

## TECHNOMELT PA 2305

Known as Macromelt 2305  
February 2013

### PRODUCT DESCRIPTION

TECHNOMELT PA 2305 provides the following product characteristics:

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

### Application Areas:

TECHNOMELT PA 2305 is used for general assembly applications.

### TECHNICAL DATA

#### Technomelt PA 2305:

Softening point, °C ASTM E28 (in glycerine)	175
Melting Viscosity at 210 °C, mPas	7,000
Melting Viscosity at 220 °C, mPas	5,000
Melting Viscosity at 230 °C, mPas ASTM D 3236 (RVT, spindle 27)	3,500
Temperature creep resistance, °C Henkel method MH 11	155
Low temperature flexibility, °C ASTM D 3111	-35
Break Strength, N/mm <sup>2</sup>	9.0
Yield Strength, N/mm <sup>2</sup> ISO 527, Specimen no.5 Cross-head-speed: 50mm/min	5.0

### 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 : 200 to 240 °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 130°C, but not longer than 72 hours.

TECHNOMELT PA 2305 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:

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.

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