Clean Melt® Adhesive Technology

Features
- Meta-1 Technology: Formulated to provide the right technology for maximum cost/benefit ratio.
- Gentle on Equipment: Reduced equipment maintenance cost and output.
- Odor-Free and Light Color: Enhance package appearance and user-friendly working environment.
- Reduced equipment maintenance and parts spend.
- Gentle on Equipment: Reduced equipment maintenance cost and output.

Benefits
- Excellent adhesion for freezer grade storage.
- Versatile for most applications including high spring back flaps.
- High temperature performance range.
- Wide variety of packages.
- Good for high temperature satchets.

PHC 8250
- 1820 Fast Short 325°F - 360°F
- 1 625 Fast Medium 325°F - 360°F
- 2 985 Fast Short 325°F - 360°F
- 2 1920 Fast Short 325°F - 360°F

PHC 7600
- 7602 High Temp 340°F - 375°F
- 1 625 Fast Medium 325°F - 360°F
- 2 985 Fast Short 325°F - 360°F

PHC 7602
- 7600 High Temp 340°F - 375°F
- 1 625 Fast Medium 325°F - 360°F
- 2 985 Fast Short 325°F - 360°F

PHC 9600
- 7602 High Temp 340°F - 375°F
- 1 625 Fast Medium 325°F - 360°F
- 2 985 Fast Short 325°F - 360°F

Q1 2013

Visit us online at: www.hbf.com 888-HBFULLER

Protect your brand with H.B. Fuller adhesive

Packaging lines are running faster and more efficiently than ever before. H.B. Fuller has responded with leading edge, trouble-free adhesive technologies that form and seal cases, cartons, and trays with better bonding using less adhesive. Our product line has the breadth and depth to handle nearly every conceivable substrate, machine, and line speed.

We continue to lead the industry with our advantra® technology and Clean Melt® family of high-performance, value-added packaging hot melts based on proprietary technology. Recently, we added Liquamelt® – an adhesive/equipment combination that combines the ease of liquid glue applications with the speed and performance of a hot melt that uses 40% renewable raw materials.

Protect your brand by using H.B. Fuller’s robust line of packaging adhesives that can improve the quality, safety and efficiency of your packaging operation, and provides the best overall value.

Do you know your Total Cost of Ownership? We can help you.

In addition to high performance adhesives and dispensing equipment, our comprehensive value-added services and expertise help ensure high productivity and low total overall costs.

H.B. Fuller’s Service includes:
- Recording & Tracking of Savings Delivered
- Rigorous Process Audit & Optimization
- Best Practices Benchmarking
- Industry Leading Training Programs
- Supply Chain & Sustainability Assessments

Are you running the right technology?

Who knows more about packaging hot melt adhesives than the company that invented and patented the metallocene technology? H.B. Fuller’s diverse portfolio of advantra® metallocene based adhesives, Clean Melt® adhesives and general purpose EVA hot melts provide your company with a complete set of adhesive choices for your packaging needs.

H.B. Fuller’s experienced technical teams can help optimize your operations by helping you choose the best adhesive for your business.

We invite you to our world headquarters to see our state-of-the-art Packaging Center of Excellence. Which allows you to see first hand our adhesives perform on various substrates.

We invite you to our world headquarters to see our state-of-the-art Packaging Center of Excellence. Which allows you to see first hand our adhesives perform on various substrates.

Contact H.B. Fuller today to learn more about our End of Line Packaging at Inquiry@hbfuller.com or 888-HBFULLER.

IMPORTANT: The user is responsible to use and distribute the information of products to be suitable for the various applications, and the user must make their own determination with respect to the user’s own specific circumstances and needs. The information in this sheet is typical and is intended only for application and market development purposes. No warranty is made as to the accuracy or completeness of the information contained herein.
Clean Melt® High Performance Packaging Adhesives

Clean Melt® High performance packaging hot melt adhesives deliver an optimum balance of sealing performance and cost effectiveness for typical applications. The reliable performance and patented formulations provide a well-balanced cost/benefit ratio. Versatile Clean Melt® adhesives combine high mileage, low maintenance, and power productivity with robust adhesion to create exceptional value.

Clean Melt® formulations provide a well balanced cost/benefit ratio. Versatile Clean Melt®® adhesives combine high performance and cost effectiveness for typical applications. The reliable performance and patented Clean Melt® technology allows for consistent hassle-free production.

Clean Melt®® Hot Melt Adhesives

Char-Free Technology
Virtually eliminates plugged nozzles due to adhesives for consistent hassle-free production.

Performs without stringing.
Enhanced package appearance and user-friendly working environment.

Odor-Free and Light Color
Gentle on Equipment
Reduced equipment maintenance and parts spend.

Product Description/Application

**Clean Melt® PHC 8250**
- Fast Short
- 325°F - 360°F
- Excellent adhesion for freezer grade applications. Good for high spring back flaps.
- 1 820 Fast Medium 325°F - 360°F
- Higher viscosity for greater green strength or aggressive hold.

**Clean Melt® 89100**
- Fast Medium
- 325°F - 360°F
- Wide temperature performance range. This is avalue-formulated metallocene polymer designed for packaging. Excellent performance in high speed packaging environments.
- 89 Fast Short 325°F - 360°F
- Excellent adhesion. Suitable for freezer grade applications.
- 2 985 Fast Short 325°F - 360°F
- Higher viscosity for greater green strength or aggressive hold.

**Clean Melt® 7600**
- Standard adhesive for freezer grade applications.
- 7602
- Excellent adhesion. Suitable for freezer grade applications.
- 1 820 Fast Medium 325°F - 360°F
- Higher viscosity for greater green strength or aggressive hold.
- 820 Fast Medium 325°F - 360°F
- Excellent adhesion. Suitable for freezer grade applications.
- 2 985 Fast Short 325°F - 360°F
- Higher viscosity for greater green strength or aggressive hold.

Features

- Char-Free Technology: Virtually eliminates plugged nozzles due to adhesives for consistent hassle-free production.
- Gentle on Equipment: Reduces equipment maintenance cost and parts spend.
- Odor-Free and Light Color: Gentle on equipment.
- Clean Cutoff & Precise Application: Enhanced package appearance and user friendly working environment.

Benefits

- High performance packaging hot melt adhesives deliver an optimum balance of sealing performance and cost effectiveness for typical applications.
- The reliable performance and patented formulations provide a well-balanced cost/benefit ratio.
- Versatile Clean Melt® adhesives combine high mileage, low maintenance, and power productivity with robust adhesion to create exceptional value.

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---

**Our Focus is Clear. Perfecting Adhesives.**

Contact H.B. Fuller today to learn more about our End of Line Packaging at Inquiry@hbfuller.com or 1-888-HBFULLER.

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- **Best Practices Benchmarking**
- **Industry Leading Training Programs**
- **Supply Chain & Sustainability Assessments**

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Important: It is the user’s responsibility to test and determine the suitability of a product for the user’s intended use. Any product samples provided for testing are provided in accordance with standard limited warranties as stated on our technical data sheets. Any product samples or product evaluations do not limit the user’s obligation to test and determine the suitability of a product or any product evaluations for the user’s intended use.

H.B. Fuller Company
1200 Willow Lake Blvd.
St. Paul, MN 55110

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1-888-HBFULLER

inquiry@hbfuller.com
advantra® Hot Melt Adhesives

Ultimate performance in packaging adhesives

advantra® premium metallocene adhesive family is the world’s leading packaging adhesive brand for applications such as case and carton sealing, straw attachment, silk-proof bag-in-box and ream wrap. Since the introduction of the revolutionary patented advantra® brand of metallocene adhesives, more than 100 million cases and cartons have been successfully sealed worldwide.

Our new advantra Encore™ technology provides greater mileage improvements over typical metallocene products with a superior bond across a large temperature range. This next generation of H.B. Fuller’s proprietary packaging adhesives is the next generation of H.B. Fuller’s packaging proprietary adhesives.

New Lower Application Temperature (LAT) Hot Melt Adhesives

Our new generation, low-application temperature products offer the safety and reduced maintenance that you would expect, but with robust bond performance at both ends of the temperature spectrum.

<table>
<thead>
<tr>
<th>Product</th>
<th>Description/Application</th>
<th>Molten Viscosity @ 200°F (cps)</th>
<th>Open Time</th>
<th>Speed</th>
<th>Application Temperature</th>
</tr>
</thead>
<tbody>
<tr>
<td>PHC 9300</td>
<td>Versatile adhesive and very good heat resistance. For applications involving high temperatures, when adhesives, high performance, and significant savings are obtained.</td>
<td>1,230 Medium/ Fast</td>
<td>Medium/ Medium</td>
<td>20°F - 200°F</td>
<td></td>
</tr>
<tr>
<td>PHC 9225</td>
<td>For high demanding hot-melt applications.</td>
<td>800 Medium/ Fast</td>
<td>Medium/ Medium</td>
<td>20°F - 200°F</td>
<td></td>
</tr>
<tr>
<td>PHC 9020</td>
<td>Self-adhesive and high performance.</td>
<td>600 Medium/ Fast</td>
<td>Medium/ Medium</td>
<td>20°F - 200°F</td>
<td></td>
</tr>
<tr>
<td>PHC 9015</td>
<td>For all high demanding hot-melt applications.</td>
<td>600 Slow/ Long</td>
<td>Medium/ Medium</td>
<td>20°F - 200°F</td>
<td></td>
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</tbody>
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<tr>
<td>PHC 9275</td>
<td>Self-adhesive and high performance.</td>
<td>1,600 Medium/ Fast</td>
<td>Medium/ Medium</td>
<td>20°F - 200°F</td>
<td></td>
</tr>
<tr>
<td>PHC 2840</td>
<td>For all high demanding hot-melt applications.</td>
<td>800 Medium/ Fast</td>
<td>Medium/ Medium</td>
<td>20°F - 200°F</td>
<td></td>
</tr>
<tr>
<td>PHC 9200</td>
<td>Self-adhesive and high performance.</td>
<td>1,245 Medium/ Fast</td>
<td>Medium/ Medium</td>
<td>20°F - 200°F</td>
<td></td>
</tr>
<tr>
<td>PHC 7030</td>
<td>Very high adhesion.</td>
<td>1,150 Medium/ Fast</td>
<td>Medium/ Medium</td>
<td>20°F - 200°F</td>
<td></td>
</tr>
<tr>
<td>PHC 7020</td>
<td>General purpose and refrigeration grade.</td>
<td>600 Medium/ Fast</td>
<td>Medium/ Medium</td>
<td>20°F - 200°F</td>
<td></td>
</tr>
<tr>
<td>PHC 7015</td>
<td>General purpose.</td>
<td>1,210 Medium/ Fast</td>
<td>Medium/ Medium</td>
<td>20°F - 200°F</td>
<td></td>
</tr>
<tr>
<td>PHC 2835</td>
<td>For all high demanding hot-melt applications.</td>
<td>750 Slow/ Long</td>
<td>Medium/ Medium</td>
<td>20°F - 200°F</td>
<td></td>
</tr>
</tbody>
</table>

General Purpose EVA

These general purpose EVA are targeted to the poultry industry. They are designed for easy application, high performance, and worker safety are desired.

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<th>Description/Application</th>
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<th>Application Temperature</th>
</tr>
</thead>
<tbody>
<tr>
<td>PHC 9260</td>
<td>Self-adhesive and very good heat resistance.</td>
<td>1,200 Medium/ Fast</td>
<td>Medium/ Medium</td>
<td>20°F - 200°F</td>
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</tbody>
</table>

Value Performance for Bonding

Whether your packaging application needs to endure desert heat or a -40 below zero blast freezer, we have the adhesive to keep it together. Difficult-to-bond boxes, over-stuffed or under-filled, when it feels like a challenge, our problem-solving specialty adhesives can help.

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<tbody>
<tr>
<td>PHC 3000</td>
<td>Versatile adhesive and high heat performance.</td>
<td>1,600 Medium/ Fast</td>
<td>Medium/ Medium</td>
<td>20°F - 200°F</td>
<td></td>
</tr>
</tbody>
</table>

Swift therm®

Swift therm® offers premium value and performance at every stage of the production process, from easy application, high performance, and worker safety are desired.

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<th>Product</th>
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End of Line Packaging

Product Description/Application Molten Viscosity @ 200°F (cps) Open Time Speed Application Temperature
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advantra® Hot Melt Adhesives

Ultimate performance in packaging adhesives

advantra® premium metallocene hot melts are the world’s leading packaging adhesive brand for applications such as case and carton sealing, straw attachment, self-proof bag-in-box and ream-seam. Since the introduction of the revolutionary patented advantra® brand of metallocene adhesives, more than 100 billion cases and cartons have been successfully sealed worldwide.

Our new advantra Encore™ technology provides greater mileage improvements over typical metallocene products with a superior bond across a large temperature range. This new platform of adhesives is the next generation of H.B. Fuller’s proprietary packaging adhesives.

---

**General Purpose EVA**

These general purpose EVA products, formulated for our experienced sourcing, R&D and technical teams, are manufactured in our worldwide class facilities.

---

**Specialty Performance**

Available for those who want the ultimate in worker safety.

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**Product Description/Application**

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<td>PHC 7003</td>
<td>Clean Melt</td>
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<td>PHC 7031</td>
<td>Clean Melt</td>
<td>800 Medium</td>
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<tr>
<td>PHC 7021</td>
<td>Clean Melt</td>
<td>1,000 Fast Short</td>
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<tr>
<td>PHC 2840</td>
<td>Smart Grip</td>
<td>1,127 Medium</td>
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<tr>
<td>PHC 3000</td>
<td>Smart Grip</td>
<td>3,100 Slow Long</td>
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**EVA Hot Melts for Wax Coated Boards**

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<tbody>
<tr>
<td>PHC 7001</td>
<td>Excellent adhesion to high value coated stock and easy packaging. 4 1,567 Fast Fast</td>
<td>350°F</td>
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<tr>
<td>PHC 7101</td>
<td>Excellent adhesion over a wide range of wax coated stock.</td>
<td>4 1,070 Fast</td>
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**EVA Hot Melts for Agricultural Case Packaging**

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<tr>
<td>PHC 7002</td>
<td>Excellent adhesion to wax coated boards.</td>
<td>8 1,150 Fast Short</td>
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<td>PHC 7005</td>
<td>Excellent adhesion to wax coated boards.</td>
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<td>Excellent adhesion to card stock.</td>
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Our new advantra Encore™ technology provides greater mileage improvements over typical metallocene products with a superior bond across a large temperature range. This new platform of adhesives is the next generation of H.B. Fuller’s proprietary packaging adhesives.

Low Application Temperature (LAT) Hot Melt Adhesives

Our next generation, low-application temperature products offer the safety and reduced maintenance that you would expect, but with robust bond performance at both ends of the temperature spectrum.

Product Description/Application Molten Temperature Viscosity @ 350°F (cps) Set Open Time Application Temperature

**advantra® PHC 9200**

- Variable bond with reduced tack and increased tack in difficult substrates.
- Ideal for high-volume applications where low application temperature, high performance, and easy application are required.

**advantra® PHC 7000**

- Excellent adhesion and very good bond formation.
- Ideal for high-volume applications where easy application, high performance, and good bond resistance are required.

**advantra® PHC 7050**

- Packaging grade with long open time.
- Excellent adhesion for demanding applications.

**advantra® PHC 7060**

- Excellent performance for demanding applications.
- Variable bond with reduced tack and increased tack in difficult substrates.

**Advantages**

- Versatile general purpose.
- Excellent bond strength across a large temperature range.
- Good for wax coated boards in beef and poultry industries.

**Specialty Performance**

Whether your packaging application needs to endure desert heat or a 40 below zero blast freezer, we have the adhesive to keep it together. Difficult-to-bond boxes, over-stuffed or under-filled, when it feels like a challenge, our problem solving specialty adhesives can help.

**Product Description/Application Molten Temperature Viscosity @ 350°F (cps) Set Open Time Application Temperature**

**Swift therm® HM 2835Y**

- Very aggressive bonding to difficult substrates.
- Unique temporary bundling adhesive.

**LiquaMelt® HM 0204**

- High tack and high heat resistance.
- Excellent adhesion with light color.

**Missouri Specialty Performance**

- **Butcher Paper Coatings**
  - High heat resistance of hot tack.
  - Ideal for wax coated board in the beef and poultry industries.

**General Purpose EVA**

These traditional formulas, supported by our experienced sourcing, R&D and technical teams, are manufactured in our world class facilities.

**Product Description/Application Molten Temperature Viscosity @ 350°F (cps) Set Open Time Application Temperature**

**advantra® PHC 9200**

- Variable bond with reduced tack and increased tack in difficult substrates.
- Ideal for high-volume applications where low application temperature, high performance, and easy application are required.

**advantra® PHC 7000**

- Excellent adhesion and very good bond formation.
- Ideal for high-volume applications where easy application, high performance, and good bond resistance are required.

**advantra® PHC 7050**

- Packaging grade with long open time.
- Excellent adhesion for demanding applications.

**advantra® PHC 7060**

- Excellent performance for demanding applications.
- Variable bond with reduced tack and increased tack in difficult substrates.
Clean Melt® Hot Melt Adhesives

High performance packaging adhesives

Clean Melt® metallocene packaging hot melt adhesives deliver an optimal balance of sealing performance and cost effectiveness for typical applications. The reliable performance and patented formulations provide a well balanced cost/benefit ratio. Versatile Clean Melt® adhesives combine high mileage, long maintenance, and power productivity with robust adhesion to create exceptional value.


dollars in

Product Description/Application Molten Gardner Color Viscosity at $350°F (cps) Set Speed Open Time Application Temperature

Clean Melt® 89100 Higher viscosity for greater green strength or high spring back flaps. 2 2,285 Fast Short $340°F - $375°F

Clean Melt® 7600 Versatile for most applications including a wide variety of packages. Good for ambient and freezer grade storage. 1 820 Fast Short $325°F - $360°F

Clean Melt® 7602 Excellent adhesion for freezer grade applications. 1 820 Fast Medium $325°F - $360°F

Clean Melt® PHC 8250 Wide temperature performance range. This is a value formulated metallocene polymer based hot melt designed for packaging stored at -40°F to 140°F. 2 565 Fast Short $325°F - $360°F

Do you know your Total Cost of Ownership? We can help you.

In addition to high performance adhesives and dispensing equipment, our comprehensive value-added services and expertise help ensure high productivity and low total overall costs.

H.B. Fuller’s service includes:
• Reporting & Tracking of Savings Collected
• Rigorous Process Audit & Optimization
• Best Practices Benchmarking
• Industry Leading Training Programs
• Supply Chain & Sustainability Assessments

Are you running the right technology?

Who knows more about packaging hot melt adhesives than the company that invented and patented the metallocene technology? H.B. Fuller’s diverse portfolio of advantra® metallocene based adhesives; Clean Melt® adhesives and general purpose EVA hot melts provide your company with a complete set of adhesive choices for your packaging needs.

H.B. Fuller’s experienced technical teams can help optimize your operations by helping you choose the best adhesive for your business.

We invite you to our world headquarters to see our state-of-the-art Packaging Center of Excellence which allows you to see first hand our adhesives perform on various substrates using the latest equipment in the market place. Contact your local sales professional for more information.

Protect your brand with H.B. Fuller adhesive

Packaging lines are running faster and more efficiently than ever before. H.B. Fuller has responded with leading edge, trouble-free adhesive technologies that form and seal cases, cartons, and trays with better bonding using less adhesive. Our product line has the breadth and depth to handle nearly every conceivable substrate, machine, and line speed.

We continue to lead the industry with our advantra® technology and Clean Melt® family of high-performance, value-added packaging hot melts based on proprietary technology. Recently, we added Liquamelt® – an adhesive/equipment combination that combines the ease of liquid glue applications with the speed and performance of a hot melt that uses 40% renewable raw materials.

Protect your brand by using H.B. Fuller’s robust line of packaging adhesives that can improve the quality, safety and efficiency of your packaging operation, and provides the best overall value.