

HHD 600

SOLVENT FREE POLYURETHANE ADHESIVE

TECHNICAL DATA SHEET

Revised B303@ 2021



PRODUCT DESCRIPTION

7A / 3BB A3B4@33 7ABC@3 1C@75
 6=B3B 5C@3B6/3 /263A7D3 13 27A3A32 B63 /263A7D3
 E7: @3/1B7B6/073B 7ABC@3 @ E/B3@B3B 4 B63ACOAB@/B3A
 B6732/1@AA7932B63@A3B/263A7D3

KEY FEATURES

==24:3F707:7BG
 F13::3B/263A7=B= /D/@73BG=4ACOAB@/B3A7kC275
 5:/AA/23B/:
 =EB33@/BC@3/71/B7=<
 756B63@/:AB/07:7BG
 @317A7=27A3A75
 ==20/:/1303BE33AB@35B6/23:/AB717BG
 ==216371/:@3A7AB/73
 8A7AB/73B=AE3/B/2A30C;

DIRECTIONS FOR USE

8D3B6347D/1CC0/5@756B034@3CA/53
 @363/B B63AG@757B@313232 B33@/BC@7483232
 8D3B63321/2B63A97B63/263A7D3AC@4/13
 31B B63AG@7572/B3@
 8D3B631/12/6019/BB63B7A723
 6A3AC7B/033323/2131BBB63B7A7234@BG71/7@
 27A3A3@A
 5BB63 AG@757B= B6363/B75 C7B /93 AC@3B63/263A7D3
 63/B32CB@313232/1/B7B33@/BC@3
 5@53A/75B4/263A7D3
 5 /123C/B3 /5B4/263A7D3B34B63 ACOAB@/B3
 E67167A4@3341B/74B7AC16/A72CAE2@33/A3
 /53BA3B1

Joint the substrates within adhesive open time

@3AAB638=7B7313A/22E3::/=EB63/263A7D3B= 5@=E C>
 3<C56 @3A7AB/73A

METHOD OF USE

@02 () A6B7A A7< / @/53 4 D7A1A7B73A
 @D7275 f13F707:7BG< B63 16=713 =4 @=13AA75 3B6=2
 1/< 03 /732 OG 83BB75 03/2 AE7@:/2 A@/G
 (G71/:/71/B7=B33@/BC@3@/537A e

APPLICATIONS

7A A317471/G 23A7532 4@ B63 /AA30G 4 331B@74
 23D713A/2 1/< 02 /G 972A 4 ACOAB@/B3A ' /:C7E;
 5:/AAetc.).

STORAGE SHELF LIFE

1/< 03 AB@324@ B6A 7< B63 @757k: C332
 19/575 7< / 2@G713 /B B33@/BC@3A03BE33< +° /2
 +° BA6=C:2 03 @=13AA32 7327/B3:G /4B3@B63 1=B/73@ 6/A
 033<332 333=B/73@A1=D3@32B=777H31=B/77B7=<

HEALTH SAFETY

63 /43BG/B/ 633B 7A/D/7/03< AB79 E30A7B3/2 A6@203
 1ACB32 4@ @3@ 6/275 13/C> /2 A7: 1B/73B
 034@3CA3

LIMITATIONS

VB3@7/:@3D32 4@7B/73@A /G 03 1B/77B32 2C@75CA3
 =B @3BC@<@2C1B B=B63 @757k: 1B/73@ AB79 E7:B
 /AAC3 @3AA7077BG 4@ @2C1B B6/B 6/A 033<1B/77B32 @
 AB@32 C23@ 127B7A B63@ B6/-B6A3 @3D7EAG 7271/B32 4
 /227B7k: 74@/B7<7A @3C7@32 3/A3 1B/1B G@ @ 7/
 (31671/3@D7133B3@@1CAB3@A3@D713@3@3A3B/B7D3

PRODUCT CHARACTERISTICS

Appearance (uncured)	Light Yellow
Uncured Viscosity* (ASTM D1084: 130°C)	ca. 5000 mPa.s
Open time**	135 sec.
Operation Temperature	100°C - 130°C
Density - cured (ASTM D792)	1.1

*based on Brookfield viscometer

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

TYPICAL PERFORMANCE OF CURED MATERIAL

Cure rate is dependent upon substrate type, moisture permeability and ambient conditions. HHD 6006 will develop adhesive properties within 24 hours. However, optimum properties are achieved after three to seven days at room temperature.

For all the performance data provided in this TDS, the samples were prepared as follows : A 1.5mm*2mm width adhesive bead was applied on PC to PC with a 0.12mm spacer. A 1kg weight was applied for 20 seconds on the sample, which was then cured for 3 days @ 23°C/50%RH before testing. The tests were performed at 2mm/min

CURED PHYSICAL PROPERTIES

Tensile Elongation at Break	951 %
Tensile Strength	11 MPa
Elastic Modulus (DIN 53504/ ISO37)	49.7 MPa
Curing Shrinkage (ISO 3521)	0.9%

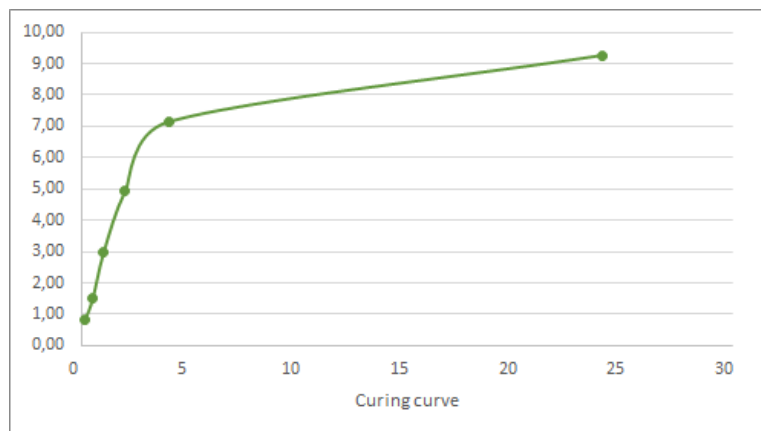
HAND HOLD SPECIFIC DATA

Sebum and sweat resistance*	Excellent
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*Internal Test Methods

CURING SPEED

Test condition: PC-PC with supporting, 23°C/50%H, 0.12mm spacer, 1.5mm*2 width adhesive bead, 1Kg weight@20 second, test method @ 2mm/min

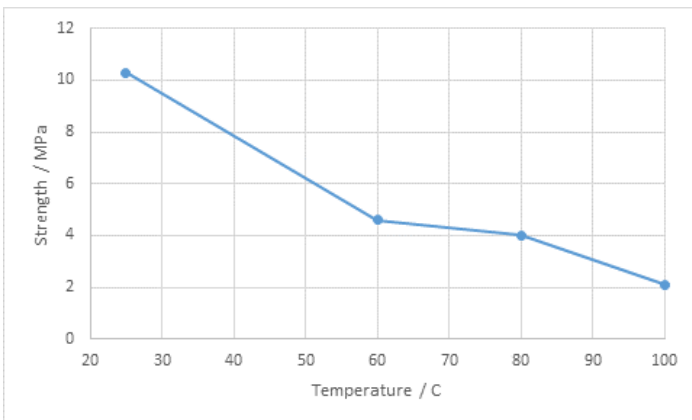


BONDING PERFORMANCE

Glass - Glass (Bare)	0.64
PC - PC	10.32
ABS - ABS	7.93
304 Steel - 304 Steel	3.13
Rilsan® PA 820 - PA 820 with Supporting	3.63
Rilsan® PA 820 - Steel	3.14

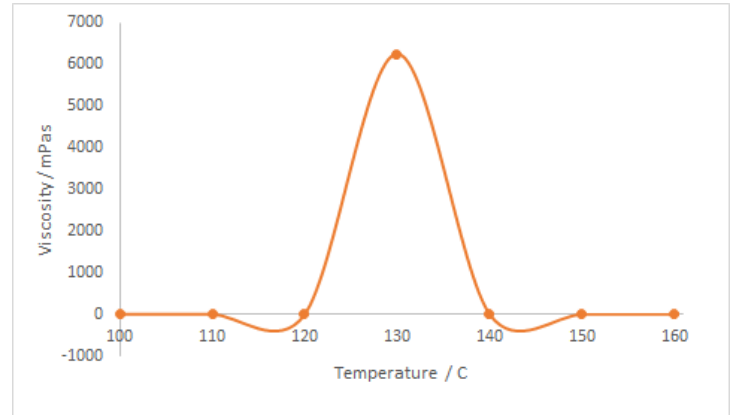
HOT STRENGTH

Test condition : PC-PC with supporting, 23°C/50% H 7days, 0.12mm spacer, 1.5mm*2 width adhesive bead, 1Kg weight @ 20 second, test @ 2mm/min, test after heat for 5min in the chamber.



APPLICATION PROCESS - VISCOSITY

Test Method: Brookfield, spindle 27 @ 20rpm, 27°C @ 60% H, 11.6g sample, idle 30min at each temperature.



CONVERSIONS

$$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$$

$$\text{kV/mm} \times 25.4 = \text{V/mil}$$

$$\text{mm} / 25.4 = \text{in}$$

$$\mu\text{m} / 25.4 = \text{mil}$$

$$\text{N} \times 0.225 = \text{lb}$$

$$\text{N/mm} \times 5.71 = \text{lb/in}$$

$$\text{N/mm}^2 \times 145 = \text{psi}$$

$$\text{MPa} \times 145 = \text{psi}$$

$$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$$

$$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$$

$$\text{mPa}\cdot\text{s} = \text{cP}$$

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