

TECHNOMELT PA 2030

Known as Macromelt 2030
November 2016

PRODUCT DESCRIPTION

TECHNOMELT PA 2030 provides the following product characteristics:

Technology	Polyamide
Product Type	Hotmelt
Cure	Physical setting
Condition	thermoplastic
Components	One-component
Application	Filter
Color	Amber

Application Areas

TECHNOMELT PA 2030 is used for general assembly applications, especially in filter industry.

TECHNICAL DATA

Technomelt PA 2030:

Softening point, °C ASTM E28 (in glycerine)	160 to 175
Melting Viscosity at 220 °C, mPas ASTM D 3236 (RVT, spindle 27)	2,000 to 3,000
Elongation °C, % ISO 527 Specimen no.5 Cross-head-speed: 50mm/min	500
Yield Strength, N/mm ² ISO 527, Specimen no.5 Cross-head-speed: 50mm/min	8
Break Strength, N/mm ² ISO 527 Specimen no.5 Cross-head-speed: 50mm/min	10
E-modulus 2%, N/mm ² ASTM D 638	130

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 : 200 to 230 °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 120°C, but not longer than 72 hours. TECHNOMELT PA 2030 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.

Apply the adhesive as closely as possible to the side where the parts to be bonded are joined and in a thickness ensuring complete and intensive coating of both surfaces.

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:

Hazards identification

Transport information

Regulatory information

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.

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Reference **N/A**