

Macromelt 6797

Hotmelt adhesive
for general assembly application

Basis: Polyamide

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Product Description

Macromelt 6797 is a hotmelt adhesive, based on Polyamide.

Application Areas

Macromelt 6797 is used for general assembly applications, especially in filter industry.

Technical Data

		Method
Colour:	amber	
Solids:	100%	
Softening Point (R & B):	120 °C	ASTM E 28
Viscosity (Brookfield, Spindle 27)		
at 160°C:	12.500 mPa.s	ASTM D 3236
at 190°C:	3.500 mPa.s	ASTM D 3236
Low temperature flexibility:	-20 °C	ASTM D 3111
Yield strength:	1,2 N / mm ²	DIN 53455
Tensile strength:	1,3 N / mm ²	
Break strength:	0,7 N / mm ²	
Temperature creep-resistance:	85 °C	Henkel MH11
Application temperature:	180 – 220°C	

Application

Preliminary remark

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 labelling, the relevant precautions should always be observed.

Preparation

The substrates must be dry, free of oil, grease and dust.



Application

Macromelt 6797 is used with application system for hotmelt adhesives. The usual processing range is between 180 and 220°C.

While processing, take care to maintain a gentle thermal load by keeping to the recommended working temperature, since prolonged overheating or too often repeated melting will inevitably entail quality changes in the adhesive. The stated processing temperatures are standard values which, according to the processing method, may vary within certain limits.

Apply the adhesive as closely as possible to the site 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.

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

Cleaning

For the cleaning of the application equipment we recommend to use our cleaner Macromelt XS 0062.

Storage

Frost-sensitive	No
Recommended storage temp.	10°C to 35°C
Shelf-life	12 months

Packaging

Bag	20 kg
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Hazard Indications/ Safety Recommendations/ Transport Regulations	see Safety Data Sheet
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Important

The above data, particularly the recommendations for application and use of our products are based on our knowledge and experience. Due to the different materials and conditions of application which are beyond our knowledge and control we recommend strongly to carry out sufficient tests in order to ensure that our products are suitable for the intended processes 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.

Henkel KGaA . 40191 Duesseldorf
Vertrieb: Henkel Teroson GmbH . 69112 Heidelberg - Germany
Tel.: +49-6221-704-0 . Fax +49-6221-705-242
industrial-adhesives@henkel.com . www.industrial-adhesives.com