



## TL5408D

**Type of Adhesive** Polyurethane based reactive hot melt adhesive.

**Product Benefits** This product was designed for the high water repellent treated fabrics including nylon fabric and polyester fabric. Has a suitable initial tack to ensure the on line processing. After cured, it is soft and elastic.  
**There is no UV indicator in this product.**

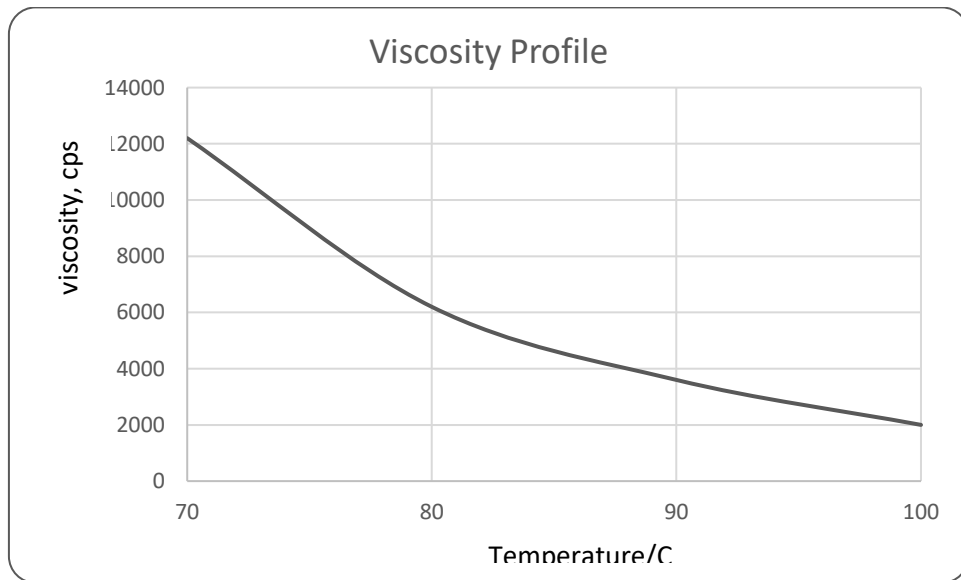
**Typical Applications** Textile lamination.

**Suitable substrates** Lamination of textile fabric, non-woven substrates, synthetic foam, film, breathable film.

**Typical Properties**

Density	approx. 1.10 g/cm <sup>3</sup> at 20°C
Viscosity	approx. 3,600 cps at 90°C
	approx. 6,200 cps at 80°C
Colour	Light yellow to white

**Viscosity profile:**



**Application Instructions**

**Open time** over five minutes.

**Working temperature** Premelting temperature approx. 90-100 °C  
Application temperature approx. 90-100°C



Application procedure	Drum, pail and bag unloaders in combination with nozzle, coating roller and screen printing systems.
Coverage	8-50 g/m <sup>2</sup> depending on application system and substrates.
Pretreatment	Bonding surfaces have to be clean, dry and free of grease and oil. Polyolefin materials have to be corona-pretreated or flame-treated.
Adhesive Application	Applied in lamination machine, put the glue in the middle of application coaters.
Preparation	Drum unloader, heating plate, conveyor pump and applicator gun can, as a rule, be set to different temperatures. Excessive heat may cause decomposition of the adhesive. Depending on the construction of the equipment, a temperature of up to 120°C is sufficient for the heating plate and the conveyor pump. Positive results have been achieved with nitrogen. Please take care of that packages are used immediately after opening in order to prevent possible reactions with moisture.
Adhesive application	Final cure is achieved by reaction with ambient moisture or moisture from the substrate. Curing time depends on the access of humidity to the bonding seam, i.e. the humidity of the substrate, substrate permeability, adhesive film thickness, relative air humidity and ambient temperature. Average curing time for bonding onto wooden materials at a temperature of 25°C and relative humidity of 65% amounts to up to 3-4 days. If large surfaces and/or impermeable materials are bonded under unfavourable climatic conditions, the curing time may be considerably longer.
<b>Cleaning Instructions</b>	H.B.Fuller provides wide PUR cleaner, please consult with sales person.
<b>Typical Packaging</b>	Drum(200Kg), Pail(18Kg), slug(2Kg).
<b>Storage Conditions</b>	Clean, good sealant and dry conditions within 5°C and 30°C.
<b>Disposal Advice</b>	Please refer to MSDS for disposal instructions.
<b>Safety Advice</b>	Please refer to MSDS for safety advice.

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