



HL0705S

HL0705S is a polyolefin hot melt adhesive designed for general product assembly. It has fast setting and has high green strength. HL0705S has good heat resistance, excellent chemical resistance, and acid resistance particularly for battery acid. HL0705S bonds well to various substrates including plastics, rubbers, polyolefins, wires, carpets, wood, PP, ABS, fiberboard. Typical applications include air filter assembly, acid battery assembly, and medical hardware assembly.

Technology / Base	Hot Melt
Type of Product	Polyolefin
Components	One component
Curing	Non-curing
Appearance / Color	Light Amber
Consistency	Viscous Liquid (Solid at Room Temperature)

Features and Benefits

- High green strength
- Fast setting
- Good bond strength on a variety of substrates
- Good heat resistance
- Excellent chemical and acid resistance
- Good adhesion to metal

Technical Data

Property	Value
Rheology	
Viscosity	23,452 cPs at 300 °F 2,900 cPs at 325 °F 2,040 cPs at 350 °F 1,500 cPs at 375 °F 1,040 cPs at 400 °F 597 cPs at 450 °F
Physical Properties	
Solids Content	100%
Density	7.6 lb/gal
Specific Gravity	0.95
Heat Resistance	145 °F
Shelf Life	24 months
Softening Point (Ring and Ball)	295 °F
Recommended Application Temperature	345 to 365 °F
Static Adhesion Failure Test Temperature	104 °F (100 Gram Oven Peel)
Static Adhesion Failure Test Temperature	200 °F (Programmed Oven Shear)
Volatile Organic Content Weight Percent (EPA 24)	0%



Application and Clean-up

Coating surface area should be clean and free of any oils, residues, dust or any other contaminants.

Typical equipment: A hot melt application equipment capable of maintaining the suggested adhesive temperature noted above and appropriate for the application. An inert nitrogen blanket is suggested (not required).

General application:

- (1) Purge the previous hot melt adhesive from the equipment.
- (2) Set the equipment temperature to the suggested settings above.
- (3) Adjust the pump pressure for the desired adhesive amount.
- (4) The open and set time characteristics may be modified with small adjustments to the amount of the applied adhesive and equipment temperature settings.

Cleaning: Consult the equipment manufacturer for cleanup procedures.

Storage Conditions

Clean and dry conditions above 20 °F and below 120 °F in the original container.

Safety and Disposal

Please refer to the SDS for product safety and disposal instructions.

To minimize the risk of burns, we recommend the use of eye protection and protective clothing when working near a hot melt applicator. To minimize the risk of flammable vapors, do not exceed a melt temperature above 400 °F. Prevent the build-up of vapors.

Extinguish all sources of ignition during hot melt use. Please refer to the SDS for additional safety advice.

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