

## TECHNOMELT PUR 6221 UV

May 2018

### PRODUCT DESCRIPTION

TECHNOMELT PUR 6221 UV provides the following product characteristics:

<b>Technology</b>	Polyurethane
<b>Product Type</b>	Hotmelt
<b>Application</b>	Bonding and lamination of interior parts

TECHNOMELT PUR 6221 UV is a high performance, moisture curing hot melt adhesive based on polyurethane. The uncured product is crystalline and demonstrates the following characteristics:

- very good application properties (can be sprayed and roller coated)
- fast setting
- high initial strength after solidification
- fluorescent under UV light

TECHNOMELT PUR 6221 UV cures by **moisture** within short time, forming a hard elastic material, demonstrating the following characteristics:

- good chemical resistance (e.g. to fuel-oil mixture, numerous plasticizers, solvents, aqueous surfactants, salt spray)
- adhesion to shaped fibre materials, wood, foils (soft PVC, TPO), textiles, thermoplastics (e.g. ABS, ABS/PC, PA, etc.) and - after pretreatment - also to nonpolar plastics (e.g. PE,PP, etc.)

### Application Areas:

TECHNOMELT PUR 6221 UV is primarily used for assembling and laminating areas

- interior parts for the automotive industry and sub-contractors (e.g. door mirrors, retainers, door linings, pillar linings, instrument panels)
- in the wood and furniture industry (profile wrapping)
- in the textile and foil industry (laminates)

### TECHNICAL DATA

(as supplied)

**TECHNOMELT PUR 6221 UV :**

#### Uncured

Softening Point, DSC, °C	~65
Colour	light ivory, fluorescent
Odour	weak
Solid content, %	100
Viscosity, Brookfield-, 130° C, Pa.s Equipment	25 to 45 rotation viscosimeter Brookfield
Measuring system	Thermosel SP 27
Speed, rpm	5
Application temperature, °C	110 to 150
<b>After curing</b>	
Shear strength, MPa (based on DIN EN 1465) (substrate failure)	~9
Substrates	beech wood (100 mm x 25 mm x 2,5 mm)
Layer thickness, mm	0.2
Bonded area	25 mm x 10 mm
Cross head speed, mm/min	100
In service temperature range, °C	-40 to 120
Short exposure (up to 1 h), °C	130

## DIRECTIONS FOR USE

### Preliminary Statement:

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

### Pretreatment:

The bonding surfaces must be clean, dry and free of oil and grease.

Substrate temperature should not fall below 20°C during application.

Lower temperatures will lead to an early solidification of the adhesive and thus to a reduced open time, possibly the adhesive might even flake off.

If necessary the substrates may be prewarmed, however, longer open times and thus extended cycle times will have to be taken into consideration at temperatures above 45°C.

### Application:

TECHNOMELT PUR 6221 UV can be applied from usual tank melting equipment and from hobbocks, using heatable equipment. The material may be applied by nozzle, roller and sprayable systems.

### Cleaning:

As long as TECHNOMELT PUR 6221 UV is not cured application equipment can be cleaned with Purmelt Cleaner 02. (See separate Technical Data Sheet). Cured adhesive can only be removed mechanically.

### Curing:

TECHNOMELT PUR 6221 UV cures exclusively by moisture and gains its final strength after 3 to 7 days, but exhibits high handling strength after the physical process of setting.

Curing is a chemical reaction depending on the following parameters:

- humidity in the rooms of application and storage
- humidity of the substrates (carrier and decor)
- permeability of the substrates to be bonded
- application weight/layer of the adhesive film

### Storage:

Frost-Sensitive	no
Recommended Storage Temperature, °C	5 to 25
Shelf life, months (in unopened original packaging)	12

### Classification:

Please refer to the corresponding **Material Safety Data Sheets** for details on:

- Hazards identification**
- Transport information**
- Regulatory information**

## ADDITIONAL INFORMATION

### Disclaimer

#### Note:

The information provided in this Technical Data Sheet (TDS) including the

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Reference 0.1