

## TECHNOMELT PUR 513C

November 2021

### PRODUCT DESCRIPTION

TECHNOMELT PUR 513C provides the following product characteristics:

<b>Technology</b>	One-Component Polyurethane Reactive
<b>Product Type</b>	Hotmelt
<b>Application</b>	Furniture and Buildings
<b>Appearance</b>	Off white Lavender

### Application Areas

TECHNOMELT PUR 513C is a one component polyurethane reactive hot melt adhesive used for lamination of sandwich panel elements of wood, lauan, fiberboard, particleboard, plywood, FRP, EPS foam, PU foam and surface-treated metals.

### Product Properties

- It is designed to give aggressive tack, long open time and high green strength.
- The product cures through reaction with moisture to form a tough, strong, and virtually thermoset polymer.

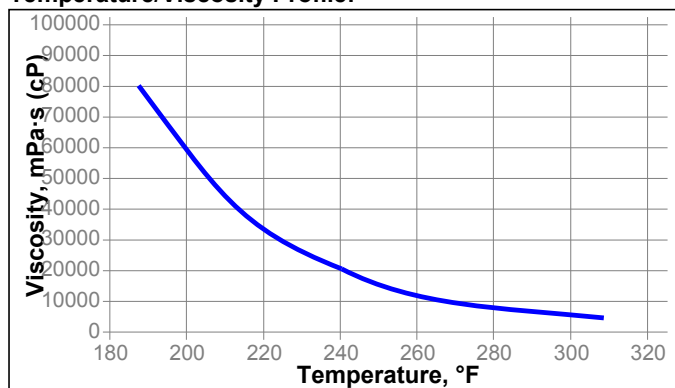
### Technical Data

#### TECHNOMELT PUR 513C:

Solids Content, %	100
Viscosity, Brookfield - 250 °F, cP (mPa.s)	12,000
Open Time, minutes	Approx. 3 to 4

Open time will vary depending to a large extent on the thermal conductivity of the substrate being coated. With surfaces that are good insulators (such as wood, foamed plastics and high pressure laminate), the open time may be extended; while with metals, open time may be shortened.

### Temperature/Viscosity Profile:



### DIRECTIONS OF USE

#### Preliminary Statement

Prior to application it is necessary to read the **Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

#### Application

TECHNOMELT PUR 513C can be applied by roll coating, extrusion, swirl spray, or reactivation.

Deposition rate can vary depending on substrate porosity. Spread rates of 8 to 12 grams per square foot are often used for roll coat applications; 6 to 10 grams per square foot are often used for extrusion or spray applications.

Henkel strongly suggests consulting with a sales or technical service professional for specific recommendations on any particular application.

Surface must be free of oil, grease, lubricants, dust, and any other surface contaminants.

Aluminum or other metals must be conversion coated or primed for best adhesion.

#### Working Temperature

Recommended working temperature: 250 to 275°F

Depending on the processing and performance needs of the application, temperatures may vary. However, adhesive temperatures above 300°F should be avoided.

NOTE: Use only with adequate forced ventilation. READ PRECAUTIONS BEFORE USING ADHESIVE.

#### Processing

Reactive hotmelt adhesives have a limited thermal stability even when working at the specified working temperatures. Therefore we recommend that after a period of 4 hours without production, that the unit is either switched off, or the set temperatures on the unit be reduced to 60°C.

#### Cure

Curing of TECHNOMELT PUR 513C is accomplished through reaction with moisture. The moisture can be provided by substrate, through absorption from the atmosphere, or a combination of both. Under extremely dry conditions, artificial ambient humidification will help to ensure full cure. Consult your sales or technical service professional for specific recommendations on substrate moisture content and ambient temperature and humidity levels. Under extremely dry conditions a light water-mist will help the cure. High temperatures accelerate curing.



**Cleaning**

Henkel offers a selection of TECHNOMELT PUR Cleaners to facilitate the removal of cured and uncured materials. To clean hoses and nozzles, use TECHNOMELT PUR Cleaner 2, Cleaner 4, Cleaner ME or Cleaner All-In-One. To clean uncured material from the rolls of roll coaters, use Cleaner785A. To facilitate removal of cured material from the rolls of roll coaters, use Cleaner 7. TECHNOMELT PUR Cleaner 3030 and M-O-C may be used to remove uncured hot melt from surfaces. Some cured material may require removal by mechanical means or the use of a special solvent for removal (e.g., n-methyl pyrrolidone) if necessary.

**Safety**

1. This product contains isocyanate.
2. Read SDS before handling and using this product.
3. Use only in equipment intended for reactive hot melts. Do not use in conventional hot melt equipment.
4. Forced ventilation must be provided over applicator and melting equipment to remove any small amount of isocyanate vapors to the outside.
5. All users of RHM products should maintain an ongoing industrial hygiene program.
6. This program should include contingency provisions in the event of ventilation failure as well as MDI monitoring

**Packaging:**

55-gallon drums

**STORAGE**

Store in a dry area at 60 to 95°F.  
 Rotate stock, using oldest material first.  
 Do not expose to the atmosphere or other wise contaminate with moisture.  
 Moisture contamination will cause a sharp melt viscosity increase and a cured skin on top of the container.  
 Containers must be used completely after opening.  
 Do not attempt to reseal.

**Shelf life**

Shelf-life (in unopened original packaging), months 6

**Classification**

Please refer to the corresponding **safety data sheets** for details on:

**Hazardous Information**  
**Transport Regulations**  
**Safety Regulations**

**ADDITIONAL INFORMATION****Disclaimer**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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