

## TECHNOMELT® PA 6202

Known as MACROMELT 6202  
September 2021

### PRODUCT DESCRIPTION

TECHNOMELT® PA 6202 provides the following product characteristics:

<b>Technology</b>	Polyamide
Chemical Type	Hot Melt Adhesive
<b>Cure</b>	Physical Setting
Appearance	Light amber
Components	One Component
Viscosity	Low
<b>Application</b>	Bonding, General assembly, Filter Pleating, Molding, Encapsulation
Application temperature	195°C to 215°C (385°F to 420 °F)
Specific Benefits	<ul style="list-style-type: none"><li>• Good heat stability</li><li>• Strong bond strength</li><li>• Suitable for non-woven and paper substrates</li></ul>

TECHNOMELT® PA 6202 is a one-component industrial grade Polyamide Hot Melt Adhesive. Once applied TECHNOMELT® PA 6202 solidifies to form a tough, resilient adhesive with good heat stability and bond strength. Typical applications include air filter pleating assembly. It is a versatile adhesive for many substrates such as plastic and metal.

TECHNOMELT® PA 6202 is manufactured from ingredients regulated under the FDA Code of Federal Regulations 175.105 (adhesives). This product is supplied in round bead form.

### TYPICAL MATERIAL PROPERTIES

#### Physical Properties

Softening point, °C	133 to 143
ASTM E28, (in glycerin)	
Melting Viscosity- RVT @ 190 °C, mPa·s (cP)	
ASTM D-3236:	
Spindle 27	4,000 to 6,000
Open Time @ 160°C, seconds	40 to 60

### TYPICAL MATERIAL PERFORMANCE

Tested @ 23°C

#### Physical Properties :

Hardness, Shore A	86
Elongation, %	420
Tensile Strength	N/mm <sup>2</sup> 3.1 (psi) (450)
Yield Strength	N/mm <sup>2</sup> 3.2 (psi) (460)
Temperature Creep Resistance, °C	113 to 118
Water Absorption, %:	
1 day	0.5
7 days	1.2

### GENERAL INFORMATION

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or their strong oxidizing materials.**

**For safe handling information on this product, consult the Safety Data Sheet, (SDS).**



**DIRECTIONS FOR USE**

1. Use gloves to minimize skin contact. DO NOT use solvents for cleaning hands.
2. The surfaces of the substrate must be dry and free from oil, grease, and dust.
3. When bonding to a substrate with high thermal conductivity the use of a specific application temperature is required for good wetting.
4. Do not heat the product above the specified application temperature range.
5. When the product is not in use do not apply heat, this will degrade the quality of the product and in extreme cases cause carbonization or charring.
6. Carbonized material must be removed mechanically.
7. To internally clean the system add TECHNOMELT® 62 to reservoir and continue to purge material until it comes out clean, like fresh TECHNOMELT® 62. Check for availability in your region.
8. For cold cleaning of surface soiling on application equipment, conveyor belts or other machine parts TECHNOMELT® CLEANER MELT-O-CLEAN can be applied. It is based on natural citrus extract and facilitates manual cleaning even in case of pronounced charring. Before using TECHNOMELT® CLEANER MELT-O-CLEAN, its suitability for lacquered and synthetic coated surfaces should be tested.

**Storage:**

Store product in the unopened container in a cool dry location. Storage information may be indicated on the product container labeling.

**Optimal Storage: Up to 28° C. Storage above 35° C can adversely affect the ability to handle and dispense the material.**

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Henkel representative.

**Product Specifications**

The technical data contained herein are intended as reference only and are not considered specifications for the product. Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

**Approval and Certificate**

Please contact Henkel representative for related approval or certificate of this product.

**Data Ranges**

The data contained herein may be reported as a typical value. Values are based on actual test data and are verified on a periodic basis.

Temperature/Humidity Ranges: 23°C / 50% RH = 23±2°C / 50±5% RH

**Conversions**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\text{N} \times 0.225 = \text{lb/F}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{psi} \times 145 = \text{N/mm}^2$   
 $\text{MPa} = \text{N/mm}^2$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

**Disclaimer**

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