



Thermogrip® 6239

HOT MELT ADHESIVES

Product Description

Bostik® Thermogrip® 6239 is a long, open time **polyamide** hot melt designed for bonding a wide variety of substrates. This high performance adhesive bonds wood, metal, most plastics, including PVC and exhibits excellent resistance to plasticizer migration.

Formula has met General Motors Specification 9985878 for seat bonding.

This product may be compositionally compliant to one or more FDA regulations for food packaging. Please contact the Bostik Regulatory Department for up-to-date FDA compliance information.

Product Benefits

- Low application viscosity
- High temperature resistance
- Good low temperature flexibility
- Long open time
- Resistance to plasticizer migration

Product Applications

- Furniture assembly: vinyl-to-vinyl, wood or plastic
- Automotive repair
- Wood cabinet assembly
- Filter assembly

Application Information

1. All surfaces should be clean and free of contaminants. If necessary, clean surfaces with solvent.
2. Apply the adhesive to the more difficult-to-bond surface. In general, hard, smooth surfaces are more difficult to bond than rough, porous surfaces.
3. "Open-time" varies depending on application temperature, amount of adhesive applied, type of substrate and ambient temperature conditions.
4. Mate the surfaces to be bonded as quickly as possible after adhesive has been applied for optimum bond strength.
5. Use firmest pressure practical for object being bonded. Do not move or adjust surfaces after contact has been made, as inferior bond strength will result.
6. Bonding some metals is enhanced by pre-warming the surfaces. Pre-warm up to 200°F (95°C) for optimum effect.

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7. Typically, a properly formed hot melt adhesive bond will achieve 50% of its strength after 1 minute, 75% after 1 hour, and 100% after 1 day.

Typical Physical Properties* (After 24 Hour Cure)

Color:	Amber
Size (dia. x length):	1/2" x 12"
Odor:	Light
Melt Point (R&B):	284°F (140°C)
Specific Gravity:	.96 gms/cc
Viscosity, cps:	
@ 375°F	6,000
@ 400°F	3,900
Open Time:	Up to 75 secs.
Temperature Resistance:	0°F to 239°F (-18°C to 115°C)

Bond Characteristics*

Bond Strength, Shear, psi:	
ABS to ABS	410
Acrylic to Acrylic	250
Polycarbonate to Polycarbonate	200
Polypropylene to Polypropylene	30
Beechwood to Beechwood	545
Chemical Resistance	
Water	Good
Weak Acids & Alkalies	Fair
Fats & Oils	Fair
Solvents	Poor

Storage and Handling

Shelf life is 999 days at 73°F (23°C) in sealed containers.

Note: Polyamides slowly absorb moisture/humidity from ambient air which may cause foaming upon melting of the product. Care should be taken to minimize moisture exposure. Keep containers sealed when not in use and store in cool, dry area.

Further Information: Please refer to MSDS for complete details.

* Values given are not intended to be used in specification preparation.

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