EV Bond 775

Technical Data Sheet

Reactive Hot Melt

EV Bond 775 is a patented Hot Melt Moisture Cure product. It is a one-component polyurethane, 100% solids hot melt adhesive.

It has characteristics of a pressure sensitive adhesive, but optimal adhesion is achieved from 10 seconds to 15 minutes after application. This product has aggressive hot tack and cures in the presence of moisture to a tough, elastomeric film. It works well in bonding various plastics, woods, metals, and glass substrates.

CHARACTERISTICS

Appearance:	Yellow-light brown
Brookfield Viscosity:	Approx. 10,000 mPa.s at 150°C
Density g/cm³ (20°C):	1.02
Film Open Time:	Up to 15 minutes
Coverage:	50-120 g/m²
Application Temperature:	Between 140°C and 160°C depending on the operating conditions.
Application Methods:	Can be run on all standard hot melt roller systems
Shelf Life:	6-12 months

PRE-TREATMENT OF BONDING SURFACES:

Bonding surfaces have to be clean, dry and free of grease and oil.
Polyolefin materials have to be corona-pretreated or flame-treated.

Features and Benefits

- High green strength allows immediate handling processing and testing
- Open time of 15 minutes allowing for extended assembly time.
- Excellent adhesion to a diverse selection of substrates including engineering plastics such as polycarbonate, and metals including stainless steel and aluminum.
- Dispense like a one-part hot melt adhesive, reacts with atmospheric moisture to form a tough, cross-linked urethane polymer network.

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TYPICAL UNCURED PROPERTIES

Property	Value
Color	Yellow
Viscosity @150°C, cps	7,500-12,000
Specific gravity, g/cm3	1.02
Solids, %	100
Shelf life @15~40°C, days	180

TYPICAL CURED PROPERTIES

Property	Value
Tensile strength at break, MPa	10.8
Elongation at break, %	575
Tensile lap shear adhesion, MPa *Al-Al after 168 hours of cure	4.5

TYPICAL APPLICATION PROPERTIES

Property	Value
Application temperature, °C *at hot melt dispenser	140-170
Open time, minutes *dependent on adhesive bead size, substrate type and environmental conditions	>15

Application Instructions

1. EV Bond 775 can be dispensed using automatic heating, dispensing or dipping systems at temperatures of 140-170°C.

2. Green strength will be achieved as soon as the adhesive bond has cooled.

Handling and Clean-Up

To clean spilled adhesive, allow the adhesive to cool to room temperature and remove heavy deposits. Any uncured residual adhesive can be scraped off using a blade. After scraping, wipe clean with a common polyurethane solvent. Clean up the adhesive residue before it cures.

If the dispense equipment is to be shut down for extended periods of time, we recommend purging the system with H.B. Fuller swift®clean 9037. Partially used containers of EV Bond 775 should be purged with a dry inert gas and resealed between uses.

Please consult your H.B. Fuller technical representative for additional recommendations.

Storage and Shelf Life

EV Bond 775 should be stored in its original sealed foil bag in a dry location that maintains temperatures between 15˚C to 40°C. Shelf life is 6 months in original unopened (sealed) foil bag when stored at this temperature range

Safety and Disposal

Please see the Material Safety Data Sheet (MSDS) for proper handling and disposal instructions.

Note

The values noted in this data sheet are typical properties only and are not intended to be used as material specifications.

For assistance in writing a material specification please contact H.B. Fuller Company..

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