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HOT MELT GUIDE V2.1

# BULK PACKAGING & ASSEMBLY

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Elemelt, an Ellsworth Adhesives brand, offers a range of both stick and bulk hot melt adhesives and specialty cleaning products in various formats to meet your product assembly and packaging needs. Available formulas include EVAs, acrylics, polyamides, metallocenes, and more. Elemelt purge cleaning compounds are safe, non-hazardous, and help flush and clean thermoplastics and PSAs from bulk reservoir tanks, or reactive PUR hot melts from equipment.

Ellsworth Adhesives is a global distributor specializing in the supply and logistics of specialty chemicals and equipment. We offer a wide range of hot melts, adhesives, sealants, lubricants, coatings, encapsulants, tapes, soldering products, surface preparation, maintenance materials, and more. Ellsworth Adhesives offers an extensive line of products to meet market demands but also offers customers complete solutions for their application needs by providing value added services and support.

**elemelt**<sup>®</sup>

# Packaging Materials

Item Number	Description	Color/ Chemistry	Running Temp (°F)	Open/Set Time	Viscosity	Softening/ Melting Point (°F)	Format
HM101KR2	Clean running.	Light Amber/ EVA	325 - 375	Short to Medium	1,000 cps @ 350 °F	228	Pellets
HM396	Workhorse product.	Amber/EVA	325 - 365	Medium	750 - 1,100 cps @ 350 °F	225	Pellets or Pillows
HM368	Standard low melt, high viscosity.	Amber/ EVA LM	225 - 280	Long	1,400 cps @ 250 °F	160	Pellets
HM657	Aggressive low melt, low viscosity.	Light Amber/ EVA LM	270 - 300	Short	370 cps @ 270 °F	212	Pellets
HM677	Very fast setting case and carton sealer. Bonds to a wide variety of substrates. Premium product.	Light Amber/ EVA	325 - 365	Short	1,700 cps @ 320 °F	239	Pellets
HM650	Economical packaging. Good for high heat resistance.	Amber/EVA	325 - 365	Medium	1,700 cps @ 320 °F	235	Pellets
HM302R2	Clean running, long open time, great adhesion.	Clear or Water White/EVA	325 - 375	Long	2,600 cps @ 350 °F	176	Pellets
HM165H	Good general purpose.	White/mPO	325 - 360	Medium	1,150 cps @ 350 °F	228	Pellets or Pillows
HM661	Premium performance. Good for high heat applications.	White/mPO	325 - 370	Long	2,000 cps @ 320 °F	230	Pellets
HM659	Workhorse, low consumption adhesive, with extremely low density. Odor and smoke free.	White or Clear/mPO	300 - 360	Medium	1,000 cps @ 350 °F	230	Pellets
HM591	Freezer grade, premium product with a broad service range.	White/mPO	320 - 360	Medium	1,000 cps @ 350 °F	232	Pellets or Pillows
PSA658	Bottle labeling.	Light Amber or Clear/PSA	275 - 350	Long	600 cps @ 320 °F	155	Chubs



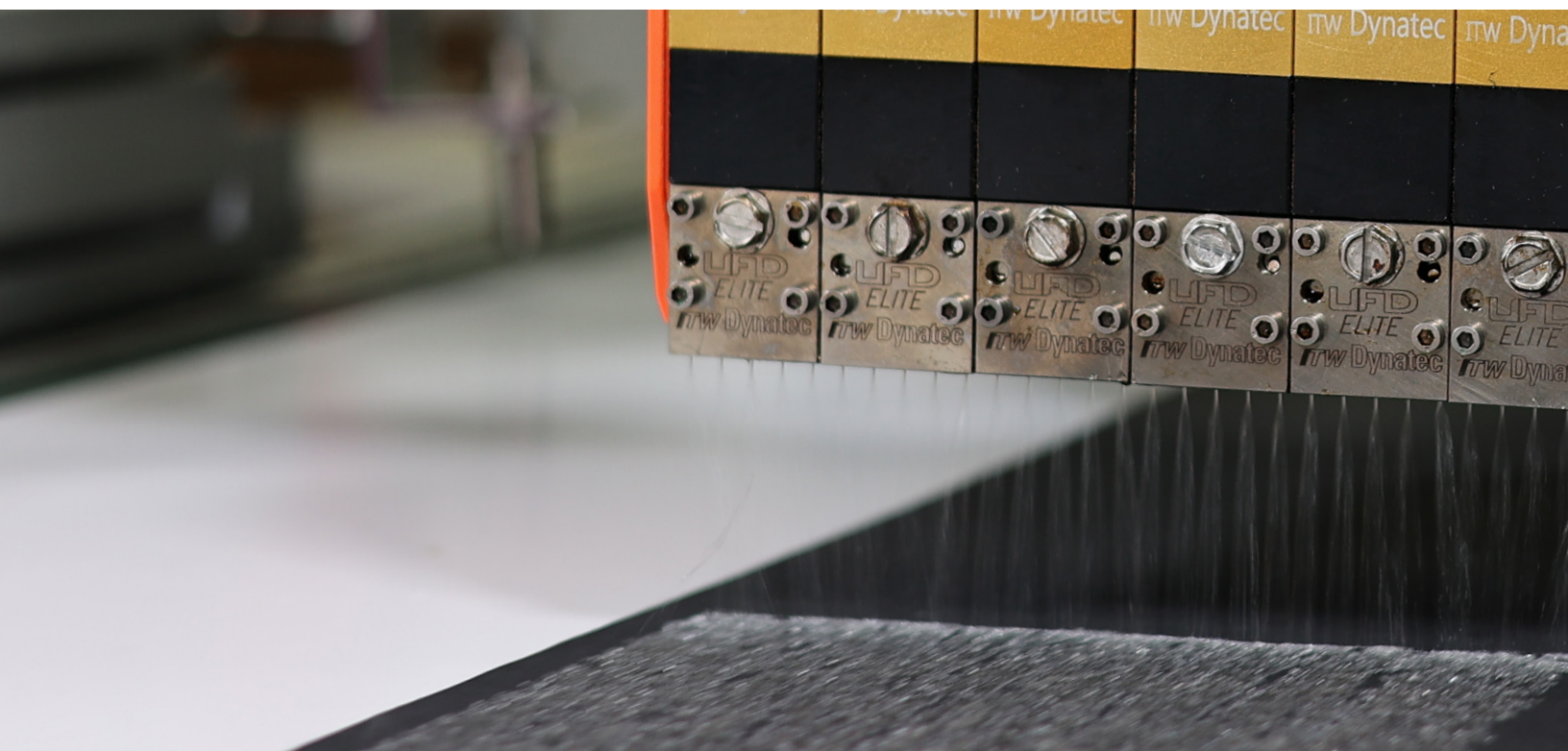
# Filter Materials

Item Number	Description	Color/Chemistry	Running Temp (°F)	Open/Set Time	Viscosity	Softening/Melting Point (°F)	Format
HM302R2	Clean running, long open time, great adhesion, NSF passable.	Clear or Water White/EVA	325 - 375	Long	2,600 cps @ 350 °F	176	Pellets
HM654	Filter pleating.	White/EVA	300 - 375	Short	6,500 cps @ 320 °F	233	Pellets
HM654FR	Filter pleating, fire retardant.	White/EVA	300 - 375	Short	6,500 cps @ 320 °F	230	Pellets
HM676	Foamable pleating product, flexible.	White/EVA	320 - 360	Medium	8,000 cps @ 320 °F	230	Pellets
PA378	Workhorse, general purpose.	Amber/Polyamide	335 - 400	Medium	4,000 cps @ 375 °F	283	Pellets
PA534	High temperature, end caps, oil filters.	Amber/Polyamide	350 - 425	Medium	8,000 cps @ 375 °F	340	Pellets
PA613	Excellent high/low temperature cycling.	Amber/Polyamide	340 - 415	Medium	8,000 cps @ 375 °F	291	Pellets
PO530	High temperature, low viscosity, good adhesion.	Clear/APAO	340 - 400	Long	6,500 cps @ 350 °F	285	Pillows or Drums
PO601	High temperature, high viscosity.	Amber/APAO	350 - 420	Medium	23,500 cps @ 375 °F	305	Pillows or Drums
PO123H	General purpose.	Amber/APAO	320 - 375	Medium	3,000 cps @ 350 °F	278	Pillows or Drums
PU595	Excellent resistance to low and high temperatures, and to moisture.	Clear or White/PUR	230 - 280	Long	13,000 cps @ 250 °F	N/A	Drums, Pails, or Cartridges



# Product Assembly Materials

Item Number	Description	Color/ Chemistry	Optimal Running Temp. (°F)	Open Time	Viscosity	Softening/ Melting Point (°F)	Format
HM302R2	Clean running, long open time, great adhesion, and NSF passable.	Clear or Water White/ EVA	325 - 375	Long	2,600 cps @ 350 °F	176	Pellets
PO123H	General purpose.	Amber/APAO	320 - 375	Medium	3,000 cps @ 350 °F	278	Pillows or Drums
PO530	High temperature, low viscosity, and good adhesion.	Clear/APAO	340 - 400	Long	6,500 cps @ 350 °F	285	Pillows or Drums
PSA110H	High temperature resistance, good creep resistance.	Amber/PSA	340 - 400	Long	12,000 cps @ 350 °F	240	Pillows or Drums
PA378	Workhorse, general purpose.	Amber/ Polyamide	335 - 400	Medium	4,000 cps @ 375 °F	283	Pellets
PA388	Long open time.	Amber/ Polyamide	340 - 400	Long	2,800 cps @ 375 °F	257	Pellets
PO601	High temperature, high viscosity.	Amber/APAO	350 - 420	Medium	23,500 cps @ 375 °F	305	Pillows or Drums
PU595	Excellent resistance to low and high temperatures, and to moisture.	Clear or White/ PUR	230 - 280	Long	13,000 cps @ 250 °F	N/A	Drums, Pails, or Cartridges





# Automotive Interior Materials

Item Number	Description	Color/Chemistry	Running Temp (°F)	Open/Set Time	Viscosity	Softening/Melting Point (°F)	Format
PU595	Excellent resistance to low and high temperatures, and moisture.	Clear or White/PUR	230 - 280	Long	13,000 cps @ 250 °F	N/A	Drums, Pails, or Cartridges
PU608	Very aggressive, high green strength.	Black/PUR	265 - 325	Medium	12,800 cps @ 300 °F	N/A	Drums
PO530	High temperature, low viscosity, good adhesion.	Clear/APAO	340 - 400	Long	6,500 cps @ 350 °F	285	Pillows or Drums
PO601	High temperature, high viscosity.	Amber/APAO	350 - 420	Medium	23,500 cps @ 375 °F	305	Pillows or Drums
PO123H	General purpose.	Amber/APAO	320 - 375	Medium	3,000 cps @ 350 °F	278	Pillows or Drums
PA378	Workhorse, general purpose.	Amber/Polyamide	335 - 400	Long	4,000 cps @ 375 °F	283	Pellets

# Insulated Panel Materials

Item Number	Description	Color/Chemistry	Running Temp (°F)	Open/Set Time	Viscosity	Softening/Melting Point (°F)	Format
PU595	Excellent resistance to low and high temperatures, and moisture.	Clear or White/PUR	230 - 280	Long	13,000 cps @ 250 °F	N/A	Drums, Pails, or Cartridges
PU608	Very aggressive, high green strength.	Black/PUR	265 - 325	Medium	12,800 cps @ 300 °F	N/A	Drums
PO530	High temperature, low viscosity, and good adhesion.	Clear/APAO	340 - 400	Long	6,500 cps @ 350 °F	285	Pillows or Drums
PSA110H	High temperature resistance.	Amber/PSA	340 - 400	Long	12,000 cps @ 350 °F	240	Pillows or Drums



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# PUR Purge Cleaners

Item Number	Description/Application	Color/Type	Optimal Running Temperature (°F)	Packaging	Format
PG3000	Flushing agent or purge. Used in bulk tanks and PUR equipment for flushing old product and debris. Designed for use with PURs.	Orange/ Polyester Plasticizer	200 - 230	5 gal Pails 55 gal Drums	Solid Pack
All-in-One	Chemical cleaning agent for PUR hot melts. Used for cleaning drum and pail unloaders, hoses, and nozzles.	Red/ Chemical Cleaner	30 mins @ 212 °F Dwell time on Platens  30 mins @ 212 °F Dwell time in hoses and nozzles	15 kg Pails 50 kg Drums	Gel
CL1000	Plasticizer cleaning agent used for roll coaters running reactive PUR hot melt.	White or Clear	180 - 280	55 lb Bags 300 lb Drums	Powder
PUR 3180	Cleaner used for drum unloaders.	Lemon Yellow/Wax	220 - 300	145 kg Drums	Solid Pack
PUR 785A	Plasticizer cleaning agent used for cleaning rolls on roll coaters.	White Wax/ Plasticizer	200 - 350	23 kg Bags 91 kg Drums	Solid Flakes
U7588	Purge cleaner for PURs and silicone hot melts.	Red/Wax	285 - 300	300 ml/10 oz Metal Cartridges	Solid Pack

# Thermoplastic Cleaning Compounds

Item Number	Description/ Application	Color/ Type	Optimal Running Temperature (°F)	Packaging	Format
R-1744	Liquid purge cleaner for bulk tanks. Used for PSAs, EVAs, and APAOs. Not designed for Polyamides or PURs.	Blue/Liquid	350	5 gal Pails	Liquid
P-2000	Flushing agent or purge. Used in bulk tanks and equipment for flushing old product and debris. Designed for use with EVAs, PSAs, and APAOs.	Green/ Wax	350 - 400	5 lb Jars 45 lb Boxes	Pellets
PG4000	Flushing agent or purge. Used in bulk tanks and equipment for flushing old product and debris. Designed for use with EVAs, PSAs, and APAOs.	Blue/EVA Blend	235 - 285	25 lb Boxes	Chips


















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# Bulk Melting Equipment

Bulk Melting Units	Description & Application	Hopper Capacity/Pail/ Drum Size	Operating Temperature Range	Viscosity Range	Melt Rate
 <p>Dynamini™</p>	Designed for flexibility. Used in various configurations depending upon application. For bead or spiral spray applications.	N05 - 5 kg (10 lbs) 10 - 9 kg (20 lbs)	40 - 218 °C (104 - 425 °F)	500 - 50,000 cps	N05/N10 17.3 lbs/hr
 <p>Simplicity™</p>	The unit has a modular design for simple installation, operation, and maintenance. Small internal reservoir and auto-feed system rivals other "tankless" systems.	4 kg (9 lbs), 8 kg (18 lbs) or 16 kg (35 lbs) Dual Piston Pump	10 - 232 °C (50 - 450 °F)	500 - 50,000 cps	25 lbs/hr
 <p>Dynamelt™ SR-Series</p>	Intuitive controls and modular design makes it simple to install, operate, and maintain. Consumes 20% less energy and less air than similar units.	SR05 - 5 kg (11lbs) SR10 - 10 kg (22 lbs) SR22 - 22 kg (48 lbs) SR45 - 45 kg (100 lbs)	38 - 232 °C (50 - 450 °F)	500 - 50,000 cps	SR05 (23 lbs/hr) SR10 (34 lbs/hr) SR22 (91 lbs/hr) SR45 (100 lbs/hr)
 <p>Dynamelt™ M-Series</p>	Units are PLC-based and provide accurate, proportionate temperature control for the hopper, hoses, and applicators. Available in 3 cabinet sizes and 4 hopper sizes.	M35 - 35 kg (75 lbs) M70 - 70 kg (155 lbs) M140 - 140 kg (310 lbs) M210 - 210 kg (460 lbs)	40 - 232 °C (100 - 450 °F)	500 - 50,000 cps	M35 (40 - 143 lbs/hr) M70 (59 - 209 lbs/hr) M140 (75 - 253 lbs/hr) M210 (99 - 319 lbs/hr)
 <p>DyNapail™ DM5</p>	Provides uninterrupted flow of hot melt adhesive. Standard features include field-interchangeable platen faces, self-diagnostics, multiple temperature control sensors, and low/empty pail indicators.	5 gal (19 L) steel pail US Standard  Pail I.D. 11.25 in (30 cm)	40 - 232 °C (100 - 450 °F)	500 - 50,000 cps	Up to 30 lbs/hr
 <p>DynaDrum™ DM55</p>	Provides uninterrupted flow of hot melt adhesive for high volume production demands. Standard features include field-interchangeable platen faces, touch screen PLC, self-diagnostics, multiple temperature control sensors, and low/empty drum indicators.	55 gal	40 - 232 °C (100 - 450 °F)	500 - 50,000 cps	Up to 600 lbs/hr

# Applicator Heads and Dispensers

Applicator Heads and Dispensers	Description & Application	Pneumatic Pressure Range to Solenoid	Operating Temperature Range	Viscosity Range	Adhesive Pressure Range/ Operating Pressure
 <p>UFD-HS (High Speed)</p>	Automatic adhesive applicator provides adhesive savings compared to traditional applicator heads. Module design positions valve seat directly behind nozzle for improved performance. Direct-connect solenoid gives faster valve response and faster cycle times for intermittent applications. 15 min. (cold start), 5 min. (module change).	4.1 to 5.5 bar (60 - 80 psi)	38 - 218 °C (100 - 425 °F)	100 - 30,000 cps	UFD 050/UFD 075/UFD 100/ UFD 150 68 bar (1,000 psi)
 <p>BF Microbead</p>	Available with single-port or dual-port pivoting modules, providing flexibility for set-up and reduction of the number of applicators required. Its smaller, more compact design simplifies installation and maintenance while rapid cycle speeds make it an ideal choice for high speed applications.	2.1 to 6.2 bar (30 - 90 psi)	38 - 218 °C (100 - 425 °F)	Single/Dual Port 100 - 5,000 cps	0 to 68 bar (0 to 1,000 psi)
 <p>Apex Slot Die</p>	Ideal for precise high speed intermittent adhesive patterns. Air-operated modules feature spring-assist close for precise cutoff. Die lip design prevents buildup of unwanted materials.	5 to 9 bar (74 - 125 psi)	38 - 200 °C (100 to 390 °F)	100 - 20,000 cps	7 to 68 bar (100 to 1,000 psi)
 <p>Marathon BF</p>	Allows for fast and easy nozzle change. Optional stroke adjustment allows for fine-tuning of optimum adhesive cutoff at the nozzle tip with an integrated filter cartridge which prevents particulate matter from obstructing flow through the head. Standard air open/close module provides positive shut-off and on-cycle.	5 to 9.7 bar (74 - 140 psi)	38 - 218 °C (100 - 425 °F)	0 - 20,000 cps	41 to 68 bar (600 to 1,000 psi)
 <p>DGII™ Hand Applicator</p>	Designed for durability and flexibility. Adhesive output may be oriented for straight or right angle application with a variety of available bead and spiral spray nozzles. The DG II™ applicator can be set up for bottom-entry or top-entry hose connection.	.48 - .96 MPa (70 - 140 psi) (for swirl application only)	38 - 232 °C (100 - 450 °F)	0 - 80,000 cps	70 bar (1,000 psi)
 <p>DynaFlex™ Hose</p>	Electrically heated, flexible conduits designed for the transfer of hot melt material from an adhesive supply unit (ASU) to an applicator (head or handgun). Extruded TFE (inner core)/ type 304 stainless steel wire braid (outer core). Length: 1.2 - 18 m (4 - 60 ft).	20 - 141 bar (295 - 2,046 psi) @ 218 °C (425°F)	218 °C (425 °F) continuous	Dependent on Valve or Gun	70 bar (1,000 psi) @ 425 °F (218 °C)
 <p>Gemini Hose</p>	Incorporates a backup heater and temperature sensor. Alerts the operator if heater or sensor failure occurs. A built-in switch turns on backup circuitry, allowing time for a new hose to be replaced at the next scheduled production downtime. Extruded TFE (inner core)/type 304 stainless steel wire braid (outer core). Length: 1.2 - 18 m (4 - 60 ft).	20 - 141 bar (295 - 2046 psi) @ 218 °C (425 °F)	218 °C (425 °F) continuous	Dependent on Valve or Gun	70 bar (1,000 psi) @ 425 °F (218 °C)



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To place an order or for more information, please contact an Ellsworth Adhesives representative at 1(800) 888-0698 or email [info@ellsworth.com](mailto:info@ellsworth.com).

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