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TECHNOMELT

Technical Data Sheet

TECHNOMELT PA 6344 (e)

(Electronics) April 2018

PRODUCT DESCRIPTION
TECHNOMELT PA 6344 (e) provides the following product characteristics:

Technology	Polyamide
Appearance	Black bead
Product Benefits	• UV resistant
Application	Molding compound thermoplastic
Typical Applications	Encapsulation
Operating Temperature	+60 to 100 °C

TECHNOMELT PA 6344 (e) UV resistance, polyamide-based, thermoplastic, hot melt adhesive is designed for molding compound applications. This material adheres well to a variety of substrates including plastic, glass, metals and ABS.

TYPICAL MATERIAL PROPERTIES

Physical Properties

Viscosity @ 225°C, mPa·s (cP)	7,000
Softening Point, ring and ball, °C	146.5
Elongation, %	700
Water Absorption, %:	
After 1 day	0.4
After 7 days	1.1
Temperature creep resistance, °C	120
Hardness, Shore A	76

TYPICAL MATERIAL PERFORMANCE

Performance

Yield Strength, N/mm²	5

GENERAL INFORMATION

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

Not for product specifications
The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

Pretreatment:
The substrate should be clean, dry, free of dust, oil, grease and other contaminants.

Application:
Application Temperature: 210 to 250°C

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 carbonization. TECHNOMELT PA 6344 (e) 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:
Carbonized 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 52 (see separate technical information).

Storage:
Store in a cool, dry location, with the container tightly closed. Storage information may be indicated on the product container labeling.

Packaging
TECHNOMELT PA 6344 (e) is supplied in round bed form for ease and handling. This product comes packaged in plastic lined boxes containing 40 pounds net.

Disclaimer
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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