

**PRODUCTION TECHNICAL BULLETIN**  
**H.M.T. Manufacturing, Inc.**  
**Hot Melt Adhesives**

General Description:

HMT's hot melt adhesives are clear medium viscosity adhesive films. The films are fast settings and thermoplastic in nature, designed for handling a wide variety of materials.

Physical Properties:

Color:	Clear:
Form:	Film:
Solids:	100%
Filler:	None
Viscosity @ 375° F:	30,000 cps
Viscosity @ 400° F:	20,000 cps
Dead Load Failure:	210° F
Softening Point:	206°-212° F
Open Time:	3-5 seconds maximum
Application Temp: (equipment)	375°-425°F (with HMT)

All three formulations are very compatible: Cloud point below 120°F.

Results regarding Ring and Ball softening point, SAFT (shear adhesive failure temperature) and open time:

<b>Characteristics</b>	<b>Advantage Adhesive</b>	
R&B	208.4°F	
SAFT	197.6°F	
Open Time	<3s	<3s

HMT Manufacturing, Inc. is available to help purchasers obtain best results for our products. Recommendations are based on tests and information believed to be reliable. However, we have no control over the conditions under which our products are stored, handled, or used by purchasers and in any event, all recommendations and sales are made on condition that we will not be held liable for any damage resulting from their use, or that such information will not infringe a patent.

**VOC (Volatile Organic Compounds) Information under the EPA method 24:  
FORMALDEHYDE CONTENT: There is no formaldehyde in HMT Hot Melt Adhesives.**

Methods & Equipment: Thermal Gravimetric Analyzer (TGA) - no VOC's under 300°C / 572°F