



Swift®melt 82674

82674 is specifically formulated as a light colored adhesive to form permanent bonds which uniquely combines high peel strength with low viscosity, enabling it to be applied with spray as well as conventional application equipment. 82674 is recommended for general purpose applications where ease of coating and high performance is desired. Typical applications include peel and stick flooring.

Technology / Base	Pressure Sensitive Hot Melt Adhesive
Type of Product	Synthetic Resin
Components	One component
Curing	Non-Reactive
Appearance / Color	Light Yellow
Consistency	Viscous Liquid (Solid at Room Temperature)

Features and Benefits

- Low viscosity allowing wider application temperature and more effective machining
- Very high peel strength and high heat resistance
- Excellent quick tack
- Broad application methods including spray, extrusion, and slot die
- Good adhesion to a variety of substrates and film stocks
- Good peel, shear and tack properties

Technical Data

Property	Value	Condition/Method
Rheology Viscosity	4,900 to 7,400 cPs	at 300 to 350 °F
Material Properties Shelf Life at 25°C	12 months	unopen original container
Solids Content	100%	
Mettler Soft Point	111 °C	ASTM D3461
Application Temperature	300 to 350 °F	
Peel Strength	8.5 lb/in	180 Degree Peel, PE on SS
Shear Strength – minimum	1200 lb	0.25 in, PE on SS
Polyken Tack	2000 g/cm ²	PE

Application and 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. First drain as much molten material as possible from the line. Then flush the unit with paraffin or a product that is recommended by the equipment manufacturer.

Product is ready to use as received; do not dilute hot melt adhesive.



Confirm compatibility before making hot melt adhesive changes.

Storage Conditions

Store for 1 year in a cool, dry place at a temperature 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.

This product compositionally meets the requirements of Section 175.105 of 21 CFR. To minimize the risk of burns, it is 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.

Typical Packaging

Please contact your local Sales Office for available packaging options.

Date Modified: 4 September 2013

Connecting what matters.™

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience, and we believe this information to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product 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.

© and ™ are trademarks of H.B. Fuller Company or one of its affiliated entities.



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 this documentation. 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, (1) the total aggregate liability of H.B. Fuller for any claim or series of related claims, however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability, or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. (2) 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. (3) Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence, death, or personal injury caused by negligence, or for breach of any mandatory implied terms unless permitted by law.

H.B. Fuller
www.hbfuller.com

©H.B. Fuller Company, 2021