

TECHNOMELT PA 6481 (e)

(Electronics) February 2018

PRODUCT DESCRIPTION

TECHNOMELT PA 6481 (e) provides the following product characteristics:

Technology	Polyamide
Appearance	Black
Components	One-component
Product Benefits	● Improved UV stability
Application	Low pressure molding, Hotmelt adhesive
Cure	Physical setting
Operating Temperature	-40 to 130 °C

TECHNOMELT PA 6481 (e) is used for molding applications. This material is formulated with improved UV stability and is especially suitable for outdoor applications.

TYPICAL MATERIAL PROPERTIES

Physical Properties

Density, g/cm ³ ISO 1183-1	0.98
Softening Point, °C ASTM E28 (in glycerine)	170 to 180
Melting Viscosity, mPa·s (cP) ASTM D-3236, RVT, Spindle 27: @ 210°C	7,300
@ 225°C	3,000 to 5,500
Hardness, Shore A ISO 868/15s	93
Elongation, % ISO 527, Specimen No. 5 Cross-head-speed: 50mm/min	550
Temperature creep resistance, °C Henkel method MH 11	155
Low Temperature Flexibility, °C ASTM D 3111	-30

TYPICAL MATERIAL PERFORMANCE

Performance

Yield Strength, N/mm ² ISO 527, Specimen no. 5 Cross-head-speed: 50mm/min	7.0
Break Strength, N/mm ² ISO 527, Specimen no. 5 Cross-head-speed: 50mm/min	9.0

GENERAL INFORMATION

For safe handling information on this product, consult the Safety Data Sheet, (SDS).

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

Pretreatment:

The substrate should be clean, dry, free of dust, oil, grease and other contaminants.

Application:

Application Temperature: 200 to 240°C

Application System: Hot Melt Application System

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 carbonization. TECHNOMELT PA 6481 (e) 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:

Carbonized 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).

Storage:

Store in a cool, dry location, with the container tightly closed. When not in used, this product will have a shelf life of at least 24 months.

Conversions

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
N x 0.225 = lb
N/mm x 5.71 = lb/in
psi x 145 = N/mm²
MPa = N/mm²
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

Disclaimer



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 beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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