



FM 1696  
BS EN ISO 9001:2008

## PRODUCT DATA

Date: January 2014

Information Sheet No.: TDS01347-01

# 6370 GLEUSTICKS

## HOT MELT ADHESIVE

**BOSTIK 6370 GLEUSTICKS** consists 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 can be used for bonding a wide range of substrates. Typical applications include: carton sealing, especially carton sealing of packaged consumer goods such as gifts and confectionery where an attractive finish is required; carton tray forming and wrap around case manufacture; pallet stabilisation and food packaging applications, as well as applications within the furniture industry.

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

The ingredients of these gluesticks are approved under section 175.105 of the USA FDA Regulations for use in food packaging adhesives.

**BOSTIK 6370 GLEUSTICKS** also meet the requirements of U.K. Ministry of Defence Specification 80-167/Issue 1 (replaces TS 10155): ADHESIVE, HOT MELT, FOR PACKAGING PURPOSES.

### RECOMMENDED USE

**BOSTIK 6370 GLEUSTICKS** are suitable for use in the production of a wide variety of packaging materials including paper, board, hardboard, wood, textiles, leather, rigid PVC and certain other plastics. Users should first carry out tests to determine suitability.

### BONDING INSTRUCTIONS

- Ensure that the surfaces to be bonded are clean and dry and free from grease and dust. For plastics and metals solvent wiping with a cloth dipped in **CLEANER 7** or **CLEANER 2** 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 the surface, when applicable, which is the more difficult to bond (in general, hard smooth surfaces are more difficult to bond than rough porous surfaces).
  - Use the **BOSTIK "TG4" GLUE GUN** or **"HEAVY DUTY" GLUE GUN** for continuous production work.
  - Use the **BOSTIK "DIY HOT MELT" GLUE GUN** or **"MULTIPURPOSE" GLUE GUN** or **"CORDLESS" GLUE GUN for DIY** or intermittent 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 results

**NOTE:** The open working time is up to 30 seconds, depending on the nature of the substrate, 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.**

See final page for disclaimer

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**WARNING:** When using this adhesive it is recommended that the customer 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.

## TYPICAL CHARACTERISTICS

Physical Form:	Flexible solid cylindrical sticks 300 mm long, approximately 11.5 mm diameter		
Colour:	Translucent water white		
Chemical Type:	Ethyl vinyl acetate		
Viscosity:	Approx. 115 poise at 177°C		
Solids Content:	100%		
Specific Gravity:	Approx. 1.0		
Softening Point Ball & Ring:	Approx. 88°C		
Temperature Resistance:	-40 to +70°C approximately		
Water Resistance:	Good		
Solvent, Oil, Fat & Plasticiser Resistance:	Not resistant.		
Shear Strength at 20°C:	<u>Substrate to itself</u>	MP a	(psi)
	Beechwood	1.4-2.0	(200-300)
Peel Strength at 20°C:	<u>Substrate to itself</u>	N/mm	(lb/in)
	Canvas	1.75	(10)

## PACKAGING

For current package 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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