



PRODUCT DATA

650 FOAM MELT

DESCRIPTION:

650 is a one-component, hot melt sealant/adhesive formulated for foaming during application via a Nordson FoamMelt Unit. The volume of 650 can be doubled during the foaming/application process thus reducing the weight of the product by 50%. 650 is pressure sensitive giving excellent adhesion to metal, wood and glass while remaining permanently flexible. 650 also has outstanding UV resistance.

PROPERTIES:

Color and Appearance:	Tan / amber elastomeric solid.
Odor (ASTM D-1833):	None – will not contaminate sweet butter.
Percent Solids (ASTM C-771):	100%
Weight per Gallon (ASTM D-71):	7.3 ± 0.5 pounds/gallon
Flexibility:	No cracking, separation or loss of adhesion of a 3/8" diameter bead on galvanized steel when bent at -40°F over a 1/4" mandrel.
Viscosity @ 350°F:	30,000 – 45,000 cps
Needle Penetration (ASTM D-1321): @ 77°F, 200 g load	90 – 110
Staining and Corrosivity: ASTM D-925, Method A – 7-days @ 175°F	No staining, no significant change in sealant color or its non-skinning characteristics. Will not cause crazing of plastic. No pitting or corrosion of aluminum or galvanized steel after 7-days @ 158°F & 100% RH. Copper staining: No evidence of darkening, etching or salt deposits on the copper after 7-days @ 158°F.
Elongation and Webbing:	≥300% elongation @ 75°F w/o water leaks.
Weatherometer:	No apparent change of physical properties after 1000-hrs exposure. Slight darkening.

S-1 Sunlamp Exposure:	No apparent change after 1000-hours exposure.
Slump (ASTM D-2202):	0.1-inch
Shelf Life:	One year in a sealed carton at ambient temperatures.

For technical assistance, customer service and general information please contact us at:

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