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Product Description Sheet

Hysol® Product 7804FRM-HV

Industrial Products, August 2001

Description

Loctite® Hysol® 7804FRM-HV polyamide hot melt is a tough, elastomeric, high performance adhesive with excellent impact resistance at low temperatures. It has been modified with fire retardant materials and has a UL 94V-0 flammability rating. It is recommended for demanding applications where substrates may be exposed to temperature extremes. Hysol 7804FRM-HV bonds to many difficult substrates including: metals, plastics, wood, leather, fabric, non-woven fabric, films and foils.

Precautions

Once melted, like any hot liquid, this adhesive can produce severe burns. Care should be taken to avoid getting hot adhesive on the skin. If skin contact occurs, flush the affected area with large amounts of cold water.

Availability

- Polyshot shapes in 35 Lbs cartons
- 10" Superstick in 25 Lbs cartons
- Pellets in 40 Lbs cartons

Storage

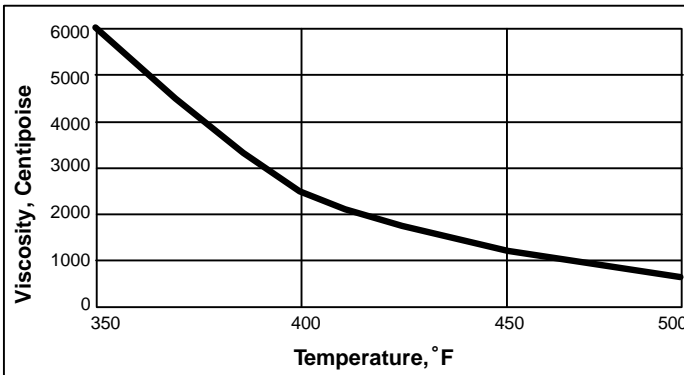
Store product in unopened container in a cool dry location. Ideal conditions are within the range 8 to 21 degrees C (46 to 70 degrees F) and are recommended for long term storage. Exposure to higher temperatures (greater than 28 degrees C) for prolonged periods should be avoided as extended exposure to warm conditions can adversely affect product properties. For further specific shelf life information, contact your local Technical Service Center.

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Loctite Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Typical Properties	Typical Value
Softening Point, °F, ASTM E 28-67	280
Viscosity @ 350°F, cP, ASTM D 3236	6000
Open Time, seconds	35
Heat resistance, °F, ASTM D 4498	220
Specific Gravity @ 77°F ASTM D 792	1.13
Tensile Strength, psi, ASTM D 638	245
Elongation, %, ASTM D 638	300
Tg, °F ASTM E 1640	-76
Application Temperature, °F	400 to 425

Viscosity Curve



GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

Application

Please read the operating instructions for the Hysol Hot Melt Applicator being used. Allow the applicator 5 - 10 minutes to reach operating temperature before applying the adhesive. Squeeze the trigger to dispense hot melt to one of the parts to be bonded. For best results, press the parts as soon as possible; within the hot melt's open time. After use, unplug the applicator and squeeze trigger twice to advance any semi-molten adhesive into the melt chamber. This helps for quick start-up when the applicator is used next. Always use gloves when using the applicator. Loctite offers a complete line of reliable, portable, hand held applicators designed to accurately dispense all shaped hot melt formulations.

NOT FOR PRODUCT SPECIFICATIONS
 THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.
 PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.
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