

Technical Information

Macromelt OM 710

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| <u>Type of Product:</u> | Polyamide hot melt with good mechanical performance, very good resistance against oils and excellent adhesion to PVC. The material is not suitable for applications in high humidity. | |
| <u>Field of application:</u> | Macromelt Molding | |
| <u>Application system:</u> | Hotmelt application systems | |
| <u>Material properties:</u> | | |
| Colour: | amber | |
| Softening point: | 170 °C | ASTM E 28 (in glycerine) |
| Melting viscosity: | 200 °C 19000 mPa.s 210 °C 13000 mPa.s 220 °C 9000 mPa.s 230 °C 6100 mPa.s 240 °C 4200 mPa.s | ASTM D 3236 (RVT, spindle 27) |
| Shore D-hardness: | 40 | DIN 53505/15 s |
| Yield strength: | 9,0 N/mm ² | DIN EN ISO 527 Specimen no. 5 |
| Break strength: | 20,0 N/mm ² | Cross-head- speed: 50mm/min |
| Elongation: | 600 % | |
| Temperature creep- resistance: | 160 °C | Henkel-method MH 11 |
| Cold flexibility: | - 20 °C | ASTM D 3111 |
| Application temperature: | 200 - 240 °C | |



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| <u>Handling suggestions:</u> | <p>When bonding to a substrate with high thermal conductivity the use of a specific application temperature is required for good wetting. The substrate surface should be free of dust, and cleaned with a suitable solvent to remove any organic material.</p> <p>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.</p> <p>Macromelt OM 710 may adsorb 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.</p> |
| <u>Drying process:</u> | <p>The material should be dried before melting in order to provide a stable production process. We recommend a drying procedure with pre-dried air at 40°C for 5 to 6 hours. A drying at higher temperatures over a longer period of time should be avoided.</p> |
| <u>Apparatus cleaning:</u> | <p>Carbonised and set (non thermoplastic) material must be removed mechanically. Removal of the thermoplastic material from the hot apparatus can be achieved with a solvent free cleaning system, such as XS0062 (see separate technical information).</p> |
| <u>Safety precautions:</u> | <p>In the solid form Macromelt OM 710 does not constitute a health hazard. However, once molten it should be treated like any hot liquid and can cause burns if in contact with exposed skin. The appropriate safety precautions should be used (see relevant safety-data-sheet). If the molten liquid does contact skin the affected area should be cooled immediately with cold water. Do not attempt to remove the adhesive, seek medical advice.</p> |
| <u>Regulations:</u> | <p>Based on available data, the product is not classed as a hazardous material in accordance with German chemical law and the hazardous substances regulations.</p> |
| <u>Form of supply:</u> | <p>Granules, multi-wall sacks with aluminium foil, contents 20 kg net.</p> |
| <u>Storage:</u> | <p>Maximum storage temperature of 35°C, for a minimum of 24 months, in the original sealed container. It is important that the containers are kept closed to reduce moisture ingress. It is possible that the performance of the material will be affected by prolonged storage in open containers.</p> |

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 carrying 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.

This Technical Data Sheet supersedes all previous editions.

Henkel KgaA, 40191 Duesseldorf, AI Industrial Adhesives
 Tel.: +49-211-797-0
 industrial-adhesives@henkel.com . www.industrial-adhesives.com



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