	1 to 2 min.	12,000 cps @ 250°F (121°C)	250°F (121°C)	N/A	N/A	Aggressive tack with 1 to 2 minute open time and high green strength. Designed for quick assembly or fast panel lamination. Its quick set up overcomes the weakness of Purmelt® R-513C™.	5 gal. SS/LL Metal Pail 55 gal. OH SS Steel Drum
Purmelt® QR-6205™ Hot Melt Adhesive	Ivory	15 to 30 sec.	60,000 cps @ 275°F (135°C)	260°F-280°F (126°C-137°C)	165°F (73°C)	N/A	Designed for wrapping profile cores made of particleboard, MDF or solid wood with veneers and resin impregnated paper and laminated foils. It is very fast setting and exhibits high initial strength. Chemical crosslinking occurs within a few days. Forms an insoluble thermoset film, has very high heat resistance and cold flexibility. It also has excellent water resistance and is resistant to most solvents.	5 gal. SS/LL Metal Pail 4 lb. Foil Pack
Terorehm® MC 9622-02™ Hot Melt Adhesive	Light Ivory	5 to 15 sec.	55 mPa @ 150°C (65.5°C)	260°F-280°F (126°C-137°C)	N/A	N/A	This high performance adhesive can be sprayed or roll coated. It has good wetting properties, is fast setting and provides high initial strength after solidification. High softening point above 100°C with good chemical resistance. Bonds to wood, foils, soft PVC, TPO, textiles, thermoplastics (ABS, ABS/PC, PA, etc.), and after pretreatment, non-polar plastics (PE, PP, etc.). Equivalent to Purmelt® 6204-23™.	20 kg Pail 55 gal. OH Blue SS Steel Drum 4 lb. Foil Pack 1 lb. Cartridge
Terorehm® MC 9530™ Hot Melt Adhesive	White	90 sec.	25,000 mPas @ 150°C (65.5°C)	260°F-280°F (126°C-137°C)	150°F-158°F (66°C-70°C)	N/A	High performance. The uncured product is crystalline and demonstrates the following characteristics: good application properties (spray or roll coat), good wetting to most substrates, and high initial strength after solidification. Softening point above 100°C, very good cold flexibility and good chemical resistance. Bonds to shaped fiber materials, wood, soft PVC, TPO, textiles, thermoplastics, and after pretreatment to non-polar plastics. Twenty seconds set time and reactivatable within approximately 3 hrs.	55 gal. OH SS Steel Drum 4 lb. Foil Pack 20 kg Pail
Purmelt® QR-5210™ Hot Melt Adhesive	Light Ivory	15 to 30 sec.	25,000 mPas @ 266°F (130°C)	260°F-280°F (126°C-137°C)	N/A	N/A	Designed for fast assembly, this adhesive provides a short open time at 20 seconds with high green strength. The viscosity is also much higher and higher application temperature is often needed (for example, 270°F vs 250°F). It is by far the best product for fast assembly — stronger than Purmelt® R-508™.	55 gal. Blue Poly Steel Drum
Loctite® 3631™ Hysol® Hot Melt Adhesive	Off White	60 sec.	12,500 mPa @ 250°C (121°C)	250°F (121°C)	N/A	N/A	Plastic bonding, high viscosity, industrial grade polyurethane hot melt adhesive. Moderate open time, cures with moisture to a tough thermoset plastic. Designed for bonding and laminating applications where fast green strength and excellent structural and mechanical properties are desired. Typical substrates include ABS and epoxy. Available in cartridges.	40 lb. Pail 300 ml Cartridge
Purmelt® QR-4663™ Hot Melt Adhesive	Off White	4 to 8 min.	9,000 mPa @ 130°C (54°C)	230°F-284°F (110°C-140°C)	N/A	N/A	High performance, pressure sensitive adhesive that gives high initial strength instantly after assembly. Long open time with high heat and cold resistance. Bonds wood, plastic, textile, and different films and foams.	55 gal. Blue Poly Steel Drum
Purmelt® R-246C™ Hot Melt Adhesive	Off White	2 min.	13,000 cps @ 250°C (121°C)	250°F (121°C)	N/A	N/A	A one-component, polyurethane, reactive hot melt adhesive. It is designed to give excellent adhesion to difficult-to-bond substrates, especially ABS. Cures through reaction with moisture to form a tough, strong, and virtually thermoset polymer. Can be used for lamination of sandwich panel elements of ABS, wood, lauan, fiberboard, particleboard, plywood, FRP, EPS foam, PU foam, and metals.	55 gal. OH SS Steel Drum



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