

TYPE:

Polyamide Hot Melt Adhesive

PHYSICAL PROPERTIES:

Viscosity	500-1000 cps. at 190°C (375°F)
Color	Clear Amber
Ring & Ball Softening Point	165-180°C (329-356°F)
Open Time	Moderate-Long (60-80 seconds)
Application Temperature	190-205°C (375-401°F)
Color Gardner	8 Maximum
2% Modulus, psi	5,300
% Elongation	120
Ultimate Tensile Strength	460 psi
Yield Strength	600 psi
Water Absorption	2.6% after 1 day, 8.4% after 7 days
Temperature Creep Resistance	140-160°C (284-320°F)
Shore A Hardness	86

Characteristics

TECHNOMELT PA 2157 is a polyamide hot melt adhesive. It is a unique hot melt with excellent heat resistance and low viscosity immediately above the softening point. This product is particularly well suited for bonding metals, elastomers, phenolics, and reinforced polyesters. In the foundry industry, it works well for bonding sand cores due to its good flow characteristics, relatively long open time and heat resistance.

TECHNOMELT PA 2157 is manufactured from ingredients regulated under the FDA Code of Federal Regulations 175.105 (adhesives) and 175.300 (side seam cements). Underwriter's Laboratories recognize TPX 16-157 as having a flammability rating of 94 V-O. This product is supplied in round bead form.

HANDLING:

TECHNOMELT PA 2157 resin will pick up moisture from the air. This will not be obvious in the solid form but could cause foaming as it is melted. Foaming could cause poor bonds. Close container tightly as soon as sufficient product has been removed for immediate use.

PRECAUTIONS:

No health hazards are expected with this product in its solid form. Once melted, it is like any hot liquid in that it can produce severe burns. Care should be taken to avoid getting the hot liquid adhesive on the skin. If this occurs, flush the affected area with large amounts of cold water. Do not try to remove solidified adhesive from the skin. Seek Medical Attention immediately. Please refer to the Material Safety Data Sheet for further information. Safety glasses and insulated gloves are recommended for normal use conditions.

Storage Conditions:

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 one year.

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

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