

TECHNOMELT® PA 638 BLACK

Known as Macromelt OM 638
February 2024

Product description

TECHNOMELT® PA 638 BLACK provides the following product characteristics:

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|---------------------|------------------|
| Technology | Polyamide |
| Product type | Hotmelt |
| Cure | Physical setting |
| Condition | Thermoplastic |
| Components | One-component |
| Application | Molding |
| Color | Black |

Application areas:

TECHNOMELT® PA 638 BLACK is used for molding applications.

Technical data

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| Density, g/cm ³ ISO 1183-1, 20 °C | 0.98 |
| Softening point, °C ASTM E28 (in glycerine) | 170 to 180 |
| Melting viscosity at 200°C, mPas | 5,000 |
| Melting viscosity at 210°C, mPas | 2,800 to 4,000 |
| Melting viscosity at 220°C, mPas | 2,900 |
| Melting viscosity at 230°C, mPas ASTM D 3236 (RVT, spindle 27) | 2,300 |
| Shore A hardness ISO 868/15s | 90 |
| Yield strength, N/mm ² ISO 527 Specimen no.5 Cross-head-speed: 50mm/min | 4.5 |
| Break strength, N/mm ² ISO 527 Specimen no.5 Cross-head-speed: 50mm/min | 5.2 |
| Elongation °C, % ISO 527, Specimen no.5 Cross-head-speed: 50mm/min | 300 |
| Temperature creep resistance, °C Henkel method MH 11 | 155 |
| Low temperature flexibility, °C ASTM D 3111 | -30 |
| Glass transition, °C DSC, 2. Run | -36 |
| Flammability, UL 94 | V-0 |
| Working temperature, °C Depends on the application, without mechanical stress | -40 to 130 |

Direction 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 240 °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 130°C, but not longer than 72 hours. TECHNOMELT® PA 638 BLACK 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:

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.



Additional information

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