

Hotmelt Materials

The Henkel brand TECHNOMELT is our first choice for industrial bonds with hot-melt adhesives (hotmelts) and offers optimal results in the manufacturing processes.

TECHNOMELT adhesives increase operational efficiency through their reliability and high quality. We would be pleased to advise you and offer support in selecting the suitable material.



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TECHNOMELT	PA 652 N/ PA 657 N black	PA 6208 N/ PA 6208 N black	PA 6288 PA 6288 black	PA 653 PA 658 black	PA 633 N/ PA 638 black	PA 641/ PA 646 black	PA 6481 black	PA 6771 black	PA 673 N/ PA 678 black	PA 676 black	PA 6773 GREY	PA 2035/ PA 2035 black	PA 2302 black	PA 6790/PA 6790 black	PA 668 white	AS 5376	PA 113	PA 6211	PA 6797 N	AS 292
colour	amber/ black	amber/ black	cremewhite/ anthracite	amber/ black	amber/ black	amber/ black	black	black	amber/ black	black	grey	amber/ black	black	amber/ black	white	milky white	amber	amber	amber	amber
Base	Polyamid	Polyamid	Polyamid	Polyamid	Polyamid	Polyamid	Polyamid	Polyamid	Polyamid	Polyamid	Polyamid	Polyamid	Polyamid	Polyamid	Polyamid	Polyolefin	Polyamid	Polyamid	Polyamid	Polypropylen
Service Temperature [°C] *	-40/ 100	-40/ 100	-40/ + 100	-40/ + 100	-40/ + 130	-40/ 130	-40/ 130	-50/ 140	-40/ 140	-50/ 140	-30/ 100	-20/ 150	-20/ 150	-40/ 130	-40/ 100	-30/ 90	-20/ 110	-40/ 100	-20/ 60	-20/ 90
Application Temperature [°C]	190 - 210	190 - 210	190 - 210	190 - 210	210 - 230	215 - 230	210 - 230	220 - 240	220 - 240	220 - 240	190 - 210	240 - 250	240 - 250	210 - 230	190 - 210	180 - 200	200 - 220	180 - 205	160 - 180	180 - 200
Shore Hardness (-40°C)	A 85	A 92	A92	A 85	D 40	D 45	D 42	n.e.	D 35	n.e.	n.e.	D 55	D 60	n.e.	n.e.	n.e.	n.e.	n.e.	n.e.	n.e.
Shore Hardnes (+20°C)	A 77	A 82	A 82	A 77	A 90	A 92	A 93	A 90	A 90	A 89	D 39	D 42	D 53	A 86	A 90	A 48	A 94	n.e.	A 60	D 55
Shore Hardness (+100°C)	A 50	A 50	A50	A 50	A 74	A 77	A 75	-	A 72	n.e.	n.e.	A 90	D 39	n.e.	n.e.	-	n.e.	n.e.	-	n.e.
Tensile strength [N/mm²]	2,7	3,6	3,2	3,2	5,2	11,0	9,0	5,5	5,6	6,5	5,0	13	20	4,0	8,5	k.A.	3,5	2,1	0,7	k.A.
Elongation at yield stress [N/mm²]	2,6	3,3	3,0	2,8	4,5	5,0	7,0	4,5	4,9	4,5	6,0	10	15	4,5	5,5	k.A.	6,0	2,2	0	k.A.
Elongation at break [%]	400	600	300	400	400	650	550	450	400	500	50	500	500	250	600	500	100	n.e.	300	k.A.
Water uptake 24h, 22°C [%]	1,4	1,0	0,75	1,4	1,0	0,8	0,8	1,3	1,0	1,2	0,5	0,5	0,3	n.e.	n.e.	< 0,2	n.e.	n.e.	n.e.	k.A.
Adhesion on PVC	++++	++++	n.e.	++++	+++	++++	+++	+++	+++	+++	+++	+	+	+++	+++	+++	++	n.e.	++++	+++
Adhesion on PA 6.6	++++	++++	+++	+++	++	+	+	+++	+	+	+++	+	+	+++	+++	+++	++	n.e.	++++	+++
Flamability at UL94	V0	V0 (6208 N: V2)	V0	-	V0 (633 N: V2)	646: V0	V2	V2 (V0)	V0	V2	-	2035: V0	-	V0	V0	V2	V0	V0	V2	-
Dielectric Constant [1 kHz]	5-7	5-7	n.e.	5-7	5	5-7	5-7	5-7	5-7	5-7	5-7	2,7	2,6	5-7	n.e.	2,05	5-7	5-7	6-8	k.A.
Volume Resistance [W cm]	10 ¹³	10 ¹²	n.e.	10 ¹⁴	10 ¹⁴	10 ¹³	10 ¹³	30 ¹²	10 ¹³	10 ¹³	10 ¹³	10 ¹³	10 ¹³	10 ¹²	n.e.	14 ¹⁷	10 ¹²	10 ¹²	10 ¹²	k.A.
Dielectric Strength [kV/mm]	~20	~20	~20	~20	~20	~20	~20	~20	~20	~20	~20	~20	~20	~20	~20	~20	34,3	~20	~20	k.A.
Glass Transition Temperature [°C]	-45	-37	-45	-45	-36	-30	-30	-50	-45	-50	-25	-20	-20	-38	-30	-35	-18	-35	-18	k.A.
Coldflexibility [°C]	-50	-40	-40	-50	-30	-35	-30	-50	-40	-55	0	-20	-15	-20	-25	-40	n.e.	-35	n.e.	k.A.
Resistance to Thermal Distortion [°C]	125	130	130	125	155	155	155	165	160	165	135	180	190	155	130	80	n.e.	115	0	k.A.
Softening Point [°C]	155 ± 5	155 ± 5	155 ± 5	155 ± 5	175 ± 5	175 ± 5	175 ± 5	185 ± 5	185 ± 5	190	160	200 ± 5	205 ± 5	175 ± 5	155 ± 5	141 ± 6	165 ± 5	145 ± 5	120 ± 5	145 ± 5
Viscosity at 210°C [mPa*s]	4000 ± 1000	3200± 800	4600 ± 1000	4500 ± 1000	3700 ± 800	7000 ± 2000	7300 ± 1000	7500 ± 1000	3000± 800	7000 ± 1000	7000 ± 1000	5000± 2000	4000± 2000	2000 ± 500	5500 ± 1000	2500 ± 800	400 ± 100	2500 ± 500	2500 ± 500	7500 ± 1000
Features	good adhesion	good adhesion	flame retardent	resistance against hydrolyze	universal usage	good adhesion to PVC	UV-stable	UV-stable, very good cold fleibility, V0 (0.75- 1.1 mm)	low viscosity at high softening point	very good cold flexibility	Thermal conductivity: 0,8-1,0 W/m Density 1,4 g/cm³	good chemical resistance, high hardness, high tempera- ture resistant	good chemical resistance, high hardness, high tempera- ture resistant	low viscosity	white and UV stable	very broad adhesion spectre, no water uptake, follow-up material of 5375	very low viscosity		very good adhesion	very good adhesion

*depending on the application

Shore Hardness
ISO 868/15 s

Elongation at yield stress
ISO 527, Test specimen Nr.5
Testing speed 50 mm/min

Glass Transition Temperature
DSC, 2. run

Resistance to Thermal Distortion
Henkel Methode 11

Viscosity
ASTM D 3236, RVT,
Spindel 27

Tensile Strength
ISO 527, Test specimen Nr.5
Testing speed 50 mm/min

Elongation at break
ISO 527, Test specimen Nr.5
Testing speed 50 mm/min

Coldflexibility
ASTM D3111

Softening Point
ASTM E28 in Glycerin