



# Supergrip® 1578-164

## ONE COMPONENT MOISTURE CURING URETHANE ADHESIVE

### KEY FEATURES

- Excellent green strength and quick tack
- Excellent creep resistance
- Long open time

### DESCRIPTION

SG1578-164 is a solvent-free, one-component, moisture curing hot melt urethane adhesive. This product is supplied in a solid form and is applied like that of a bulk hot melt adhesive. Once dispensed, the adhesive will react with ambient moisture to yield a cross-linked thermoset adhesive. Heat is not required for cure to occur.

SG1578-164 is staple product that offers properties well-suited for assembly applications in a variety of markets. This product provides high initial tack, rapid development of strength upon application from the molten state, and excellent creep resistance prior to curing. SG1578-164 exhibits good adhesion to a variety of substrates, including flexible vinyl, wood, ABS, fiberboard, HPL, steel, polyurethane foam, and most plastics.

### KEY BENEFITS

- Quick processing of assembly fixtures
- Easy repositioning and handling
- Bonds well to a wide variety of substrates

### SHELF LIFE

The shelf life of SG1578-164 is twelve months at 23°C (73°F) in unopened factory sealed containers. Due to product moisture sensitivity, shipping containers must be kept tightly sealed and opened just prior to product use.



### TYPICAL PHYSICAL PROPERTIES

Description	Results
Color	Off-White
Solids	100%
Thermosel Viscosity	15,000 cP (120°C)
Density	9.6 lb/gallon (1.15 g/cm <sup>3</sup> )
Green Strength (3 min., ambient conditions)	60 psi (410 kN/m <sup>2</sup> )
Open Time	5 – 9 min. for a 10 mil film at ambient conditions
Application Temperature	110°C – 120°C

### TYPICAL PROPERTIES OF CURED FILM

Description	Result
Cure Conditions	7 days @ 25°C, 50% RH
Tensile at Break	1,050 psi (7,240 kN/m <sup>2</sup> )
Elongation at Break	830 %
Water / Chemical Resistance	Excellent
Heat Resistance	379°F (193°C)

## APPLICATION TECHNIQUES

The typical application temperature range for SG1578-164 is 110°C – 120°C (230°F – 248°F). Refer to the product SDS prior to use at temperatures greater than 120°C (248°F). Adhesive application is best conducted using direct pail or drum melting systems. These systems may be equipped for adhesive application via bead extrusion, swirl spray, or roll coating methods.

Adhesive cure rate is dependent upon substrate type and moisture permeability, relative humidity, and temperature. The optimal curing conditions are 50% relative humidity and 21°C (70°F). SG1578-164 will develop adhesive properties within 24 hours. Under optimal conditions, the adhesive will achieve final properties after seven days.

## CLEANUP PROCEDURE

Since SG1578-164 is applied at elevated temperatures, it is advisable to clean the equipment regularly with an appropriate cleaning agent such as Supergrip® PURGE

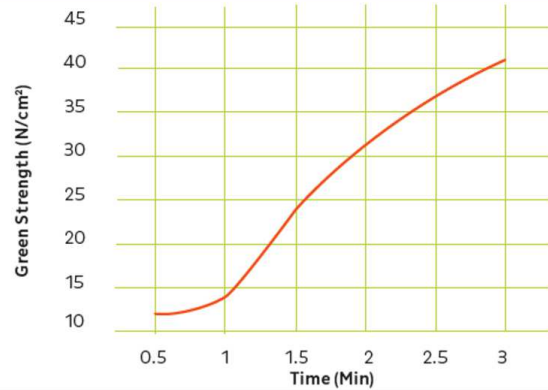
## BASIC USES

SG1578-164 can be used in a variety of general product assembly applications. Additional uses include rigid panel bonding and laminating, seating applications, and door panel laminating.

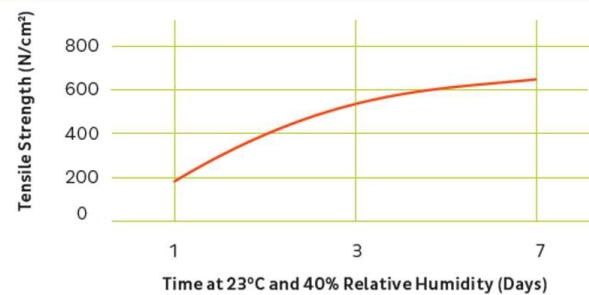
## HEALTH & SAFETY PRECAUTIONS

SG1578-164 contains di-isocyanate, it is preferable to avoid contact with the skin and with food products. This precaution only applies to non-cured adhesive in its delivered state. Refer to the product Safety Data Sheet (SDS) prior to use for complete cautionary information.

## GREEN STRENGTH DEVELOPMENT PROFILE



## TENSILE STRENGTH DEVELOPMENT PROFILE



## LIMITED WARRANTY

The Limited Warranty for this product can be found at [www.bostik-us.com/resource-center/warranties](http://www.bostik-us.com/resource-center/warranties) or by calling 1-800-726-7845 (choose option 2, then option 2 again). To the maximum extent allowed by law, Bostik disclaims all other express or implied warranties, including without limitation warranties of merchantability and fitness for a particular purpose. Unless otherwise stated in the limited warranty, the sole remedy for breach of warranty is replacement of the product or refund of the buyer's purchase price. Bostik disclaims any liability for direct, incidental, consequential, or special damages to the maximum extent allowed by law. Disclaimers of implied warranties may not be applicable to certain classes of buyers and some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitations may not apply to you. It is the buyer's obligation to test the suitability of the product for an intended use prior to using it. The Limited Warranty extends only to the original purchaser and is not transferable or assignable. Any claim for a defective product must be filed within 30 days of discovery of a problem, and must be submitted with written proof of purchase.

## BOSTIK HOTLINE

Smart help  
**1-800-726-7845**

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