

TECHNOMELT[®] PA 652 N

January 2022

PRODUCT DESCRIPTION

TECHNOMELT[®] PA 652 N provides the following product characteristics:

Technology	Polyamide
Product Type	Hotmelt
Condition	Thermoplastic
Appearance	Amber
Components	One-component
Cure	Physical setting
Application	Molding
Operating Temperature Range	-40 to 100°C (Depends on application, without mechanical stress)

TECHNOMELT[®] PA 652 N 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.

TECHNOMELT[®] PA 652 N is well suited to applications where excellent adhesion and cold temperature flexibility is essential to the assembly.

UL 94 V-0

TECHNOMELT[®] PA 652 N has been tested to UL 94 V-0. Contact Henkel for details.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Density @ 20°C, g/cm ³	0.98
Melting Viscosity- RVT, mPa·s (cP) ASTM D-3236:	
Spindle 27:	
@ 180°C	9,500
@ 190°C	7,000
@ 200°C	5,400
@ 210°C	4,000
Softening Point (in glycerine), °C ASTM E28	150 to 165

TYPICAL PERFORMANCE OF CURED MATERIAL

Physical Properties

Hardness, Shore A ISO 868/15s	77
Elongation, % ISO 527	400
Yield Strength Speciman No. 5	N/mm ² 2.6 (psi) (377)
Cross-head-speed: 50mm/min ISO 527	
Breaking Strength Specimen no.5	N/mm ² 2.7 (psi) (392)
Cross-head-speed: 50mm/min ISO 527	
Temperature Creep Resistance, °C Henkel Method 11	125
Low Temperature Flexibility, °C ASTM D3111	-50
Glass Transition Temperature (Tg), °C DSC Second run	-45

Electrical Properties

Volume Resistivity, ohm-cm	1×10 ¹²
Dielectric Strength, kV/mm	>14

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or their strong oxidizing materials.

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



DIRECTIONS FOR USE

1. Use gloves to minimize skin contact. DO NOT use solvents for cleaning hands.
2. The surfaces of the substrate must be dry and free from oil, grease, and dust.
3. When bonding to a substrate with high thermal conductivity the use of a specific application temperature is required for good wetting.
4. Do not heat the product above the specified application temperature range.
5. 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 or charring.
6. Carbonized material must be removed mechanically.
7. To internally clean the system add TECHNOMELT® 62 to reservoir and continue to purge material until it comes out clean, like fresh TECHNOMELT® 62. Check for availability in your region.
8. For cold cleaning of surface soiling on application equipment, conveyor belts or other machine parts TECHNOMELT® CLEANER MELT-O-CLEAN can be applied. It is based on natural citrus extract and facilitates manual cleaning even in case of pronounced charring. Before using TECHNOMELT® CLEANER MELT-O-CLEAN, its suitability for lacquered and synthetic coated surfaces should be tested.

Storage:

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

Optimal Storage: Up to 28° C. Storage above 35° C can adversely affect the ability to handle and dispense the material.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel 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 Henkel representative.

Product Specifications

The technical data contained herein are intended as reference only and are not considered specifications for the product. Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

Approval and Certificate

Please contact Henkel representative for related approval or certificate of this product.

Data Ranges

The data contained herein may be reported as a typical value. Values are based on actual test data and are verified on a periodic basis.

Temperature/Humidity Ranges: 23°C / 50% RH = 23±2°C / 50±5% RH

Conversions

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

Disclaimer

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