

**Bostik® Thermogrip®**  
**6333****HOT MELT  
ADHESIVES****Product Description**

Bostik® Thermogrip® 6333 is a **polyethylene-based** hot melt adhesive which exhibits good shear strength and good adhesion to porous substrates particularly for packaging applications.

Bostik® 6333 is in compositional compliance with FDA Regulation 21 CFR 175.105 for food packaging.

**Product Benefits**

- Medium open time means more assembly time
- Low viscosity, less finger fatigue
- Wide temperature service range

**Product Applications**

- Corrugated case and carton sealing
- Bondable porous substrates include paper, filter paper and fabrics, woven and non-woven cotton, cordage, burlap and canvas.
- Good adhesion to wood

**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. 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:	Straw, opaque
Size (dia. x length):	1/2" x 4", 1/2" x 15"
Melt Point (R&B):	210°F (99°C)
Specific Gravity:	0.95 gms/cc
Viscosity, cps: @ 350°F (177°C)	2,050
Open Time:	15 to 20 secs. (variable)
Temperature Resistance:	-22°F to 170°F (-30°C to 77°C)

**Bond Characteristics**

Bond Strength, psi:	
Beechwood-to-beechwood	550
Chemical Resistance	
Water	Good
Weak Acids & Alkalies	Fair
Fats & Oils	Poor
Solvents	Poor

**Storage and Handling**

Shelf Life:	999 days @ 73.4°F (23°C)
Shipping and storage:	Between 40°F to 95°F (4°C to 35°C)
Further Information:	Please refer to MSDS for complete details.

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

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