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Product Description Sheet

Hysol® Product 7809FR

Industrial Products, August 2001

Description

Loctite® Hysol® 7809FR polyamide hot melt is a tough, high performance adhesive that has been modified with fire retardant materials. It has a UL 94V-O flammability rating, File # E63126 Volume 1. It is recommended for demanding applications where substrates may be exposed to temperature extremes. Hysol 7809FR bonds to many difficult substrates including: metals, plastics, wood, leather, fabric, non-woven fabric, films, and foils.

Block Shear, ASTM D4501	Typical Value
24 Hour RTC, 68°F/50%RH	
PVC	200
Valox	285
HD Polyethylene	220
Polypropylene	160
ABS	275

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).

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.

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 Adhesive and Coating Systems offers a complete line of reliable, portable, hand held applicators designed to accurately dispense all shaped hot melt formulations.

Availability

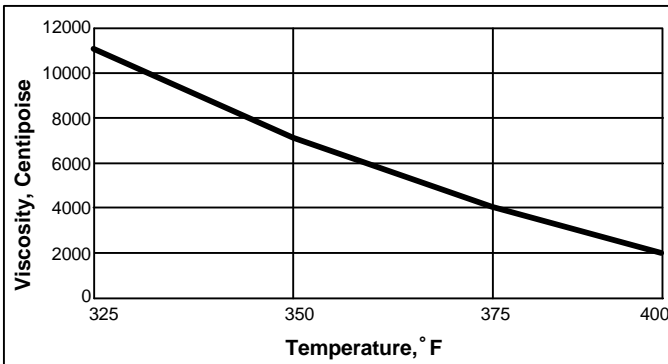
- Polyshot shape in 25 Lbs pails
- 10" Superstick in 32 Lbs cartons
- Pellets in 40 Lbs cartons

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.

Typical Properties	Typical Value
Softening Point, °F, ASTM E 28-67	269
Viscosity @ 350°F, cP, ASTM D 3236	7000
Open Time, seconds	35
Heat resistance, °F, ASTM D 4498	240
Specific Gravity @ 77°F ASTM D 792	1.01
Tensile Strength, psi, ASTM D 638	363
Elongation, %, ASTM D 638	373
Tg, °F, ASTM E 1640	-11
Application Temperature, °F	400 to 450
T-Peel Aluminum, pli, ASTM D 1876	12
Hardness, Shore A, ASTM D 2240	85

Viscosity Curve



PERFORMANCE OF CURED MATERIAL

Shear Strength vs. Substrate, ASTM D1002 psi,
(cured 5 days at 22°C)

	Typical Value
Grit-Blasted Steel	1220
Aluminum	1030
Anodized Aluminum	1430
Stainless Steel	1000
Galvanized	880
Zinc Dichromate	875
Polycarbonate	100
Nylon	450
G-10 Epoxy	560
LDPE	20
Wood (Pine)	610
Glass	325
Polystyrene	230

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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Note

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