

UNI-REZ™ 2671 Hot Melt Polyamide Adhesive

PRODUCT DATA SHEET

UNI-REZ 2671 hot melt polyamide adhesive is a resin based on dimer acid. UNI-REZ 2671 hot melt polyamide adhesive has excellent green strength, chemical resistance and adhesion to PVC.

FEATURES:

- Heat resistance
- High green strength
- Adhesion to plastic including plasticized PVC
- High chemical and humidity resistance

POTENTIAL APPLICATIONS:

- Packaging
- Multipurpose assembly

SALES SPECIFICATIONS

| Property | Test Method* | Specification |
|--|-----------------------|---------------|
| Softening Point (°C), Ring & Ball | ASTM E28 (AQCM 003) | 155 - 165 |
| Viscosity LVT Brookfield, Spindle #31, cps/mPA.s 190°C | ASTM D3236 (AQCM 146) | 6000 - 9500 |
| Color, 40% in n-Butanol, Gardner | AQCM 002 | Max. 6 |

*Kraton test methods are available upon request

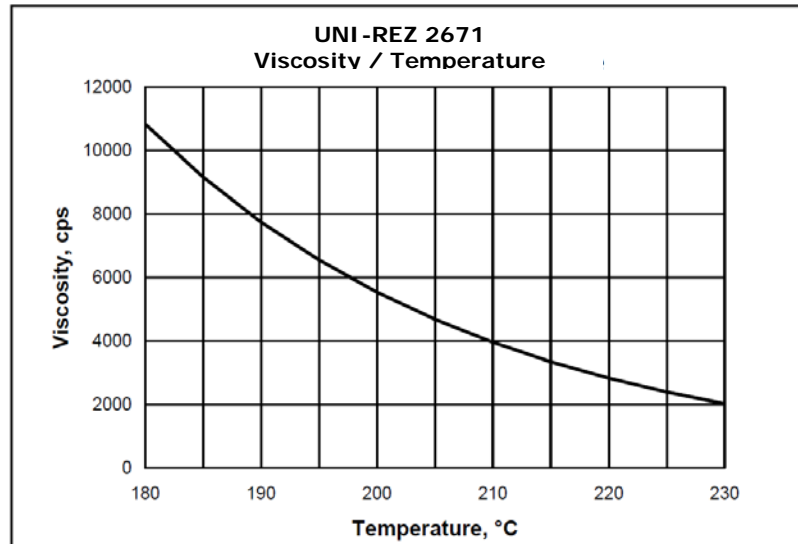
TYPICAL VALUES

| Property | Test Method* | Typical Value |
|---|---------------|---------------|
| Acid Value mg KOH/g | AQCM 001 | 10.0 |
| Amine Value mg KOH/g | AQCM 139 | 0.4 |
| Color 40% in n-Butanol, Gardner | AQCM 002 | 4+ |
| Moisture Quintel Moisture Analyzer, % | AQCM 056 | 0.12 |
| Tensile Strength psi (MPa) | ASTM D1708 | 1000 (6.9) |
| Elongation % | ASTM D1708 | 500 |
| Tensile Modulus psi (MPa) | ASTM D638 | 12500 (86) |
| Peel Strength pli (N/25mm), plasticized PVC to itself | ASTM D1876 | 15 (66) |
| Mandrel Bend Flexibility (1" diameter), pass, °C | ASTM D3111 | -10 |
| Open Time seconds, 10 mil film | ASTM D4497 | 5-10 |
| Shear Adhesion Failure Temp (SAFT), 1 kg. wt. °C | ASTM D4498 | 135 |
| Shore A and D Hardness | ASTM D2240-97 | A80 / D35 |
| Water Absorption % after 24 hours | ASTM D570 | 0.8 |
| Water Absorption % after 7 days | ASTM D570 | 1.9 |
| Pounds per gallon (g/cc), 25°C | ASTM D792 | 8.2 (9.8) |
| Flash Point °C, COC | ASTM D92-16 | 271 (520°F) |

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|-------------------------------|---|
| HOT MELT STABILITY | UNI-REZ 2671 hot melt polyamide adhesive may be exposed to air for up to 3 hours at 210°C (410°F) or 7 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 2671 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 2671 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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