

## Interior Hot Melt Selection Guide



Henkel



# INTERIOR HOT MELT SELECTION GUIDE

Product	Chemistry	Packages	Form (Pellet, etc.)	IDH #	Open Time (min)	Viscosity (cP)	Color	Spray Apply	Application Temperature	Softening Point	Attributes/Applications
TECHNOMELT® AS 3210	PO Hot Melt	Drum	Solid	1217503	1	8,000 @ 177°C (350°F)	Off-White	Y	171°C to 182°C (340°F to 360°F)	135°C (275°F)	A sprayable or extrudable hot melt adhesive with exceptionally long open time that forms strong bonds having good heat resistance. It is used to bond fabrics, flexible urethane foams and cloth-backed vinyls to various board stocks, polyolefin plastics and ABS. It is formulated to meet the requirements of General Motors Specification 998 5676.
		Box	Pellets	1700025							
TECHNOMELT® AS 4216	PO Hot Melt	Bag	Pellets	1730862	0.5	33,000 @ 177°C (350°F)	Cream White	N	180°C to 200°C (356°F to 392°F)	155°C to 170°C (311°F to 338°F)	A high viscous hot melt adhesive, based on polyolefins. It is characterized by a high-temperature creep resistance and forms an elastic film. Because it has excellent adhesion to polypropylene (PP), it is used to bond units of PP especially where low fogging values are required.
TECHNOMELT® AS 8380	APAO Hot Melt	Box	Briquettes	1850429	10	8,000 @ 190°C (375°F)	Off-White	Y	148°C to 177°C (300°F to 350°F)	146°C (295°F)	A short open time material, suitable for the manufacturing of automotive interior components. Can be applied for trims, sound absorption padding, carpet bonding, foams and accessories.
TECHNOMELT® AS 8381	APAO Hot Melt	Box	Briquettes	1850431	15	2,000 @ 190°C (375°F)	Off-White	Y	148°C to 177°C (300°F to 350°F)	99°C (210°F)	An extended open time material, suitable for the manufacturing of automotive interior components. Can be applied for trims, sound absorption padding, carpet bonding, foams and accessories.
TECHNOMELT® AS 8382	APAO Hot Melt	Box	Briquettes	1850430	2	3,000 @ 190°C (375°F)	Off-White	Y	148°C to 177°C (300°F to 350°F)	119°C (246°F)	A medium open time material, suitable for the manufacturing of automotive interior components. Can be applied to trims, sound absorption padding, carpet bonding, foams and accessories.
TECHNOMELT® 8383	APAO Hot Melt	Drum	Solid	1963247	0.5	5,000-8,000 @ 190°C (375°F)	Ivory	Y	163°C to 190°C (325°F to 375°F)	150-160°C (302° -320°F)	Short open time material that is a load bearing, high heat resistant adhesive suitable for automotive interior components such as headliner attachments, trim parts, sound absorption padding, carpet and foams. Meets GM 9985942, 9986384, 9985744
		Box	Pillows	2399910							
TECHNOMELT® 8384	APAO Hot Melt	Box	Briquettes	1957673	8	2000 cPs @ 190°C	Ivory	Y	163°C to 190°C (325°F to 375°F)	114°C (237°F)	A long open time, medium viscosity hot melt with good tack and improved adhesion for interior applications. Can be applied for sound absorption padding, carpet bonding, and foam substrates.
TECHNOMELT® DM 5633	PO Hot Melt	Box	Blocks, 3.5 lb	1323572	1-2	1,850 @ 160°C (325°F)	Light yellow	N/A	135°C - 175°C (275°F - 350°F).	113°C (235°F)	Adhesive can be rolled, bead or spray applied. Can also be foamed. Ideal to bond fabrics, flexible urethane foams and cloth-backed vinyl to various board stocks, polyolefin plastics and ABS.
TECHNOMELT® PA 6239	PA Hot Melt	Bag	Pellets	38358	0.5-1	7,000 @ 225°C (437°F)	Translucent Light Amber	Y	249°C to 266°C (480°F to 510°F)	133°C to 143°C (271°F to 289°F)	A versatile thermoplastic resin for bonding a variety of substrates. It possesses a good creep resistance at elevated temperatures with excellent bond strength at low temperatures, and exhibits good adhesion to a variety of substrates including wood, plastics, metals, ABS, and flexible vinyls.
TECHNOMELT® 6650	PSA	Box	Chub	1217724	5	2,000 @ 177°C (350°F)	Transparent Amber	Y	135°C to 163°C (275°F to 325°F)	approx. 82°C (180°F)	Pressure-sensitive adhesive for non-woven material, carpets, foams, and hardboard, plastic, and composite substrates. Temperature resistance makes it suitable for evaluation for beltline and below-beltline applications. Can be applied for sound absorption padding, carpet bonding, and foam substrates.
TECHNOMELT® PS 8668	PSA	Drum	Solid	553304	NA	36,000 @ 177°C (350°F)	Amber	N	177°C to 190°C (350°F to 375°F)	140°C (284°F)	A high-viscosity, permanent, pressure-sensitive hot melt designed for assembly application requiring high peel, shear and heat resistance. Adheres well to a wide variety of substrates. It has high tack and good green strength. Can be applied for sound absorption padding, carpet bonding, and foam substrates.
		Box	Brick	1399958							
TECHNOMELT® PUR 513C	PUR	Drum Pail	Solid	515271 542817	3-4	12,000 @ 121°C (250°F)	Off-White	Y	121°C (250°F)	75°C (167°F)	A moisture-cure adhesive designed to give aggressive tack, long open time and high green strength; forms a tough, strong, and virtually thermoset polymer. Used for lamination of sandwich panel elements of wood, lauan, fiberboard, particleboard, plywood, FRP, EPS foam, PU foam, and surface-treated metals.
TECHNOMELT® PUR QR R-624	PUR	Drum	Solid	1119977	0.7	13,000 @ 121°C (250°F)	Off-White	Y	121°C (250°F)	70°C (158°F)	A moisture-cure adhesive designed to give excellent adhesion to difficult-to-bond substrates, especially ABS. Used for lamination of sandwich panel elements of ABS, wood, lauan, fiberboard, particleboard, plywood, FRP, EPS foam, PU foam, and metals.
		Pail		1864070							
TECHNOMELT® PUR 913A	PUR	Drum	Solid	1223189	4-5	12,000 @ 121°C (250°F)	Translucent solid. (Blue under UV light source)	Y	107°C to 135°C (225°F to 275°F)	75°C (167°F)	Moisture-curing hot melt adhesive designed for immediate handling strength, fast setting speed and good deflection-resistance. This product has become the industry standard for trouble-free machining and runs cleanly at a low application temperature. Also, 91-913A contains UV dye for improved visibility under a UV light source. Can be applied by spray, roll coater, or slot coater adapted for reactive hot melts at optimum material temperature of 250°F.
		Pail		1223191							
TECHNOMELT® PUR 6220 UV LV	PUR	Pail	Solid	1987868	0.5	12,000-19,000 @ 130°C	Ivory	N	110-150°C	60°C	Moisture-curing adhesive based on polyurethane, designed to be roll coated or extruded. Can be cooled and reactivated within the prescribed time, before the moisture reaction starts. Used for interior automotive parts, such as door panels, door liners, load floors, instrument panels and foil lamination.
TECHNOMELT® PUR 6221	PUR	Pail	Solid	2089147	0.2	25,000-45,000 @ 130°C	Ivory	Y	110-150°C	70°C	Moisture-curing adhesive based on polyurethane, designed to be sprayed. Can be cooled and reactivated within the prescribed time, before the moisture reaction starts. Used for interior automotive parts, such as door panels, door liners, load floors, instrument panels and foil lamination.
TECHNOMELT® PUR 9622-02 UVNA	PUR	Drum	Solid	1614405	0.1 to 0.25	55,000 @ 150°C (302°F)	Light Ivory	N	126°C to 137°C (260°F to 280°F)	64°C (147°F)	A high-quality, moisture-curing hot melt adhesive. It is injectable and rollable with good wetting properties on many substrates, high initial strength, and extremely short setting time. High heat strength about 100°C. Good chemical stability. Adhesion to fiber-forming materials, wood-based materials, soft PVC films, TPO textiles, polar plastics and nonpolar plastics after pretreatment.
		Pail		1662991							
TECHNOMELT® PUR 3460	PUR	Cartridges	Solid	1264588	0.5 to 1	10,000 @ 130 °C (266°F)	Light Ivory	N/A	126°C - 137°C (260°F - 280°F)	60 °C (140 °F)	Low softening point and long open time PUR. Exhibits very high heat resistance (> 150 °C / > 302 °F) and cold flexibility. Excellent solvent resistance.
TECHNOMELT® PUR 4663 NA 20	PUR	Pail	Solid	2397340	0.5 to 1.5	6,500 - 10,000 @ 121°C (250°F)	Off-White	Y	120 - 140°C (250 - 285°F)	65°C (150°F)	High performance, moisture curing polyurethane-based hot melt adhesive. Developed for lamination where the ambient conditions can exceed 30°C. It provides high initial green strength for edge wrapping applications. Demonstrates great flexibility.
TECHNOMELT® PUR Cleaner 2	Cleaner	Bag	Granule	245517	N/A	5,500 - 7,500 @ 130 °C (266°F)	Blue	N/A	100 - 170°C (212 - 338°F)	75°C (167°F)	Effectively cleans uncured polyurethane, converts the reactive components of the poly-urethane hotmelt adhesive, to rule out further crosslinking processes. Blue colorant added for better visibility.

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**TECHNOMELT®**  
**TEROSON®**

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