

# Technical Information

Macromelt 6790 S

<u>Type of Product:</u>	Thermoplastic hot melt adhesive based on poly-amide	
<u>Field of application:</u>	Hot melt adhesive for moulding systems and general assembly applications	
<u>Application system:</u>	Application systems for hot-melt adhesives	
<u>Material properties:</u>		
Colour:	black	
Softening point:	174 °C	ASTM E 28 (in siliconoil)
Melting viscosity:	200 °C 2400 mPa.s 210 °C 1900 mPa.s 220 °C 1400 mPa.s 230 °C 1100 mPa.s 240 °C 800 mPa.s	ASTM D 3236 (RVT, spindle 27)
Low temperature flexibility:	- 30 °C	ASTM D 3111
Yield strength:	4,5 N/mm <sup>2</sup>	DIN 53455 Specimen no.
4 Tensile strength:	4,5 N/mm <sup>2</sup>	cross-head- speed: 50
mm/min Break strength:	4,0 N/mm <sup>2</sup>	
Temperature creep- resistance:	155 °C	Henkel-method MH 11
Application temperature:	200 - 240 °C	

Henkel KGaA . TI - Industrial Adhesives . 40191 Duesseldorf . Germany  
Fon +49-211-797-xxxx . Fax +49-211-798-xxxx  
industrial-adhesives@henkel.com . www.industrial-adhesives.com

Handling  
bonded  
suggestions:

When substrates with high heat conductivity shall be the use of a given application temperature is necessary for good wetting. The substrate surface should be free of dust and cleaned with a suitable solvent so that there is no fat and oil.  
Don't heat the product over the mentioned application temperature range. Without using don't heat the product for a long time, because the quality can decrease or extremely the product cokes. The standby temperature is 130 °C.  
Macromelt 6790 S may adsorb moisture from the air. This will not be obvious in the solid form, but could cause foaming as the adhesive is melted which may result in poor bonds. Reclose the container tightly as soon as sufficient adhesive has been removed for immediate use.

Apparatus  
cleaning:

Remove very strong coked and not thermoplastic rests of hot melt mechanical. We recommend a solvent free cleaning agent for the hot application apparatus like Macromelt XS0062 (see separate technical information).

Safety-  
precautions:

No health hazards are expected when Macromelt 6790 S is in solid form. However, once melted it is like any hot liquid, which can produce severe burns. The appropriate safety precautions should be used (see also safety-data-sheet). If the molten adhesive has contacted your skin, cool the affected area immediately with cold water. Do not try to remove the adhesive from the skin. Go to your first aid station for attention.

Regulations:

On the base of the available data, the product is not a hazardous material according to the German chemical law or the hazardous substances regulations dated 26.08.1986 (incl. the 1. modification dated 16.12.1987).

Disposal:

EAK code: 080404 cured adhesives and sealants

Form of supply:

Granulate, multi-wall paper sacks inside with aluminium foil containing 20 kg net.

Storage:

Up to max. +35 °C, min. 24 months in original closed container. Be sure that used container are closed immediatly with insulation against moisture. Maybe the adhesive and application properties can decrease by storing with open containers.

Information provided herein is based upon our practical knowledge and experience. Due to different materials used as well as to varying working conditions which are beyond our control we strictly recommend to carry out intensive trials. Any warranty and/or liability shall not be based on above information or personal consultation, except the contents of a consultation is explicitly confirmed by us in writing.