

TECHNOMELT® PA 6208 N

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PRODUCT DESCRIPTION

TECHNOMELT® PA 6208 N provides the following product characteristics:

Technology	Polyamide
Product type	Hotmelt
Cure	Physical setting
Condition	Thermoplastic
Components	One-component
Application	General assembly
Color	Amber

Application areas

TECHNOMELT® PA 6208 N is used for molding, filter and other general assembly applications. This product has good adhesion to a variety of substrates including fabrics, leather, metals, wood, ABS and flexible vinyl.

TECHNICAL DATA

Density, g/cm ³ ISO 1183-1, 20°C	0.98
Softening point, °C ASTM E28 (in glycerine)	150 to 160
Melting viscosity at 190°C, mPas	6,500
Melting viscosity at 200°C, mPas	4,800
Melting viscosity at 210°C, mPas	2,800 to 4,000
Melting viscosity at 220°C, mPas ASTM D 3236 (RVT, spindle 27)	2,700
Temperature creep resistance, °C Henkel method MH 11	130
Yield strength, N/mm ² ISO 527, Specimen no. 5 Cross-head-speed: 50mm/min	3.3
Break strength, N/mm ² ISO 527, Specimen no. 5 Cross-head-speed: 50mm/min	3.6
Elongation, % ISO 527, Specimen no. 5 Cross-head-speed: 50mm/min	600
Shore A hardness ISO 868/15s	82
Low temperature flexibility, °C ASTM D 3111	-40
Working temperature, °C Depends on the application, without mechanical stress	-40 to 100

DIRECTIONS FOR USE

Preliminary statement

Prior to use it is necessary to read the **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 230°C.

Application system: Hot melt application system

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 90°C, but not longer than 72 hours.

TECHNOMELT® PA 6208 N 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.

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).

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.

Classification

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

Hazards identification

Transport information

Regulatory information



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