KEY BENEFITS
- Black color
- Low hardness, excellent flexibility
- Long open time

DESCRIPTION
HHD 6103BK is a black color, one-component, solvent-free, moisture curing polyurethane adhesive. Once dispensed, the adhesive will react with ambient moisture or water content of the substrates to yield a cross-linked thermoset adhesive. Heat is not required for curing to occur.

APPLICATIONS
HHD 6103BK is specifically designed for the assembly of electronic devices and can bond many kinds of substrates (PC, ABS, aluminum, etc...).

TECHNICAL DATA

<table>
<thead>
<tr>
<th>CHARACTERISTIC</th>
<th>VALUE</th>
</tr>
</thead>
<tbody>
<tr>
<td>Appearance (uncured)</td>
<td>Black Solid</td>
</tr>
<tr>
<td>Brookfield Viscosity (uncured) thermosel @ 130°C</td>
<td>ca. 9000</td>
</tr>
<tr>
<td>Specific Gravity (uncured)</td>
<td>1.1</td>
</tr>
<tr>
<td>Open time*</td>
<td>5</td>
</tr>
<tr>
<td>Hardness (cured) Shore A</td>
<td>80</td>
</tr>
</tbody>
</table>

*Open time is an application parameter that depends on the environment temperature, substrates and application process.

METHOD OF USE
This product is suitable for application by HMPUR dispenser. Coating weight can vary according to substrates.
Typical application temperature range is 110-130 °C.

CURING TIME
Cure rate is dependent upon substrate type, moisture permeability and ambient conditions. HHD 6103BK will develop adhesive properties within 24 hours. However, optimum properties are achieved after three to seven days at room temperature.

PACKAGING
- 30mL – PP syringes
- 300mL – Aluminum cartridge

CLEANING
As HHD 6103BK is applied at elevated temperatures, it is advisable to clean the equipment regularly with an appropriate cleaning agent.

STORAGE
HHD 6103BK can be stored for 6 months in the original, unopened packaging in a dry place at temperatures between +15°C and +25°C. It should be processed immediately after the container has been opened.

PRECAUTIONS
Read Material Safety Data Sheet before using and handling this product. MSDS is available upon request.

The information given and recommendations made herein are based on Bostik’s research only and are not guaranteed to be accurate. The performance of the product, its shelf life, and application characteristics will depend on many variables, including the kind of materials to which the product will be applied, the environment in which the product is stored or applied, and the equipment used for application. Any change in any of these variables can affect the product’s performance. It is the buyer’s obligation, prior to using the product, to test the suitability of the product for an intended use under the conditions that will exist at the time of the intended use. Bostik does not warrant the product’s suitability for any particular application. The product is sold pursuant to Bostik’s Terms and Conditions of Sale that accompanies the product at the time of sale. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute permission, inducement, or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

SMART HELP
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