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TECHNICAL DATA SHEET

PRODUCT NAME: SPECTRA-MELT Primer 362 / Curative 362

PRODUCT DESCRIPTION:

Two-component adhesive system to promote adhesion between thermoplastic hotmelt resin and difficult substrates.

MARKET USE: Automotive, electronics encapsulation, LED, strain relief and other markets.

Product	362 Primer	362 Curative
Appearance	Clear to Amber Liquid	Transparent Brown Liquid
Viscosity (cps@25°C) Brookfield LVT Spindle 2, 30 rpm	400 - 1000	<10 (typical)
Density (kg/m ³)	850.8 - 874.7	1010.0 - 1040.0
Solid Content by Weight (%)	15 - 17	47 - 51.5
Flash Point Seta (°C)	-4	29
Solvents	Methyl Ethyl Ketone (MEK), Xylene	Xylene

APPLICATION:

Surface Preparation – Remove grease, oil, fingerprints, dust, mold release agents, rust and other contaminants from surface to be bonded.

Mixing – In a well-ventilated area and proper PPE (please refer to SDS), slowly adding 6-10 parts of **Curative 362** to 100 parts of **Primer 362, by weight** in an appropriate container.

If dilution is needed, use xylene in a ratio of 3 parts mixed adhesive system to 1 part solvent, by weight.

Applying – Apply adhesive system by spray, brush, or dip methods. The recommended dry film thickness is 17.8-25.4 micron (0.7-1.0 mil).

Drying/Curing – Allow adhesive to air-dry for 30-60 minutes at room temperature. Full bond strength will take 24 hours at room temperature.



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Optimum adhesion is achieved when molding is done shortly after adhesive application and drying, however coated parts can sit for one week before bonding if care is taken to protect the coated parts from contamination.

Cleanup – Use solvents such as xylene or MEK to remove adhesive before heat is applied. Remove cured adhesive by mechanical blasting methods.

HANDLING SUGGESTIONS: Before applying, it is necessary to read the Safety Data Sheet (SDS) for information about precautionary measures and recommendations. For chemical products exempt from compulsory labeling, the relevant precautions should always be observed.

For Industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

FORM OF SUPPLY:

STORAGE: Shelf life is one life from date of shipment when stored in a well-ventilated area at 21-27 °C.

The information above, particularly the recommendations for application and use of our products is based on our knowledge and experience. Due to the different substrates and conditions of application, which is beyond our knowledge and control, we strongly recommend carrying out sufficient tests to ensure that the product is suitable for the intended process and applications.

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