

TECHNOMELT PA 2039

February 2017

- PRELIMINARY -

PRODUCT DESCRIPTION

TECHNOMELT PA 2039 provides the following product characteristics:

Technology	Polyamide
Product Type	Hotmelt
Cure	Physical setting
Components	One-component
Application	General assembly
Appearance	Light yellow/amber granules

Application Areas:

TECHNOMELT PA 2039 is a hotmelt adhesive especially suitable for porous substrates such as paper, wood and leather.

TECHNICAL DATA

Appearance	light yellow/ amber granules	ASTM D 2090
Softening point	195 to 215°C	ASTM E 28
Viscosity at 220°C	7,000 to 12,000 mPa s	ASTM D 3236
Water content K.F.	0.2% max	ASTM D 789
Specific gravity	0.975 g/mL	
*Mechanical properties:		
Tensile yield	6 N/mm ²	
Tensile break	5 N/mm ²	
Elongation	300%	
2% modulus	65 N/mm ²	
Mandrel test 100% pass	-5°C	ASTM D 3111
Shore D-hardness	38	ASTM D 2240
Application temperature	190 to 230°C	

Extruder's Temperature setting example:

	Zone 1	Zone 2	Zone 3	Die Head	Gear Pump	Hose	Nozzle
°C	170	200	210	210	210	210	2015

*The following values of the mechanical properties are provisional and may change in the future.

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.

Application:

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.

The substrate surface should be free of dust and cleaned with a suitable solvent so that there is no fat and oil.

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 approximately 50°C below the application temperature.

TECHNOMELT PA 2039 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.

Cleaning:

For cleaning of the extruder we recommend to use fresh material.

Periodically carry out a thoroughly cleaning of the screw and of the extruder barrel according to the procedures suggested by extruder's manufacturer.

Safety Precautions:

In the solid form TECHNOMELT PA 2039 does not constitute a health hazard. However, once molten it should be treated like any hot liquid and can cause burns if in contact with exposed skin. The appropriate safety precautions should be used (see relevant safety-data-sheet). If the molten liquid does contact skin the affected area should be cooled immediately with cold water. Do not attempt to remove the adhesive, seek medical advice.

Regulations:

On the base of the available data, the product is not a hazardous material according to the European directive 1999/45/EEC.

Form of Supply:

Granulate, multi-wall sacks containing 20 kg net. Also available in 500 Kg Big Bags.

Storage:

Up to max. +35 °C, 24 months in original closed container.

Be sure that used container are closed immediately with insulation against moisture.

The adhesive and application properties can decrease by storing with open containers.

Classification:

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

Hazards identification

Transport information

Regulatory information

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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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Reference 0.1