

TECHNOMELT® PA 2035

Known as Macromelt 2035
February 2024

Product description

TECHNOMELT® PA 2035 provides the following product characteristics:

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|---------------------|------------------|
| Technology | Polyamide |
| Product type | Hotmelt |
| Cure | Physical setting |
| Condition | Thermoplastic |
| Components | One-component |
| Application | Filter |
| Color | Amber |

Application areas:

TECHNOMELT® PA 2035 is used in many areas of the automotive filter industry. The adhesive is used mainly for fixing of pleats and sealing of pleats in automotive air and oil filters.

Technical data

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|-----------------------------------|----------------|
| Softening point, °C | 195 to 205 |
| ASTM E28 (in glycerine) | |
| Melting viscosity at 220°C, mPas | 3,500 to 6,500 |
| ASTM D 3236 (RVT, spindle 27) | |
| Yield strength, N/mm ² | 500 |
| ISO 527, Specimen no.5 | |
| Cross-head-speed: 50mm/min | |
| Break strength, N/mm ² | 10 |
| ISO 527, Specimen no.5 | |
| Cross-head-speed: 50mm/min | |
| Elongation, % | 13 |
| ISO 527, Specimen no.5 | |
| Cross-head-speed: 50mm/min | |
| E-modulus 2%, N/mm ² | 150 |
| ASTM D 638 | |

Direction 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 : 210 to 240 °C
Application system : Hotmelt application systems
Application system : Hotmelt extruder system

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 130°C, but not longer than 72 hours. TECHNOMELT® PA 2035 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. Apply the adhesive as closely as possible to the side where the parts to be bonded are joined and in a thickness ensuring complete and intensive coating of both surfaces. Immediately after joining, keep the parts pressed together until the bonded joint 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 joint 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).

Classification:

Please refer to the corresponding **Material Safety Data Sheets** for details on:

Hazards identification
Transport information
Regulatory 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.

Additional information

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