

## TECHNOMELT PA 6208 N BLACK (e)

(Electronics) June 2020

### PRODUCT DESCRIPTION

TECHNOMELT PA 6208 N BLACK (e) provides the following product characteristics:

<b>Technology</b>	Polyamide
<b>Appearance</b>	Black
<b>Components</b>	One-component
<b>Application</b>	Molding compound thermoplastic
<b>Cure</b>	Physical setting
<b>Typical Applications</b>	Encapsulation
<b>Operating Temperature Range</b>	-40 to 100°C (Depends on application, without mechanical stress)
<b>UL Flammability Rating</b>	UL 94 V-0

TECHNOMELT PA 6208 N BLACK (e) thermoplastic, hot melt adhesive is designed for molding compound applications. This material adheres well to a variety of substrates including metals and ABS.

### TYPICAL MATERIAL PROPERTIES

#### Physical Properties

Softening Point, °C	155
ASTM E28 (in glycerine)	
Viscosity @ 210°C, mPa·s (cP)	3,200
Temperature creep resistance, °C	130
Henkel method MH 11	
Elongation, %	450
ISO 527, Specimen No. 5	
Cross-head-speed: 50mm/min	
Hardness, Shore A	82
ISO 868/15s	
Low Temperature Flexibility, °C	-40
ASTM D 3111	

### TYPICAL MATERIAL PERFORMANCE

#### Performance

Yield Strength, N/mm <sup>2</sup>	3.3
ISO 527, Specimen no. 5	
Cross-head-speed: 50mm/min	
Break Strength, N/mm <sup>2</sup>	3.6
ISO 527, Specimen no. 5	
Cross-head-speed: 50mm/min	

### 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: 180 to 230°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 6208 N BLACK (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.

#### 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.

#### Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\text{N} \times 0.225 = \text{lb/F}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{psi} \times 145 = \text{N/mm}^2$   
 $\text{MPa} = \text{N/mm}^2$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

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