

TECHNOMELT PA 6737

November 2018

PRODUCT DESCRIPTION

TECHNOMELT PA 6737 provides the following product characteristics:

Technology	Polyamide
Product Type	Hotmelt
Cure	Physical setting
Condition	thermoplastic
Components	One-component
Application	General assembly
Appearance	Amber

Application Areas:

TECHNOMELT PA 6737 is used for general assembly applications, especially for plastic substrates.

TECHNICAL DATA

Technomelt PA 6737:

Softening point, °C	95 to 105
ASTM E28 (in glycerine)	
Melting Viscosity at 160 °C, mPas	24,000 to 28,000
Melting Viscosity at 190 °C, mPas	9,000
Melting Viscosity at 210 °C, mPas	5,000
Melting Viscosity at 220 °C, mPas	4,000
ASTM D 3236 (RVT, spindle 27)	
Specific gravity, g/cm ³	0.97
ASTM D 1963	
Yield Strength, N/mm ²	5
ASTM D 638	
Break Strength, N/mm ²	6
ASTM D 638	
Elongation, %	900
ASTM D 638	
E-modulus 2%, N/mm ²	65
ASTM D 638	
Mandrel test 100% pass, °C	-20
ASTM D 3111	
Shore D hardness	28
ASTM D 2240	

DIRECTIONS FOR USE

Preliminary Statement:

Prior to use it is necessary to read the **Material 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 System : Hotmelt application system (tank melter and/or extruders) with gear pump.

Application Temperature : 190 to 220 °C

Typical application temperature range:

160 to 180 °C by Extruders preferably equipped with gear pumps.

190 to 220 °C by Hotmelt application systems with gear pumps.

When substrates with high heat conductivity shall be bonded the use of a given application temperature is necessary for good wetting.

The substrate surface should be free of dust and cleaned with a suitable solvent so that there is no fat and oil.

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.

Without using do not heat the product for a long time, this will degrade the quality of the product by increasing the product viscosity and in extreme cases cause carbonization.

The standby temperature for the product is approximately °C below the application temperature but only for few hours.

Do not keep on the application system overnight.

The product may adsorb moisture from the air.

This will not be obvious in the solid form, but could cause foaming as the adhesive is melted which may result in poor bonds.

Re-close the container tightly as soon as sufficient adhesive has been removed for immediate use.

Viscosity specifications have to be meant at manufacturing date.

A spontaneous viscosity increase within the shelf life timeframe is a normal and well know peculiarity for this product, contributing to its long term performances.

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 12 months.



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