



Hot Melt Adhesives

Solvent and Water-Free Foam Bonding Mattress Adhesive

Worthen Industries hot melt adhesives (HMAs) are custom formulations to address the needs of the furniture and mattress assembly industries. Provides a solvent and water-free option for mattress assembly and furniture foam fabricating operations.



Fast Drying

100% solids means no drying time required.

Work Friendly

Our workhorse product 9045-0 was developed for long open time to give assembly workers time to position substrates in place.

Versatile Application Options

Bead patterns: 9045-0 may be applied as multiple extruded beads on automatic spray lines. This has the advantage of extending open time allowing operators more time to position substrate.

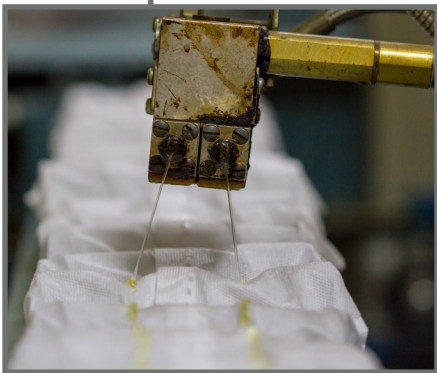
Spiral patterns: 9045-0 can be used with handheld units that usually spray a spiral pattern that will cover a larger area.

Stability on Equipment

Thermally stable at 375°F for at least 48 hours. Recommend maintaining temperature at less than 300°F when not in use for long periods.

Excellent Bonding

Provides foam to foam and foam to non-woven bonding in furniture and mattress assembly and foam to polyester fiber bonding for cushion assembly.



Provides a solvent and water-free option for mattress assembly and furniture foam fabricating operations



Physical Properties

Solids	100%
Viscosity Curve #27 @ 20 rpm	275°F /135°C = 12,000 cP 300°F /149°C = 6,400 cP 325°F /163°C = 4,200 cP 350°F /177°C = 2,600 cP 375°F /191°C = 2,000 cP
Tack Range	The open time range of 9045-0 allows time for operators to position the substrate in place
Dry Time	HMA's are 100% solids and do not require drying
Shelf Life	At least one (1) year

Instructions



1. Application Procedure

Bead patterns: applied as multiple extruded beads on automatic spray lines. This has the advantage of extending open time allowing operators more time to position substrate.

Spiral patterns: used with handheld units that spray a spiral pattern to cover a larger area.

Recommended application temperature 350°F - 375°F.

2. Compression Force

0.25 psi for a minimum of 5 seconds (Repeat if necessary) Compression requirements vary depending on substrates being bonded.

3. Downtime Procedure

Adhesive is thermally stable but it is recommended that the heat is turned off during long shutdowns. For downtime of 1-2 hours reduce heat to less than 300°F.

ISO 9001: 2015 & ISO 14001: 2015 Certified



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