

TECHNOMELT PA 6208 (e)

(Electronics) July 2015

PRODUCT DESCRIPTION

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

Technology	Polyamide
Appearance	Amber
Components	One-component
Application	Molding compound thermoplastic
Cure	Physical setting
Typical Applications	Encapsulation
Flammability Rating	UL 94 V0
Operating Temperature Range	-40 to 100°C (Depends on application, without mechanical stress)

TECHNOMELT PA 6208 (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)	
Melting Viscosity @ 210°C, mPa·s (cP)	3,400
Temperature creep resistance, °C	130
Henkel method MH 11	
Elongation, %	600
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 ²	3.3
ISO 527, Specimen no. 5	
Cross-head-speed: 50mm/min	
Break Strength, N/mm ²	3.6
ISO 527, Specimen no. 5	
Cross-head-speed: 50mm/min	

GENERAL INFORMATION

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

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 (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 0062 (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
N/mm² x 145 = psi
MPa = N/mm²
MPa x 145 = psi
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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