

**PRODUCT DESCRIPTION**

Technomelt PA 6818 provides the following product characteristics:

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

**Application Areas**

Technomelt PA 6818 is used for molding application. It has high softening point and suitable for porous substrates such as paper, wood and leather.

**Technical Data**

Softening point, °C ASTM E28(in glycerine)	206~216
Melting Viscosity at 235°C, mPas ASTM D 3236(RVT, spindle 27)	4000~7500
Specific gravity, g/cm <sup>3</sup> ASTM D 1963	0.98
Yield Strength, N/mm <sup>2</sup> ASTM D 638	21
Break Strength, N/mm <sup>2</sup> ASTM D 638	17
Elongation, % ASTM D 638	300
E-modulus 2%, N/mm <sup>2</sup> ASTM D 638	350
Mandrel test 100% pass, °C ASTM D 3111	5

**DIRECTIONS FOR USE****Preliminary Statement:**

Prior to application 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.

**Preparation:**

The surfaces of the substrate must be dry and free from oil, grease and dust.

**Application:**

Application Temperature: 225 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 approximately 50°C below the application temperature, but not for longer than 72 hours.

Technomelt PA 6818 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.

**Classification:**

Please refer to the corresponding 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:**

The information provided herein, especially recommendations for the usage and the application of our products, is based upon our knowledge and experience. Due to different materials used as well as to varying working conditions beyond our control we strictly recommend to carry out intensive trials to test the suitability of our products with regard to the required processes and applications. We do not accept any liability with regard to the above information or with regard to any verbal recommendation, except for cases where we are liable of gross negligence or false intention.  
This datasheet replaces all former versions.

Reference 0.0