

UNI-REZ™ 2678 Hot Melt Polyamide Adhesive

PRODUCT DATA SHEET

UNI-REZ 2678 hot melt polyamide adhesive is a resin based on dimer acid. UNI-REZ 2678 hot melt polyamide adhesive has good low temperature flexibility and adhesion to various plastic substrates.

FEATURES:

- Excellent high/low temperature cycling
- Adhesion to plastics including plasticized PVC
- Moderate open time
- Low temperature flexibility

POTENTIAL APPLICATIONS:

- Cabinet assembly
- Converting/ packaging
- Multipurpose assembly
- Low pressure molding

SALES SPECIFICATIONS

Property	Test Method*	Specification
Softening Point (°C), Ring & Ball	ASTM E28 (AQCM 003)	135 - 150
Viscosity LVT Brookfield, Spindle #31, cps/mPA.s 190°C	ASTM D3236 (AQCM 146)	3000 - 5550
Color, 40% in n-Butanol, Gardner	AQCM 002	Max. 7

*Kraton test methods are available upon request

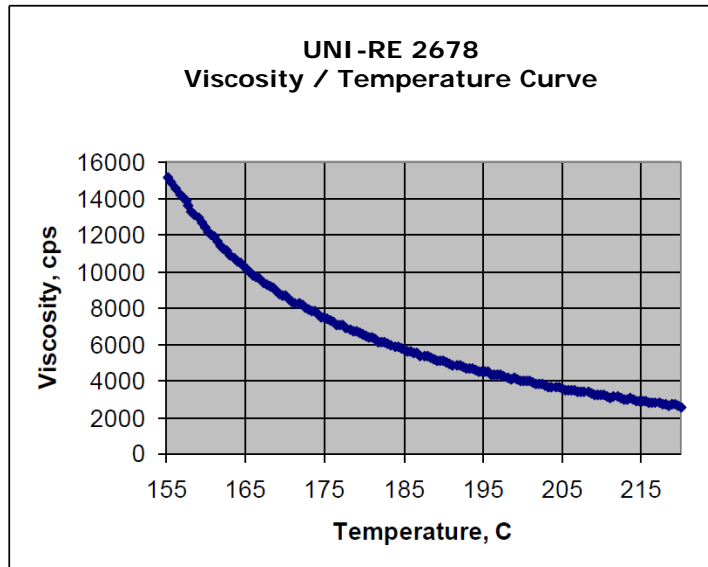
TYPICAL VALUES

Property	Test Method*	Typical Value
Acid Value mg KOH/g	AQCM 001	0.8
Amine Value mg KOH/g	AQCM 139	7.8
Color 40% in n-Butanol, Gardner	AQCM 002	5+
Moisture Quintel Moisture Analyzer, %	AQCM 056	0.30
Tensile Strength psi (MPa)	ASTM D1708	275 (1.9)
Elongation %	ASTM D1708	170
Tensile Modulus psi (MPa)	ASTM D638	5000 (34)
Peel Strength pli (N/25mm), plasticized PVC to itself	ASTM D1876	15 (66)
Mandrel Bend Flexibility (1" diameter), pass, °C	ASTM D3111	-40
Open Time seconds, 10 mil film	ASTM D4497	20
Shear Adhesion Failure Temp (SAFT), 1 kg. wt. °C	ASTM D4498	130
Shore A and D Hardness	ASTM D2240-97	A74 / D22
Water Absorption % after 24 hours	ASTM D570	1.0
Water Absorption % after 7 days	ASTM D570	2.2
Pounds per gallon (g/cc), 25°C	ASTM D792	8.2 (0.98)
Flash Point °C, COC	ASTM D92-16	271 (520°F)

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HOT MELT STABILITY	UNI-REZ 2678 hot melt polyamide adhesive may be exposed to air for up to 5 hours at 210°C (410°F) or 10 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 2678 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 2678 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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