



Clean Melt[®] PHC8420

Type of Adhesive Hot Melt Adhesive

Product Benefits This product is an advanced case forming hot melt adhesive based on patented HB Fuller technology. It provides a unique combination of benefits, including a clear, consistent color, odor and smoke-free environment, increased mileage and clean machining. It exhibits high heat resistance and is fast setting.

Typical Applications Agricultural markets, Bliss Boxes and other high stress corrugated applications

Suitable Substrates Uncoated and lightly coated corrugated

Typical Properties

Property	Value
APPLICATION TEMPERATURE	350 deg. F
COLOR	OFF-WHITE
COLOR GARDNER INDEX	1
ODOR	CHARACTERISTIC
SHELF LIFE	365 day
SOFTENING POINT	230 deg. F
SPECIFIC GRAVITY	0.98
STATIC ADHESION FAILURE TEST TEMPERATURE (100 GRAM PROGRAMMED OVEN PEEL)	145 deg. F
STATIC ADHESION FAILURE TEST TEMPERATURE (500 GRAM OVEN SHEAR)	202 deg. F
VISCOSITY (@ 250F)	5,200 cP
VISCOSITY (@ 300F)	2,150 cP
VISCOSITY (@ 350F)	1,240 cP

Application Instructions Application temp: See table above.

Suggested application methods include roll coating and extrusion.

Cleaning Instructions Consult the equipment manufacturer for cleanup procedures. After clean-up, flush the applicator thoroughly with hot melt to



	purge the system.
Typical Packaging	Please contact your local Sales Office for available packaging options.
Storage Conditions	Clean and dry conditions above 20°F and below 120°F.
Disposal Advice	Please refer to the MSDS 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 400F. Prevent the build-up of vapors. Extinguish all sources of ignition during hot melt use. Please refer to the MSDS for additional safety advice.

Our Focus is Clear. Perfecting Adhesives.

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