

TECHNOMELT PA 6211 (e)

(Electronics) March 2018

PRODUCT DESCRIPTION

TECHNOMELT PA 6211 (e) provides the following product characteristics:

Technology	Polyamide
Appearance	Amber
Components	One-component
Application	Molding compound thermoplastic
Cure	Physical setting
Typical Applications	Encapsulation, Low pressure molding
Key Substrates	Plastics

TECHNOMELT PA 6211 (e) thermoplastic, hot melt adhesive is designed for molding compound applications.

TYPICAL MATERIAL PROPERTIES

Physical Properties

Softening Point, °C ASTM E28 (in glycerine)	140 to 150
@ 180°C	7,100
@ 190°C	4,900
@ 200°C	3,500
@ 210°C	2,000 to 3,000
Specific gravity, g/cm ³ ASTM D-1963	0.97
Yield Strength, N/mm ² ASTM D-638	2.7
Break Strength, N/mm ² ASTM D-638	2.5
Elongation, % ASTM D-638	400
E modulus, 2%, N/mm ² ASTM D-638	32
Mandrel test, 100% pass, °C ASTM D-3111	-35

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.

Application:

Application Temperature: 180 to 210°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.

The standby temperature for the product is approximately 50°C below the application temperature, but not for longer than 72 hours.

TECHNOMELT PA 6211 (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 PA 62 (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

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

Disclaimer

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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