

Bostik® Thermogrip®
2391**HOT MELT
ADHESIVES****Product Description**

Bostik® Thermogrip® 2391 is a general purpose, medium open time hot melt glue cartridge for use in applicators utilizing 1" cartridges. It exhibits good bonding characteristics on a wide variety of substrates including cardboard, foam, fabric, wood and some plastics.

Bostik® 2391 is in compositional compliance with FDA regulation 21 CFR 175.105 for food packaging.

Product Benefits

- Medium open time means more assembly time
- Withstands elevated temperatures
- Good cold resistance

Product Applications

- Packaging—case and carton closure
- Cabinet manufacturing
- Display boards

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:	Light tan
Size (dia. x length):	1" x 3"
Ring & Ball Softening Pt.:	203°F to 210°F (95°C to 99°C)
Specific Gravity:	0.958 gms/cc
Viscosity, cps: @350°F (177°C)	1,900
Open Time:	40 secs.
Temperature Resistance):	-20°F to 160 (-29°C to 71°C)

Bond Characteristics

Bond Strength:	
Shear Strength (Plywood):	300 psi
Peel Strength (Canvas), lbs./linear inch:	4.0

Chemical Resistance

Water	Good
Acids & Alkalies	Fair
Fats & Oils	Fair
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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