

## TECHNOMELT® PA 6370

January 2026

### PRODUCT DESCRIPTION

TECHNOMELT® PA 6370 provides the following product characteristics:

<b>Technology</b>	Polyamide
<b>Chemical type</b>	Hot melt adhesive
<b>Cure</b>	Physical setting
<b>Appearance</b>	Amber
<b>Components</b>	One-component
<b>Viscosity</b>	Low
<b>Application</b>	Molding
<b>Molding temperature</b>	200°C to 230°C (392°F to 446°F)
<b>Operating temperature range</b>	-20°C to 140°C (-4°F to 284°F) Depends on application, without mechanical stress
<b>Specific benefits</b>	<ul style="list-style-type: none"> <li>• Easy moldability</li> <li>• Exceptional flowability</li> <li>• Very low coefficient of thermal expansion</li> <li>• Excellent self-extinguishing properties</li> <li>• Excellent hydrophobicity</li> </ul>

TECHNOMELT® PA 6370 is a one-component industrial grade polyamide hot melt adhesive designed to meet low pressure molding process requirements. This product can be processed at low molding pressure due to its low viscosity, allowing encapsulation of fragile components without damage.

Once applied TECHNOMELT® PA 6370 solidifies to form a barrier between electronics and the environment. It is a resilient encapsulant with good resistance to moisture, heat, and corrosive environments. Typical applications include sealing and protecting electrical components such as fan motors, eV charging piles, sensors and many industry devices under harsh conditions. It is a versatile adhesive for many substrates such as FR4 and many plastics including ABS, PC.

TECHNOMELT® PA 6370 has been tested to UL 94 V0. Contact Henkel for details.

### TYPICAL PROPERTIES

Specific gravity, g/cm <sup>3</sup> ISO 1183-1, @ 25°C	0.98
Softening point, °C ASTM E28 (in glycerin)	172
Melt viscosity, @ 190°C, mPa.s ASTM D 3236 (RVT, Spindle 27)	6,950
Viscosity @ 200°C, mPa.s	4,000
Viscosity @ 210°C, mPa.s	3,000
Viscosity @ 220°C, mPa.s	1,925
Viscosity @ 230°C, mPa.s	1,575

### TYPICAL PERFORMANCE

#### Physical

Shore hardness, Durometer A DIN EN ISO 868/15s	87
Elongation, % ISO 527 Specimen no.5 Cross head speed, 50 mm/min.	320
Low temperature flexibility, °C ASTM D 3111	-20
Coefficient of thermal expansion, ppm Measuring cell TMA/SDTA 2+, intercooler, 3 mm ball point probe (quartz)	175
Glass transition temperature (Tg), °C by DSC second run	-20
Water absorption, 1 day @ 23°C, %	0.5

#### Strength

Tensile at break ISO 527 Specimen no.5	N/mm <sup>2</sup> (psi)	4.3 (623)
Yield strength ISO 527 Specimen no.5 Cross-head-speed: 50mm/min	N/mm <sup>2</sup> (psi)	4.0 (580)

#### Lap shear, MPa

Al/Al	1,2
FR4/FR4	4.9
PVC/PVC	4.0

**Electrical properties**

Dielectric constant / Dissipation factor ASTM D150-18, Sample thickness: 3mm	
50 Hz	9.8 / 0.192
1 kHz	6.8 / 0.272
1 MHz	3.0 / 0.070
2 MHz	2.9 / 0.061
Dielectric strength, kV/mm IEC 60243	14
Volume resistivity, ohms-cm ASTM D257-14(2021)e1, Sample thickness: 3mm, Voltage: 500V, Time: 1min	$2.25 \times 10^{11}$

**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 other 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. Material has been formulated to provide the best possible moldability and as wide a molding latitude as possible.
4. Much of the final molding parameters will be determined by the mold design.
5. Molding temperature will vary from situation to situation, range shown on this data sheet is a starting range for process development.
6. When potting to a substrate with high thermal conductivity the use of a specific application temperature is required for good wetting.
7. Do not heat the product above the specified application temperature range.
8. 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.
9. Carbonized material must be removed mechanically.
10. 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). Check for availability in your region.

**Storage**

Store product in the unopened container in a 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 will 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. Material from opened containers should be transferred immediately into airtight containers. Material should be stored in sealed containers in a cool location to maximize shelf life.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation 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 specification**

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  
 µm / 25.4 = mil  
 N x 0.225 = lb  
 N/mm x 5.71 = lb/in  
 N/mm<sup>2</sup> x 145 = psi  
 MPa x 145 = psi  
 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**

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 production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product. Any liability in respect of the information in the Technical data sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:**

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.



**In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:**

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. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Corporation, or Henkel Canada Corporation, the following disclaimer is applicable:**

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

**Trademark usage**

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 1