



## Technical Data Sheet

### H.B. Fuller HL6369

This product is a hot melt adhesive that has a long open time, excellent hot tack, and high as well as low temperature resistance. It shows good adhesion to metal. It is suitable for bonding fiberglass insulation to metal as well as many other general assembly type applications. This product has good initial handling strength and reaches its ultimate strength in about 72 hours.

Technology/Base	Hot Melt
Type of Product	APAO
Color/Appearance	Gardner color = 3-9
Consistency/Form	Solid

#### Features and Benefits

- Good initial handling strength
- Long open time
- Excellent hot tack
- High and low temperature resistance

#### Technical Data

Property	Typical Value
Viscosity	6,300 cP at 325 °F
Specific Gravity	0.93
Softening Point	298-314 °F
Application Temperature	350-400 °F
Shelf Life	365 day

#### Typical Applications

It is suitable for bonding fiberglass insulation to metal as well as many other general assembly type applications



## Technical Data Sheet

---

### Application & Cleaning Instructions

---

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.

### Typical Packaging

---

Please contact your local Sales Office for available packaging options

### Disposal Advice

---

Please refer to the SDS for disposal instructions.

### Safety Advice

---

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.

**NOTE TO USER:** by ordering/receiving product you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), break of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

**IMPORTANT:** The information, specifications, procedures and recommendations herein (together "information") are based on our experience and we believe these to be accurate. No Representation, guarantee or warranty is made as to the accuracy or completeness of the information or that the information will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance, goodwill or any indirect or consequential losses arising out of or in connection with product supply.

#### North America

888-HBFULLER

888-423-8553

[inquiry@hbfuller.com](mailto:inquiry@hbfuller.com)

[www.hbfuller.com](http://www.hbfuller.com)

