



## TL5404D

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

**Product Benefits** Patent product, specially designed to bond to High Durable Water Repellant (HDWR) fabrics most commonly used for the SPORT market segment.  
**There is UV indicator in this product.**

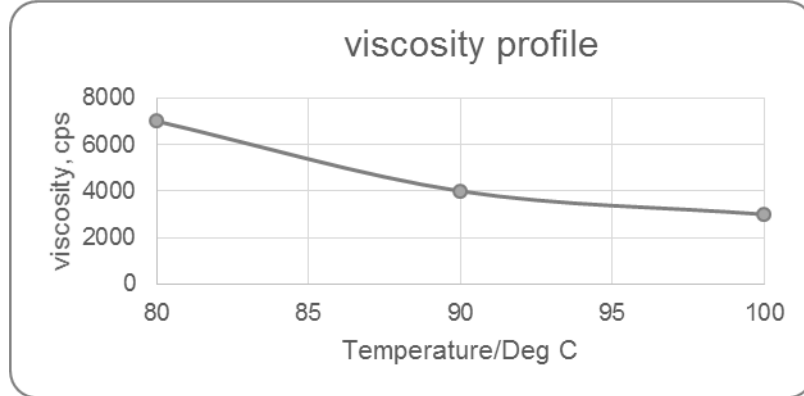
**Typical Applications** Textile lamination

**Suitable substrates** Fabrics with high DWR, film (eg TPU, PU, PTFE)

**Typical Properties**

Density	approx. 1.11 g/cm <sup>3</sup> at 20°C
Viscosity	approx. 3,000 cps at 100°C
	approx. 4,000 cps at 90°C
	approx. 7000 cps at 80°C
Colour	Off-white

**Viscosity profile:**



**Application Instructions**

**Open time** less than 5 min, depending on application procedure, application thickness and substrate

**Working temperature** Pre-melting temperature approx. 80-100°C  
Application temperature approx. 80-100°C

**Application procedure** Drum, pail and bag unloaders in combination with nozzle, coating roller and screen printing systems.

**Coverage** 6-15 g/m<sup>2</sup> depending on application system and substrates.



## TECHNICAL DATA SHEET 技术资料

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.
Cleaning Instructions	H.B.Fuller designed professional cleaner special for textile lamination, please consult with the sales.
<b>Typical Packaging</b> <b>Storage Conditions</b> <b>Disposal Advice</b> <b>Safety Advice</b>	Drum (200Kg), Pail (18Kg), Slug (2Kg) Clean and dry conditions within 5°C and 30°C. Please refer to MSDS for disposal instructions. Please refer to MSDS for safety advice.

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