MACROMELT OM 648

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PRODUCT DESCRIPTION

MACROMELT OM 648 provides the following product characteristics:

Technology	Polyamide
Product Type	Hotmelt
Cure	Physical setting
Condition	Thermoplastic
Components	One-component
Application	Molding
Color	Black

Application Areas

MACROMELT OM 648 is used for molding applications.

The product shows an improved UV stability and is especially suitable for outdoor applications.

TECHNICAL DATA

Macromelt OM 648:

Density, g/cm³ ISO 1183-1, 20°C	0.98
Softening point, °C ASTM E28 (in glycerine)	170 to 180
Melting Viscosity at 200 °C, mPas	10,000
Melting Viscosity at 210 °C, mPas	7,300
Melting Viscosity at 220 °C, mPas	5,400
Melting Viscosity at 225 °C, mPas	3,000 to 5,500
Melting Viscosity at 230 °C, mPas	4,100
Melting Viscosity at 240 °C, mPas ASTM D 3236 (RVT, spindle 27)	3,100
Shore A hardness ISO 868/15s	93
Yield Strength, N/mm² ISO 527 Specimen no.5 Cross-head-speed: 50mm/min	7.0
Break Strength, N/mm² ISO 527 Specimen no.5 Cross-head-speed: 50mm/min	9.0
Elongation, % ISO 527, Specimen no.5 Cross-head-speed: 50mm/min	550
Temperature creep resistance, °C Henkel method MH 11	155
Low temperature flexibility, °C ASTM D 3111	-30
Glass Transition, °C DSC, 2. Run	-30
Working Temperature, °C Depends on the application, without mechanical stress	-40 to 130

DIRECTIONS FOR USE

Preliminary Statement:

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed.

Preparation:

The surfaces of the substrate must be dry and free from oil, grease and dust.

Application:

Application Temperature : 200 to 240 °C
Application System : Hotmelt application systems

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 carbonisation. The standby temperature for the product is 130°C, but not longer than 72 hours.
MACROMELT OM 648 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:

Carbonised 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 Macromelt 0062 (see separate technical information)

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information
Transport Regulations
Safety Regulations

Storage:

When properly stored in a cool, dry location, with the container tightly closed when not in use, this product will have a shelf life of at least 24 months.

ADDITIONAL INFORMATION

Disclaimer:

The information provided herein, especially recommendations for the usage and the application of our products, is based upon our knowledge and experience. Due to different materials used as well as to varying working conditions beyond our control we strictly recommend to carry out intensive trials to test the suitability of our products with regard to the required processes and applications. We do not accept any liability with regard to the above information or with regard to any verbal recommendation, except for cases where we are liable of gross negligence or false intention.
This datasheet replaces all former versions.

Reference 0.0

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