Technical Data Sheet

TECHNOMELT® PA 641

February 2013

PRODUCT DESCRIPTION

TECHNOMELT® PA 641 provides the following product characteristics:

Technology	Polyamide
Chemical Type	Hotmelt
Cure	Physical setting
Condition	Thermoplastic
Components	One-component
Application	Molding
Color	Amber

Application areas

TECHNOMELT® PA 641 is used for molding applications.

Density, g/cm³ ISO 1183-1, 20 °C	0.98
Softening point, °C ASTM E28 (in glycerine)	170 to 180
Melting viscosity at 210°C, mPas	7,000
Melting viscosity at 220°C, mPas	5,000
Melting viscosity at 225°C, mPas	3,500 to 5,500
Melting viscosity at 230°C, mPas ASTM D 3236 (RVT, spindle 27)	3,500
Shore A hardness, °C ISO 868/15s	92
Low temperature flexibility, °C ASTM D 3111	-35
Yield strength, N/mm² ISO 527 Specimen no.5 Cross-head-speed: 50mm/min	5.0
Break strength, N/mm² ISO 527 Specimen no.5 Cross-head-speed: 50mm/min	9.0
Elongation, % ISO 527 Specimen no.5 Cross-head-speed: 50mm/min	650
Temperature creep resistance, °C Henkel method MH 11	155
Glass transition, °C DSC, 2. run	-30
Working temperature, °C Depends on the application, without mechanical stress	-40 to 130

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 Material Safety Data Sheet.

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 641 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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