

## TECHNOMELT PA 678 (e)

(Electronics) June 2015

### PRODUCT DESCRIPTION

TECHNOMELT PA 678 (e) provides the following product characteristics:

<b>Technology</b>	Polyamide
<b>Appearance</b>	Black
<b>Product Benefits</b>	<ul style="list-style-type: none"><li>• Easy moldability</li><li>• Good adhesion to a variety of substrates</li><li>• Excellent moisture resistance</li><li>• Excellent environmental resistance</li><li>• Simplified process flow</li></ul>
<b>Application</b>	Molding compound thermoplastic
<b>Typical Applications</b>	Encapsulation
<b>Operating Temperature</b>	-40 to +140 °C

TECHNOMELT PA 678 (e) high performance thermoplastic polyamide is designed to meet low pressure molding process requirements. This product can be processed at low processing pressure due to its low viscosity, allowing encapsulation of fragile components without damage. This material produces no toxic fumes in process and provides a good balance of low and high temperature performance.

### LIQUID-STATE TYPICAL PROPERTIES

Viscosity @ 210 °C, mPa·s (cP)	3,400
Density, g/cm <sup>3</sup>	0.98
Softening Point, °C	187

### TYPICAL PROCESS DATA

#### Handling:

Molding Temperature, °C	210 to 240
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TECHNOMELT PA 678 (e) has been formulated to provide the best possible moldability and as wide a molding latitude as possible. Much of the final molding parameters will be determined by the mold design. Although molding and curing conditions will vary from situation to situation, recommended starting ranges are shown above.

### SOLID-STATE PROPERTIES

#### Physical Properties

Glass Transition Temperature (T <sub>g</sub> ), °C	-50
Thermal Conductivity, W/m·°C	0.15
Shore Hardness, Shore A	88
Elongation, at break, %	400

#### Electrical Properties

Dielectric Strength, kV/mm	>20
Volume Resistivity, ohms-cm	1.9×10 <sup>12</sup>
Comparative Tracking Index @ 300 mm, IEC 60112, volts	600

### 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.

### STORAGE:

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

TECHNOMELT PA 678 (e) will absorb moisture from the air. Material from opened containers should be transferred immediately into air tight containers. Material should be stored in sealed containers in a cool dry location in order to maximize shelf life.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

### 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  
psi x 145 = N/mm<sup>2</sup>  
MPa = N/mm<sup>2</sup>  
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. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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