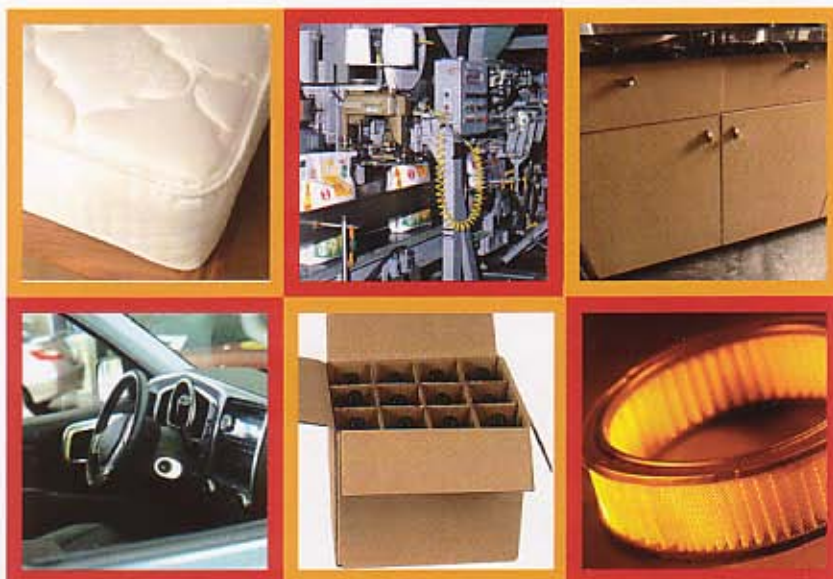




Technology to stick with™

Specialty Hot Melt Adhesives

A reference guide to industry-specific formulas for automated applications



Adhesive Tech
3 Merrill Indust
Hampton, NH C

The logo for Heigl Adhesives features a stylized yellow and blue drop shape inside a circular frame. The word "Heigl" is written in a large, bold, blue font with a yellow outline, and "Adhesives" is written in a smaller, blue font below it. The tagline "Drops to Drums" is written in a curved path around the drop shape.

7630 W. 78th St. Bloomington, MN 55439
Visit us online at:
www.heigl adhesive.com
Bus: 952.943.1441 / 1.800.401.1441 • Fax: 952.943.1255

www.adhesivetech.com

INDUSTRY REFERENCE

Category	Application	Substrates / Uses	Adhesive Needed
APPLIANCES	HVAC, Insulation, Ducts	AL, FRP, Paper	296, 297
AUTOMOTIVE	Interior Trim Seating	PP, Vinyl, Insulation, Sound Proofing Foam, Fabric	067, 292, 296, 297 292, 296, 297
BOOK BINDING	Spine and Side Seam	Paper, Fiber	057, 890, 891
DOORS/MILLWORK	Hollow Core, Insulation	Wood, Metal, Composite	292, 296, 962
FILTERS	Automotive/Consumer Assembly	Paper, Nonwovens, Elastomers	289, 616
FURNITURE	Cabinets, Construction Edge Banding, Veneers Mattresses	Wood, Laminates Wood, Plastic, MDF, Particle Board Urethane, Latex Foam, Fabric	601, 852, 962 851, 852, 853 051, 058, 294, 296, 297, 614
	Upholstery	Fabric, Wood, Foam	051, 058, 294, 296, 297, 614
	Window Treatments	Fabric, Wood, Nonwovens	700
NONWOVENS	Absorption Pads Carpet Mat Non-Slip Carpet Seaming Consumer Hygiene Products RV Interior Walls	Fabric, Fiber, Paper Fiber, Fabric Fiber, Fabric Fiber, Fabric Fabric, Nonwovens	296, 297 055 229, 962 296, 297 296, 297
PACKAGING/EOLP	Carton Closing Carton Closing Carton Closing Carton Closing	Corrugated, Wax Corrugated PP, UV, PE Corrugated High Heat Resistance, Hot Fill Freezer Grade	510, 511, 513 601, 611, 612, 661 059, 186, 292, 299, 640 295 512, 611, 613
PACKAGING/PROTECTIVE	Carrying Cases Foam Inserts, Fabrication	Plastic, Wood, Foam EPS, Ethafoam, Corrugated	054, 292 296, 297, 299, 962
PACKAGING/SPECIALTY	POP Display/Product Assembly Consumer Products Clear Cases Flexible Packaging Fugitive Glue, Temporary Hold Tamperproof/Destructive Closure Bags	Wax, UV, Porous Materials TetraPak/Straw Bonding, Bottle Wraps, Soap Wraps, Paper, Plastics Polyethylene Paper, Plastics, Laminates Credit Cards, Samples, Direct Mail PP, PE, Multiwall, Poly Mailers	058, 059 229, 291, 640 052, 293, 615 062, 299 299, 613 050, 053, 056, 060 061, 299

FORMULA	FORM	DESCRIPTION	HEAT RESISTANCE * SAFT ** Adtech	VISCOSITY @350°F, cps	SOFTENING PT.	SHEAR TENSILE pine, psi	WORKING TIME seconds
229	Pellets	General purpose adhesive for plastics and porous substrates, clear	146°F/63°C **	11,000	190°F/88°C	353	35-45
601 Hot Pac	Chips	Fast set, 350° F packaging adhesive, tan	135°F/57°C **	1,100	216°F/102°C	775	25
611	Chips	Freezer grade packaging adhesive, good to -26°F/-32°C, light yellow	160°F/71°C**	1,400	220°F/104°C	704	2
612	Chips	Great for wax coated cartons, rapid set, light tan	145°F/63°C**	2,400	205°F/96°C	833	1
613	Pellets	Flexible, general purpose use, freezer capable, amber	145°F/63°C**	1,625	170°F/77°C	519	15-20
614	Pellets	Good for bonding foams, fabric and nonwovens, clear	155°F/66°C**	12,000	175°F/79°C	125	30-45
615	Pellets	Low temperature, good adhesion to paper, no stringing, yellow	145°F/63°C**	500	176°F/80°C	160	5
616	Pellets	Quick set, high adhesion, good thermal stability, white	165°F/74°C**	4,500	230°F/110°C	548	10
640	Pillows	Low viscosity, formulated for UV coated paper and cartons, tan	130°F/54°C **	2,000	194°F/90°C	450	50
661 Cool Pac	Chips	Low temperature, 250° F packaging adhesive, light tan	135°F/57°C**	950 (@ 250°F)	158°F/70°C	355	15
962	Pellets	Excellent wood working adhesive, good general purpose use, tan	130°F/54°C **	6,000	208°F/98°C	625	30-40
510	Chips	Metallocene based, rapid set packaging adhesive, white	180°F/82°C**	1,100	210°F/99°	512	15
511	Chips	Metallocene based, fast set packaging adhesive, extended pot stability, strong, white	170°F/77°C**	800	219°F/104°C	448	15
512	Chips	Metallocene based, low temp, general purpose use, freezer grade, white	140°F/60°C**	850 (@ 275°F)	165°F/74°C	331	40
513	Chips	Metallocene based, general purpose use, high heat resistance, white	175°F/79°C**	1,000	232°F/111°C	541	10
050	Pellets	PSA, non-bleeding, fugitive glue, off-white	150°F/66°C**	950	197°F/92°C	73	25
051	Drums	PSA, medium viscosity, rubberized, high tack, high heat resistance, light yellow	205°F/96°C**	6,000	260°F/127°C	158	5
052	Pillows	PSA, high peel and initial tack, light yellow	126°F/52°C *	586	167°F/75°C	73	25
053	Pillows	PSA, low tack, fugitive glue, amber	160°F/70°C **	10,800	200°F/93°C	47	15
054	Pillows	PSA, high peel, good initial tack, good heat and cold resistance, yellow	162°F/72°C *	5,000	212°F/100°C	107	25
056	Pillows	PSA, low surface tack, low viscosity, fugitive glue, light yellow	125°F/52°C *	1,185	192°F/89°C	58	15
058	Blocks	PSA, ultra high tack, amber	120F°/49°C **	1,500	172°F/78°C	95	35

LEGEND:

EVA

Metallocene

PSA

APAO

Specialty

