

TECHNOMELT[®] PA 6797 N

November 2021

PRODUCT DESCRIPTION

TECHNOMELT[®] PA 6797 N provides the following product characteristics:

Technology	Polyamide
Chemical Type	Hot Melt Adhesive
Cure	Physical Setting
Appearance	Amber
Components	One Component
Viscosity	Low
Application	General Assembly
Molding Temperature	180 to 220°C (356 to 428°F)
Operating Temperature Range	-20 to 60°C (-4 to 140°F) Depends on application, without mechanical stress
Specific Benefits	<ul style="list-style-type: none">• Strong adhesion• Good bond strength

TECHNOMELT[®] PA 6797 N is a one-component industrial grade Polyamide Hot Melt Adhesive.

Once applied TECHNOMELT[®] PA 6797 N solidifies to form a resilient adhesive with good bond strength and strong adhesion. Typical applications include general assembly applications. It is a versatile adhesive for many substrates including PVC and PA6.6.

UL 94

TECHNOMELT[®] PA 6797 N has been tested to UL 94 V2. Contact Henkel for details.

TYPICAL MATERIAL PROPERTIES

Physical Properties

Specific Gravity @ 23°C, g/cm ³ ISO 1183	0.98
Softening point (in Glycerine), °C ASTM E28	115 to 125
Melting Viscosity- RVT, mPa·s (cP) ASTM D3236:	
Spindle 27:	
@ 160°C	12,500
@ 190°C	3,000 to 4,000
@ 210°C	2,500

TYPICAL MATERIAL PERFORMANCE

Tested @ 23°C

Physical Properties :

Hardness Shore, Durometer A DIN EN ISO 868/15s	60
Elongation, % ISO 527, Specimen no.5 Cross-head-speed: 50mm/min	300
Low Temperature Flexibility, °C ASTM D3111	-20
Temperature Creep Resistance, °C Henkel MH 11 Method	85
Glass Transition Temperature (Tg), °C DSC Second run	-18
Tensile at break ISO 527, Specimen no.5	N/mm ² 0.8 (psi) (120)
Yield Strength ISO 527, Specimen no.5 Cross-head-speed: 50mm/min	N/mm ² 1.2 (psi) (170)
E-modulus ASTM D638	N/mm ² 8.5 (psi) (1,230)

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. Typical Hot Melt application systems including gear pump or piston pump can be used.
4. Application temperature will vary from situation to situation, range shown on this data sheet is a starting range for process development.
5. When potting 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® PA 62 to reservoir and continue to purge material until it comes out clean, like fresh TECHNOMELT® PA 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: 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. 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 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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\text{N} \times 0.225 = \text{lb/F}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{psi} \times 145 = \text{N/mm}^2$
 $\text{MPa} = \text{N/mm}^2$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

Disclaimer

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