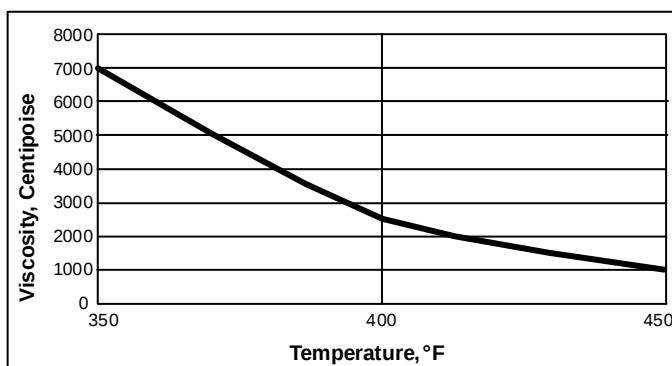


Description

Technomelt® PA 7804™ polyamide hot melt is a tough, elastomeric, high performance adhesive with excellent impact resistance at low temperatures. It is recommended for demanding applications where substrates may be exposed to temperature extremes. Technomelt® PA 7804™ bonds to many difficult substrates including: metals, plastics, wood, leather, fabric, non-woven fabric, and foils.

Typical Properties	Typical Value
Softening Point, °F, ASTM E 28-67	280
Viscosity @ 350°F, cP, ASTM D 3236	7000
Open Time, seconds	35
Heat resistance, °F, ASTM D 4498	220
Specific Gravity @ 77°F ASTM D 792	1.01
Tensile Strength, psi, ASTM D 638	340
Elongation, %, ASTM D 638	900
Tg, °F ASTM E 1640	-76
"T" Peel, Aluminum, pli ASTM D 1876	27
Hardness, Shore A	74

Viscosity Curve



Electrical Properties	Typical Value
Dielectric Strength, ASTM D149, V/mil	600
Dielectric Constant, MIL 1-16923. K	6.0
Dissipation Factor, ASTM D 150	0.14
Volume Resistivity, ASTM D 257	2.2×10^{13}
Surface Resistivity, ASTM D 257	2.4×10^{13}

PERFORMANCE OF CURED MATERIAL

Shear Strength vs. Substrate ASTM D1002, psi,
cured 5 days at 22°C

	Typical Value
Grit-Blasted Steel	520
Aluminum	670
Anodized Aluminum	825
Stainless Steel	565
Galvanized	570
Zinc Dichromate	420
Polycarbonate	120
Nylon	150
G-10 Epoxy	170
LDPE	10
Glass	125

Block Shear, ASTM D4501	Typical Value
24 Hour RTC, 68°F/50%RH	
PVC	137
Valox	150
HD Polyethylene	125
Polypropylene	160
ABS	140

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 other strong oxidizing materials.

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

Precautions

Once melted, like any hot liquid, this adhesive can produce severe burns. Care should be taken to avoid getting hot adhesive on the skin. If skin contact occurs, flush the affected area with large amounts of cold water.

Application

Please read the operating instructions for the Hysol Hot Melt Applicator being used. Allow the applicator 5 - 10 minutes to reach operating temperature before applying the adhesive. Squeeze the trigger to dispense hot melt to one of the parts to be bonded. For best results, press the parts as soon as possible; within the hot melt's open time. After use, unplug the applicator and squeeze trigger twice to advance any semi-molten adhesive into the melt chamber. This helps for quick start-up when the applicator is used next. Always use gloves when using the applicator. Henkel offers a complete line of reliable, portable, hand held applicators designed to accurately dispense all shaped hot melt formulations.

Storage

Store product in unopened container in a cool dry location. Ideal conditions are within the range 8 to 21 degrees C (46 to 70 degrees F) and are recommended for long term storage. Exposure to higher temperatures (greater than 28 degrees C) for prolonged periods should be avoided as extended exposure to warm conditions can adversely affect product properties. For further specific shelf life information, contact your local Technical Service Center.

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.

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