



## HL3008

HL3008 is a Hot Melt Moisture Cure product is a one-component polyurethane, 100% solids hot melt adhesive. It shows strong green strength. The product works well in bonding various plastics, woods.

|                         |               |                                                 |
|-------------------------|---------------|-------------------------------------------------|
| Technology / Base       | Polyurethane  |                                                 |
| Type of Product         | Adhesive      |                                                 |
| Components              | One component |                                                 |
| Curing                  | Moisture      |                                                 |
| Solid Contents          | 100           | %                                               |
| Appearance / Color      | Yellow        |                                                 |
| Consistency             | ~8000         | mPa·s @ 130°C                                   |
| Density                 | 1.05          | g/cm <sup>3</sup> (20°C)                        |
| Film Open Time          | >2            | min (depends on different operating conditions) |
| Application Temperature | 120~160       | °C (depending on the operating conditions)      |

### Features and Benefits

- One component requires no mixing
- High green strength, long open time
- Suitable for sponge mattress lamination

### Curing Profile

To obtain complete cure, this product should be exposed to temperatures and relative humidity conditions greater than or equal to 20°C and 50% RH. For adhesive film thicknesses 0.02 inches or less, cure is typically completed in 7 days under these conditions. Complete cure will take longer at lower temperatures and lower RH. Cure rates and completeness of cure will vary with adhesive film thickness and substrate's water permeability.

Contact H.B. Fuller technical support for additional curing recommendations.

### Application Instructions

1. Contaminants like oil, dust, corrosion and dirt negatively affect the adhesion of any adhesive. Surfaces must be clean, dry and free from surface contaminants. A surface energy of 36 dynes/cm<sup>2</sup> or higher is recommended for optimum wet-out.
2. This product is either applied in beads or tapes or as a sheet onto one of the bonding surfaces. Bonding is carried out immediately upon application.

3. 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 unfavorable climatic conditions, the curing time may be considerably longer.
4. To clean spilled adhesive, allow the adhesive to cool to room temperature and scrape off heavy deposits with a putty knife. Any uncured residual film may be wiped clean with common polyurethane solvent (toluene, MEK). Clean the adhesive before it cures. Cured adhesive can only be cleaned with extremely high heat (>400°C) or an aggressive solvent such as heated N-methyl-pyrrolidone.



## Working Instructions

1. Bonding surfaces must be clean, dry, and free of grease and oil. Polyolefin materials must be corona-pretreated or flame-treated.
2. Drum unloader, heating plate, conveyor pump and applicator gun can, as a rule, should 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 160°C is sufficient for the heating plate and the conveyor pump. The application equipment may be run at temperatures of up to 160°C. For tank melters only protective gases with < 5ppm humidity should be used. Positive results have been achieved with nitrogen.
3. Please take care of that packages are used immediately after opening to prevent possible reactions with moisture.

## Typical Packaging

Please contact your local Sales Office for available packaging options.

## Disposal and Safety Advice

Please consult the Material Safety Data Sheet (MSDS) for detail instructions.

## Storage Conditions and Shelf life

Store in the original unopened packaging in a cool, dry place.  
Shelf life: 9 months from date of manufacture (see details on label).

Date Modified: 04-Feb-24

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