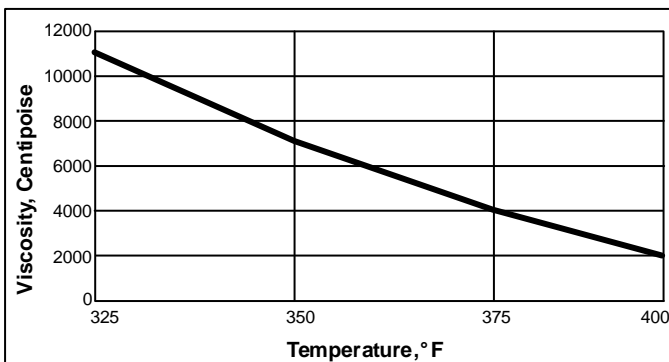


Description

Technomelt® PA 7809FR™ polyamide hot melt is a tough, high performance adhesive that has been modified with fire retardant materials. It has a UL 94V-O flammability rating, File # E63126 Volume 1. It is recommended for demanding applications where substrates may be exposed to temperature extremes. Technomelt® PA 7809FR™ bonds to many difficult substrates including: metals, plastics, wood, leather, fabric, non-woven fabric, films, and foils.

| Typical Properties | Typical Value |
|------------------------------------|---------------|
| Softening Point, °F, ASTM E 28-67 | 269 |
| Viscosity @ 350°F, cP, ASTM D 3236 | 7000 |
| Open Time, seconds | 35 |
| Heat resistance, °F, ASTM D 4498 | 240 |
| Specific Gravity @ 77°F ASTM D 792 | 1.01 |
| Tensile Strength, psi, ASTM D 638 | 363 |
| Elongation, %, ASTM D 638 | 373 |
| Tg, °F, ASTM E 1640 | -11 |
| Application Temperature, °F | 400 to 450 |
| T-Peel Aluminum, pli, ASTM D 1876 | 12 |
| Hardness, Shore A, ASTM D 2240 | 85 |

Viscosity Curve



PERFORMANCE OF CURED MATERIAL

Shear Strength vs. Substrate, ASTM D1002 psi,
(cured 5 days at 22°C)

| | Typical Value |
|--------------------|---------------|
| Grit-Blasted Steel | 1220 |
| Aluminum | 1030 |
| Anodized Aluminum | 1430 |
| Stainless Steel | 1000 |
| Galvanized | 880 |
| Zinc Dichromate | 875 |
| Polycarbonate | 100 |
| Nylon | 450 |
| G-10 Epoxy | 560 |
| LDPE | 20 |
| Wood (Pine) | 610 |
| Glass | 325 |
| Polystyrene | 230 |

| Block Shear, ASTM D4501 | Typical Value |
|-------------------------|---------------|
| 24 Hour RTC, 68°F/50%RH | |
| PVC | 200 |
| Valox | 285 |
| HD Polyethylene | 220 |
| Polypropylene | 160 |
| ABS | 275 |

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, (MSDS).

Precautions

Once melted, like any hot liquid, this adhesive can produce severe burns. Care should be taken to avoid getting hot adhesive on the skin. If skin contact occurs, flush the affected area with large amounts of cold water.

Application

Please read the operating instructions for the Hysol Hot Melt Applicator being used. Allow the applicator 5 - 10 minutes to reach operating temperature before applying the adhesive. Squeeze the trigger to dispense hot melt to one of the parts to be bonded. For best results, press the parts as soon as possible; within the hot melt's open time. After use, unplug the applicator and squeeze trigger twice to advance any semi-molten adhesive into the melt chamber. This helps for quick start-up when the applicator is used next. Always use gloves when using the applicator. Henkel Adhesive and Coating Systems offers a complete line of reliable, portable, hand held applicators designed to accurately dispense all shaped hot melt formulations.

Storage

Store product in unopened container in a cool dry location. Ideal conditions are within the range 8 to 21 degrees C (46 to 70 degrees F) and are recommended for long term storage. Exposure to higher temperatures (greater than 28 degrees C) for prolonged periods should be avoided as extended exposure to warm conditions can adversely affect product properties. For further specific shelf life information, contact your local Technical Service Center.

Note

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

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