

TECHNOMELT PA 6238

Known as Macromelt 6238
February 2013

PRODUCT DESCRIPTION

TECHNOMELT PA 6238 provides the following product characteristics:

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

Application Areas

TECHNOMELT PA 6238 is used for general assembly applications.

TECHNICAL DATA

Technomelt PA 6238:

Density, g/cm ³ ISO 1183-1, 20°C	0.98
Softening point, °C ASTM E28 (in glycerine)	135 to 145
Melting Viscosity at 160 °C, mPas	27,000
Melting Viscosity at 180 °C, mPas	13,000
Melting Viscosity at 200 °C, mPas	7,000
Melting Viscosity at 210 °C, mPas	4,000 to 6,000
Melting Viscosity at 220 °C, mPas ASTM D 3236 (RVT, spindle 27)	3,500
Temperature creep resistance, °C Henkel method MH 11	110
Yield Strength, N/mm ² ISO 527, Specimen no.5 Cross-head-speed: 50mm/min	4
Break Strength, N/mm ² ISO 527, Specimen no.5 Cross-head-speed: 50mm/min	4.5
Elongation, % ISO 527, Specimen no.5 Cross-head-speed: 50mm/min	500
Low temperature flexibility, °C ASTM D 3111	-10

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 : 180 to 220 °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 90°C, but not for longer than 72h.

TECHNOMELT PA 6238 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.

Immediately after joining, keep the parts pressed together until the bonded joint is held by the adhesive itself. The time which this requires is largely dependent on the recovery of the material to be bonded. If the joint is parted even by some tenths of millimeters during the binding stage, a ridge is formed which leads to reduced load capacity of the joint.

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:

Hazardous Information
Transport Regulations
Safety Regulations

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.

ADDITIONAL INFORMATION

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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