

TECHNOMELT PA 678 BLACK

Known as Macromelt OM 678
February 2013

PRODUCT DESCRIPTION

TECHNOMELT PA 678 BLACK provides the following product characteristics:

Technology	Polyamide
Product Type	Hotmelt
Cure	Physical setting
Condition	thermoplastic
Components	One-component
Application	Molding
Color	Black

Application Areas:

TECHNOMELT PA 678 BLACK is used for molding applications.

TECHNICAL DATA

Technomelt PA 678 BLACK:

Density, g/cm ³	0.98
ISO 1183-1, 20°C	
Softening point, °C	182 to 192
ASTM E28 (in glycerine)	
Melting Viscosity at 210 °C, mPas	2,500 to 4,000
Melting Viscosity at 220 °C, mPas	2,500
Melting Viscosity at 230 °C, mPas	1,900
ASTM D 3236 (RVT, spindle 27)	
Shore A hardness	90
ISO 868/15s	
Yield Strength, N/mm ²	5.1
ISO 527 Specimen no.5	
Cross-head-speed: 50mm/min	
Break Strength, N/mm ²	5.5
ISO 527 Specimen no.5	
Cross-head-speed: 50mm/min	
Elongation °C, %	400
ISO 527, Specimen no.5	
Cross-head-speed: 50mm/min	
Temperature creep resistance, °C	160
Henkel method MH 11	
Glass Transition, °C	-45
DSC, 2. Run	
Low temperature flexibility, °C	-40
ASTM D 3111	
Flammability	V-0
UL 94	
Working Temperature, °C	-40 to 140
Depends on the application, without mechanical stress	

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 Temperature : 210 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 678 BLACK 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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