TECHNICAL – INFORMATION

Exakt Polyamide 162-FO

Product Description: Exakt Polyamide 162–FO provides following product characteristics:

Technology	Polyamide
Product Type	Hotmelt
Cure	Physical setting
Condition	Thermoplastic
Components	One component
Application	General assembly
Color	Amber

Application Areas: Exakt Polyamide 162–FO is used for molding, filter and other general assembly applications.
This product has good adhesion to a variety of substrates including fabrics, leather, metals, wood, ABS and flexible vinyl.

Technical Data:

Density, g/m³:	0.98 ISO 1183-1 20 °C
Softening point, °C:	150 – 160 ASTM E28 (in glycerine)
Melting Viscosity at 190 °C, mPas:	6500
Melting Viscosity at 200 °C, mPas:	4800
Melting Viscosity at 210 °C, mPas:	2800 – 4000
Melting Viscosity at 220 °C, mPas	2700
ASTM D 3236 (RVT, spindle 27)	
Temperature creep resistance, °C	130
Bickers method MH 11	
Yield strength, N/mm²	3.3
ISO	527,
Specimen	no.5
Cross-head-speed:	50mm/min
Break Strength, N/mm²	3.6
ISO	527
Specimen	no.5
Cross-head-speed:	50mm/min
Elongation, %	600
ISO	527
Specimen no.5	
Cross-head-speed:	50mm/min
Shore A hardness	82
ISO	868/15s
Low temperature flexibility, °C	-40
ASTM D	3111
Flammability	V – 0
UL	94

DIRECTIONS FOR USE:

Prelimnary 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: 180 – 230 °C

Application system:

hotmelt application systems:
When bonding to a substrate with high thermal conductivity the use of 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 90 °C, but not longer than 72h. 162–FO Polyamid may absorb moisture from the air. This will not be apperant 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.
Immediately after joining, keep the parts pressed together until the bonded join is held by adhesive itself. The time which this requires is lagerly dependent on the recovery of the material to be bonded. If the join is parted even by some tenths of millimeters during the binding stage, a ridge is formed which leads to reduced load capacity of the join.

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 Exakt Cleaner 100-NL.

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.

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