HHD 6006
SOLVENT-FREE POLYURETHANE ADHESIVE

PRODUCT DESCRIPTION
HHD 6006 is a one-component, solvent-free, moisture curing hot-melt polyurethane adhesive. Once dispensed, the adhesive will react with ambient moisture or water content of the substrates to yield a cross-linked thermoset adhesive.

KEY FEATURES
- Good flexibility
- Excellent adhesion to a variety of substrates including glass and metal
- Low temperature application
- High thermal stability
- Precision dispensing
- Good balance between strength and elasticity
- Good chemical resistance
- Resistance to sweat and sebum

DIRECTIONS FOR USE
1. Remove the Al foil vacuum bag right before usage.
2. Pre-heat the syringe at recommended temperature if needed.
3. Remove the end cap and the skin on the adhesive surface.
4. Connect the syringe adapter.
5. Remove the cap and any block at the tip side.
6. Choose suitable needle and connect to the tip side for typical air dispensers.
7. Put the syringe into the heating unit make sure the adhesive is heated up to recommended application temperature.
8. Purge small amount of adhesive.
9. Apply an adequate amount of adhesive to one of the substrate, which is free of contamination such as oil, dust, mold release agents, etc.
10. Joint the substrates within adhesive open time
11. Press the joint pieces and dwell, allow the adhesive to grow up enough resistances.

METHOD OF USE
Born2bond™ HMPUR solutions span a range of viscosities, providing flexibility in the choice of processing method. HHD 6006 can be applied by jetting, bead, swirl and spray. Typical application temperature range is 100-130°C

APPLICATIONS
HHD 6006 is specifically designed for the assembly of electronic devices and can bond many kinds of substrates (PC, ABS, aluminum, glass, etc.).

STORAGE/SHELF LIFE
HHD 6006 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. Keep containers covered to minimize contamination.

HEALTH/SAFETY
The Safety Data Sheet is available on Bostik website and should be consulted for proper handling, cleanup and spill containment before use.

LIMITATIONS
Material removed from containers may be contaminated during use. Do not return product to the original container. Bostik will not assume responsibility for product that has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or customer service representative.

Always use glasses and gloves when applying adhesives.
**PRODUCT CHARACTERISTICS**

<table>
<thead>
<tr>
<th>Characteristic</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Appearance (uncured)</td>
<td>Light Yellow</td>
</tr>
<tr>
<td>Uncured Viscosity* (ASTM D1084:130°C)</td>
<td>ca. 5000 mPa.s</td>
</tr>
<tr>
<td>Open time**</td>
<td>135 sec.</td>
</tr>
<tr>
<td>Operation Temperature</td>
<td>100°C - 130°C</td>
</tr>
<tr>
<td>Density - cured (ASTM D792)</td>
<td>1.1</td>
</tr>
</tbody>
</table>

*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 7 days @ 23°C/50%RH. The tests were performed @ 2mm/min.

**CURED PHYSICAL PROPERTIES**

- Tensile Elongation at Break: 950 %
- Tensile Strength: 11 MPa
- Elastic Modulus (DIN 53504/ ISO37): 50 MPa
- Curing Shrinkage (ISO 3521): 0.9%

**APPLICATION PROCESS - VISCOSITY**

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

**HAND HOLD SPECIFIC DATA**

- Sebum and sweat resistance*: Excellent

*Internal Test Methods
**BONDING PERFORMANCE**

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Glass - Glass (Bare)</td>
<td>1</td>
</tr>
<tr>
<td>PC - PC</td>
<td>10</td>
</tr>
<tr>
<td>ABS - ABS</td>
<td>7</td>
</tr>
<tr>
<td>304 Steel - 304 Steel</td>
<td>3</td>
</tr>
<tr>
<td>Rilsan® PA 820 - PA 820 with Supporting</td>
<td>3</td>
</tr>
<tr>
<td>Rilsan® PA 820 - Steel</td>
<td>3</td>
</tr>
</tbody>
</table>

**HOT STRENGTH**

Sample preparation and test conditions: 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 7 days @ 23°C/50%RH. The performed @ 2mm/min after heat exposure for 5min in the chamber.

![HOT STRENGTH GRAPH](image)

**SEBUM AND SWEAT RESISTANCE**

Sample preparation and test conditions: 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 soaking in sebum and sweat at 45°C for 7 days. The tests were performed at 2mm/min.

<table>
<thead>
<tr>
<th>PRODUCT</th>
<th>Before</th>
<th>After sebum</th>
<th>After sweat</th>
</tr>
</thead>
<tbody>
<tr>
<td>HHD 6006</td>
<td>10,3</td>
<td>6,3</td>
<td>8,3</td>
</tr>
</tbody>
</table>

**CONVERSIONS**

\[(°C \times 1.8) + 32 = °F\]

\[kW/mm \times 25.4 = V/mil\]

\[mm / 25.4 = \text{in}\]

\[\mu m / 25.4 = \text{mil}\]

\[N \times 0.225 = \text{lb}\]

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

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

\[MPa \times 145 = \text{psi}\]

\[N \cdot m \times 8.851 = \text{lb-in}\]

\[N \cdot mm \times 0.142 = \text{oz-in}\]

\[mPa \cdot s = \text{cP}\]
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