

# Macromelt 6208

Hotmelt adhesive for potting

Basis: Polyamide

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## Product Description

Macromelt 6208 is an amber-coloured, polyamide-based hotmelt adhesive.

## Application Areas

Macromelt 6208 is used for potting and general assembly applications, especially on wood and plastics in particular. In the filter industry the adhesive is used for securing the longitudinal seams of filter bags and for adhering revenue stamps to polyester-coated paper and needle felt. In addition, it is used for bonding fabric tapes to one another and paper filters into plastic frames (Novadur).

## Technical Data

Colour:	amber
Solids content:	100 %
Density:	ca. 0,98 g/cm <sup>3</sup>
Melting viscosity according to ASTM D 3236	
at 190°C:	6.500 ± 1.500 mPa.s
at 200°C:	4.800 ± 1.000 mPa.s
at 210°C:	3.500 ± 800 mPa.s
at 220°C:	2.700 ± 600 mPa.s
Equipment:	Brookfield Thermosel, Spindle 27
Softening point according to ASTM E 28:	155 ± 5°C
Application temperature:	180–230°C
Low temperature flexibility ASTM D 3111: -	-40°C
Temperature creep–resistance:	130 ± 5°C
Yield strength DIN 53455:	3,3 ± 0,5 MPa
Tensile shear strength DIN 53455	3,4 ± 0,5 MPa
Tensile strength at rupture:	3,6 ± 0,5 MPa

## Processing

### Preliminary statement

Prior to application it is necessary to read the **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

Use hotmelt adhesive applicators to process Macromelt 6208. The usual processing range is between 180 and 230°C.

While processing, take care to maintain a gentle thermal load by keeping to the recommended working temperature. Avoid overheating above the given processing temperature since, if prolonged or repeated, it may lead to reduction of quality and - in extreme cases - to carbonization of the hotmelt adhesive.

Do not leave the melted adhesive in the applicator for several hours at processing temperature without extraction. During breaks in work the temperature of the hotmelt adhesive should be lowered to approx. 90°C in the entire applicator, but not for longer than 72 hours. Refill the quantity of granules used, taking care that the melting pan is filled. Avoid loading with wet material (due to uptake of moisture from the air) since moist hotmelt adhesive tends to foam. This causes a foam-like structure of poor solidity when cooled. Therefore, be sure to close the container tightly again after extraction.

Apply the adhesive as closely as possible to the side where the parts to be bonded are joined and in a thickness ensuring complete and intensive coating of both surfaces. When joining materials of different adhesive properties apply the adhesive to the surface which is more difficult to join if possible. If this is not possible, it is advisable to raise the application temperature or increase the thickness of the adhesive layer applied. Also, the stated processing temperature should be maintained as otherwise sufficient coating - particularly of substrates with good heat conductivity - is not ensured.

Immediately after joining, keep the parts pressed together until the bonded joint is held by the adhesive itself. The time which this requires is largely dependent on the recovery of the material to be bonded. If the joint is parted even by some tenths of millimeters during the binding stage, a ridge is formed which leads to reduced load capacity of the joint.

## Storage

Frost-sensitive	no
Recommended storage temp.	10°C to 20°C
Shelf-life	24 months in original packaging

## Packaging

Sack	20 kg
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<b>Hazard Indications/ Safety Recommendations/ Transport Regulations</b>	see Safety Data Sheet
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## Important

The above data, particularly the recommendations for application and use of our products is based on our knowledge and experience. Due to different materials and conditions of application which are beyond our knowledge and control we strongly recommend carrying out sufficient tests in order to ensure that our products are suitable for the intended process and applications. Except for willful acts any liability based on such recommendations or any oral advice is hereby expressly excluded.

**This Technical Data Sheet supersedes all previous editions.**

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