



FM 1696
BS EN ISO 9001:2008

PRODUCT DATA

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Information Sheet No.: TDS01350-01

6330 GLUESTICKS HOT MELT ADHESIVE

BOSTIK 6330 GLUESTICKS consist of a high performance, hot melt adhesive supplied in sticks 300 mm long and approximately 11.5 mm in diameter. They are designed for application by appropriate glue guns and provide bonds with good flexibility and peel strengths, being particularly suitable for use with flexible substrates.

Gluestick adhesives have an extended open working time and the applied adhesive coating can also be heat reactivated.

The ingredients of **BOSTIK 6330 GLUESTICKS** are approved under Section 175.105 of the USA FDA regulations for use in food packaging adhesives.

BOSTIK 6330 GLUESTICKS also meet the requirements of U.K. Ministry of Defence Defense Standard 80-167/Issue 1 (replaces TS10155): ADHESIVE, HOT MELT FOR PACKAGING PURPOSES.

RECOMMENDED USE

BOSTIK 6330 GLUESTICKS are suitable for assembly and repair work with a variety of materials including paper, board, hardboard, wood, leather, skins, textiles, clear and filled rubber, open and closed cell foam rubbers, polyurethane and rigid PVC components, ABS, Perspex, aluminium, dry Oasis and Triflora, live and artificial flowers.

BONDING INSTRUCTIONS

- Ensure that the surfaces to be bonded are clean and dry. For plastics and metals solvent wiping with a cloth dipped in **CLEANER 2** or **CLEANER 7** is suggested. The abrading of hard, smooth and shiny surfaces will improve the bond
- Using an appropriate **BOSTIK HOT-GLUE GUN*** (which has a factory pre-set temperature to ensure the optimum results with this formulation) apply the adhesive to that surface, when applicable, which is the more difficult to bond (in general, metals and hard smooth surfaces are more difficult to bond than rough porous surfaces).
 - *Use the **BOSTIK TG4 GLUE GUN** for industrial production work.
 - **IMPORTANT:** When metals are bonded, pre-warming to at least 90°C is usually necessary.
- Join the two mating surfaces together (using the highest pressure practicable) as quickly as possible after adhesive application in order to obtain the best results.

NOTE: The open working time is up to 45 seconds, depending on the nature of the substrates, application temperature, volume and cross section of applied adhesive and closing pressure.

Do not move or adjust surfaces after contact has been made, as inferior bond strength will result.

As a general guide, a properly formed bond will, after joining, achieve:

Handling strength:	Within 1 minute
Full strength:	75% within 1 hour
	100% within 2 hours

CLEANER: Use **CLEANER 7** or **CLEANER 2** for surface preparation and equipment cleaning **BUT DO NOT CLEAN HOT APPLICATION EQUIPMENT WITH THESE SOLVENTS**

WARNING: When using this adhesive it is recommended that customers pre-test for any effect of subsequent painting or dyes on glued joints as some spirit based dyes can severely attack small overlap wood joints.

See final page for disclaimer

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TYPICAL CHARACTERISTICS

Physical Form:	Soft flexible solid in sticks, 300 mm long, approx. 11.5 mm diameter		
Colour:	White (translucent)		
Chemical Type:	Ethylene vinyl acetate		
Viscosity:	160 poise at 190°C		
Specific Gravity:	Approx. 1.0		
Melting Point:	80°C		
Elongation:	1800%		
Tensile Strength:	3 MPa (435 psi)		
Heat Stability	Heat degradation is not a problem with the BOSTIK THERMOGRIP GLUE GUN system of matched hand guns and gluesticks		
Temperature Resistance	-25 to + 65°C approximately		
Water Resistance	Good		
Acid & Alkali Resistance	Good		
Solvent, Oil, Fat & Plasticiser Resistance:	Poor		
Shear Strength: (at 20°C)	<u>Substrate to Itself</u>	<u>MPa</u>	<u>(psi)</u>
	Beechwood	2.65	(385)
	ABS	1.9	(280)
	Formica	2.1	(305)
	Aluminium	2.4	(350)
	Polyethylene	2.1	(300)
	Polyamide	1.8	(260)
	Polypropylene	2.0	(290)
	Polycarbonate	2.3	(335)
	Polystyrene	2.5	(365)
	PVC (rigid)	2.6	(375)
	Polymethacrylate	2.4	(350)
	Galvanized Iron	1.8	(260)
Peel Strength: (at 20°C)	<u>Substrate to Itself</u>	<u>N/mm</u>	<u>(lb/in)</u>
	Canvas	4.5	(26)

PACKAGING

For current pack sizes please contact the Customer Service Department

STORAGE

Store under dry conditions between 5 and 25°C. Keep dry during transportation

SHELF LIFE

At least 2 years from date of manufacture, under the above conditions of storage.

MATERIAL SAFETY DATA

For further information refer to the relevant Health and Safety Data Sheet.

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