

TECHNOMELT® PA 6206

Known as TECHNOMELT® 6206 or MACROMELT® MM-6206
January 2022

PRODUCT DESCRIPTION

TECHNOMELT® PA 6206 provides the following product characteristics:

Technology	Polyamide
Chemical Type	Hot Melt Adhesive
Cure	Physical Setting
Appearance	Amber Pellet
Components	One Component
Viscosity	Medium
Application	Bonding, Molding and Encapsulation
Application temperature	(210 to 232)°C (410 to 450)°F
Specific Benefits	<ul style="list-style-type: none">• Good chemical resistance• Good flame resistance

TECHNOMELT® PA 6206 is a one-component industrial grade Polyamide Hot Melt Adhesive. Once applied TECHNOMELT® PA 6206 solidifies to form a tough, resilient adhesive with good heat stability and bond strength. Typical applications include filter pleating assembly, automotive, and molding applications. It is a versatile adhesive for many substrates.

UL 94 V-0

TECHNOMELT® PA 6206 has been tested to UL 94 V-0. Contact Henkel for details.

TYPICAL MATERIAL PROPERTIES

Physical Properties

Specific Gravity @ 23°C ISO 1183	0.98
Softening point (in Glycerine), °C ASTM E28	167 to 177
Melting Viscosity- RVT @ 210°C, mPa·s (cP) ASTM D3236: Spindle 27	4,300

TYPICAL MATERIAL PERFORMANCE

Tested @ 23°C

Physical Properties :

Hardness Shore, Durometer A ASTM D2240	97
Elongation, %	480

ISO 527, Specimen no.5

Cross-head-speed: 50mm/min

Tensile at break ASTM D 628	N/mm ² (psi)	7.6 (1,100)
Yield Strength ASTM D 628, Specimen no.5 Cross-head-speed: 50mm/min	N/mm ² (psi)	12.4 (1,800)
E-modulus ASTM D 1708	N/mm ² (psi)	103.4 (15,000)
Glass Transition Temperature (Tg), °C DSC Second run		5
Water Absorption, %:		
1 day		0.3
7 days		0.7
Thermal Conductivity, W/m·°C		0.15

Electrical Properties :

Dielectric Strength, kV/mm	23
Volume Resistivity	1.6×10 ¹¹

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. Hotmelt application system with gear pump recommended.
4. Hotmelt application system with extruder recommended.
5. When bonding to a substrate with high thermal conductivity the use of a specific application temperature is required for good wetting.
6. Do not heat the product above the specified application temperature range.
7. 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.
8. Carbonized material must be removed mechanically.



9. 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.
10. 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: from 8 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

(°C x 1.8) + 32 = °F
 kV/mm x 25.4 = V/mil
 mm / 25.4 = inches
 N x 0.225 = lb/F
 N/mm x 5.71 = lb/in
 N/mm² x 145 = psi
 N/mm² = MPa
 N·m x 8.851 = lb·in
 N·m x 0.738 = lb·ft
 N·mm x 0.142 = oz·in
 mPa·s = cP

Disclaimer

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