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TECHNOMELT

Technical Data Sheet

TECHNOMELT PA 6208 N

January 2018

PRODUCT DESCRIPTION

TECHNOMELT PA 6208 N provides the following product characteristics:

Technology	Polyamide
Product Type	Hotmelt
Cure	Physical setting
Condition	thermoplastic
Components	One-component
Application	General assembly
Color	Amber

Application Areas:

TECHNOMELT PA 6208 N is used for molding, filter and other general assembly applications.

This product has good adhesion to a variety of substrates including fabrics, leather, metals, wood, ABS and flexible vinyl.

TECHNICAL DATA

Density, g/cm³ ISO 1183-1, 20°C	0.98
Softening point, °C ASTM E28 (in glycerine)	150 to 160
Melting Viscosity at 190 °C, mPas	6,500
Melting Viscosity at 200 °C, mPas	4,800
Melting Viscosity at 210 °C, mPas	2,800 to 4,000
Melting Viscosity at 220 °C, mPas ASTM D 3236 (RVT, spindle 27)	2,700
Temperature creep resistance, °C Henkel method MH 11	130
Yield Strength, N/mm² ISO 527, Specimen no.5 Cross-head-speed: 50mm/min	3.3
Break Strength, N/mm² ISO 527, Specimen no.5 Cross-head-speed: 50mm/min	3.6
Elongation, % ISO 527, Specimen no.5 Cross-head-speed: 50mm/min	600
Shore A hardness ISO 868/15s	82
Low temperature flexibility, °C ASTM D 3111	-40
Working Temperature, °C Depends on the application, without mechanical stress	-40 to 100

DIRECTIONS FOR USE

Preliminary Statement:

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Preparation:

The surfaces of the substrate must be dry and free from oil, grease and dust.

Application:

Application Temperature : 180 to 230 °C.
Application System : Hotmelt application systems
When bonding to a substrate with high thermal conductivity the use of a specific application temperature is required for good wetting.
Do not heat the product above the specified application temperature range.
When the product is not in use do not apply heat, this will degrade the quality of the product and in extreme cases cause carbonisation. The standby temperature for the product is 90°C, but not for longer than 72h.
TECHNOMELT PA 6208 N may absorb moisture from the air. This will not be apparent in the solid form, but may cause bubbles on heating and could affect the bond quality. It is important, therefore, that containers are kept closed and sealed when not in use.
Immediately after joining, keep the parts pressed together until the bonded join is held by the adhesive itself. The time which this requires is largely dependent on the recovery of the material to be bonded. If the join is parted even by some tenths of millimeters during the binding stage, a ridge is formed which leads to reduced load capacity of the join.

Cleaning:

Carbonised and set (non thermoplastic) material must be removed mechanically. Removal of the thermoplastic material from the hot apparatus can be achieved with solvent free cleaning system, such as TECHNOMELT PA 62 (see separate technical information).

Storage:

When properly stored in a cool, dry location, with the container tightly closed when not in use, this product will have a shelf life of at least 24 months.

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Classification:
Please refer to the corresponding **Material Safety Data Sheets** for details on:
Hazards identification
Transport information
Regulatory information

ADDITIONAL INFORMATION

Disclaimer

Note:
The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.
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