

## TECHNOMELT PA 2084

Known as Macromelt 2084  
February 2013

### PRODUCT DESCRIPTION

TECHNOMELT PA 2084 provides the following product characteristics:

<b>Technology</b>	Polyamide
Product Type	Hotmelt
<b>Cure</b>	Physical setting
Condition	Thermoplastic
Components	One-component
<b>Application</b>	Foundry
Color	Amber

### Application Areas

TECHNOMELT PA 2084 is applied in the foundry industry. Due to the fast setting speed TECHNOMELT PA 2084 is especially used for bonding sand cores by automatic application.

### TECHNICAL DATA

#### Technomelt PA 2084:

Softening point, °C	165 to 175
ASTM E28 (in glycerine)	
Melting Viscosity at 180 °C, mPas	200 to 400
Melting Viscosity at 190 °C, mPas	80 to 160
ASTM D 3236 (RVT, spindle 21)	
Temperature creep resistance, °C	150
Henkel method AIE SKE 10-05	
Open Time, seconds	~7
Henkel method AIE SKE 10-21*	
Setting Time, seconds	approx. 5 (5 sec. open time)
Henkel method AIE SKE 10-21*	
Setting Time, seconds	approx. 10 (2 sec. open time)
Henkel method AIE SKE 10-21*	

\*Coldbox stick, 20°C, Distance: 1mm, Appl. temp.: 190°C, Quantity: 0.45-0.50g, Area: 22 x 22mm, Pressure: 10N

### 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 200 °C  
Application System : Hotmelt application systems

TECHNOMELT PA 2084 is applied by melting equipment with a gear pump.

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 2084 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 joint.

#### 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:

**Hazardous Information**  
**Transport Regulations**  
**Safety Regulations**

#### 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

##### 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



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