

UNI-REZ™ 2291 Hot Melt Polyamide Adhesive

PRODUCT DATA SHEET

UNI-REZ 2291 hot melt polyamide resin is based on dimer acids. This tough, flexible resin is recommended for bonding plastics (including plasticized PVC and ABS) and pre-heated metals. UNI-REZ 2291 is soluble in n-propanol and can be applied as a thin film when cut into a 25% solids solution.

FEATURES:

- Heat resistance
- Adhesion to plastic including plasticized PVC
- Good hot melt stability
- Good solution stability in n-propanol
- Chemical and grease resistance

POTENTIAL APPLICATIONS:

- Automotive air filter construction
- Lamination
- Multipurpose assembly

SPECIFICATION

Property	Test Method*	Typical Value
Softening Point °C, Ring & Ball	ASTM E28 (AQCM 003)	129 - 141
Viscosity, Gardner-Holdt of Resin Solution in 40% n-propanol	AQCM 042	X – Z2
Color LICO, 40% in n-propanol	AQCM 002	7 max

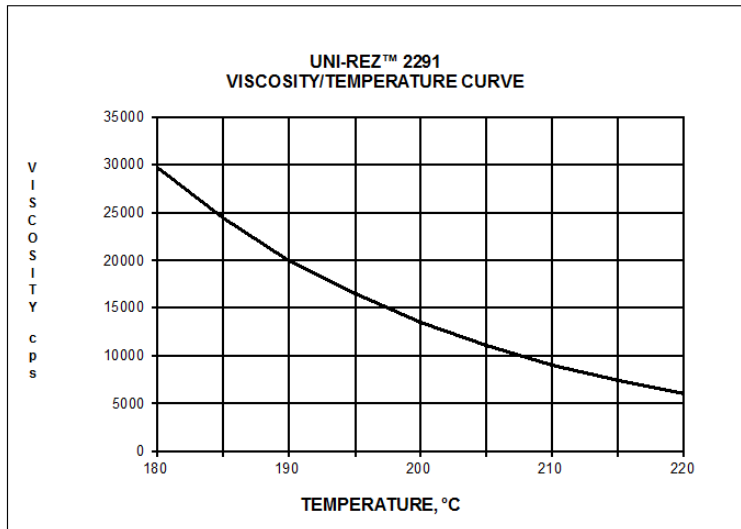
TYPICAL VALUES

Property	Test Method*	Typical Value
Softening Point °C, Ring & Ball	ASTM E28 (AQCM 003)	135
Viscosity LVT Brookfield, Spindle #31, cps/mPa.s @ 205°C	ASTM D3236 (AQCM 146)	12500
Acid Value mg KOH/g	AQCM 001	1.2
Amine Value mg KOH/g	AQCM 069	4.2
Color 40% in n-Butanol, Gardner	AQCM 002	4
Moisture Quintel Moisture Analyzer, %	AQCM 056	0.2
Tensile Strength psi (MPa)	ASTM D1708	750 (6.2)
Elongation %	ASTM D1708	600
Tensile Modulus psi (MPa)	ASTM D638	4000 (28)
Peel Strength pli (N/25mm), plasticized PVC to itself	ASTM D1876	50 (220)
Mandrel Bend Flexibility (1" diameter), pass, °C	ASTM D3111	-20
Open Time seconds, 10 mil film	ASTM D4497	20-25
Shore A and D Hardness	ASTM D2240-97	A82 / D31
Flash Point °C, COC	ASTM D92-16	271 (520°F)

*Kraton test methods are available upon request

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HOT MELT STABILITY	UNI-REZ 2291 hot melt polyamide adhesive may be exposed to air for up to 3 hours at 210°C (410°F) or 5 hours at 190°C (374°F) without skin formation or significant viscosity increase. A nitrogen blanket is essential for longer melt pot residence times.
SOLUBILITY	UNI-REZ 2291 hot melt polyamide adhesive is designed to be used as a hot melt. However, if this polyamide should need to be cut into a solvent for testing the recommended solvents include n-butanol, n-propanol or a 50/50 blend of isopropyl alcohol and toluene.
PACKAGING	UNI-REZ 2291 hot melt polyamide adhesive is in pellet form, packaged in poly-foil lined multi-wall bags, 40 or 50 lb. net.
STORAGE RECOMMENDATION	This product will slowly absorb moisture from the air, which may cause foaming when the resin is melted and could result in inadequate bonds. Partially used containers should be closed tightly or the remaining resin transferred into an airtight container and kept in a cool, dry area.

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