

TECHNOMELT PA 668 N

June 2021

PRODUCT DESCRIPTION

TECHNOMELT PA 668 N provides the following product characteristics:

Technology	Polyamide
Appearance	Clear
Application	Molding compound thermoplastic
Cure	Physical setting
Operating Temperature	-25 to +105 °C
Typical Applications	Encapsulation

TECHNOMELT PA 668 N is used for molding applications where optical transparency is required.

TYPICAL MATERIAL PROPERTIES

Physical Properties

Density, g/cm ³	0.98
Softening Point, °C	155
ASTM E28 (in glycerine)	
Viscosity @ 225°C, mPa·s (cP)	5,500
ASTM D-3236, RVT, Spindle 27	
Hardness, Shore A	90
ISO 868/15s	
Elongation, %	600
ISO 527, Specimen No. 5	
Cross-head-speed: 50mm/min	
Cold Flex Temperature, °C	-25

TYPICAL MATERIAL PERFORMANCE

Performance:

Yield Strength	5.5
ISO 527, Specimen no. 5	
Cross-head-speed: 50mm/min	
Break Strength	8.5
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).

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 668 N 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).

TECHNOMELT PA 62 is sold in select regions only. Please consult your local Henkel Sales representative for availability.

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.

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local Henkel representative for assistance and recommendations on the specifications of this product.

Conversions

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

Disclaimer

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