



Product Data Sheet

Revision Date: 08-10-2010

UNI-REZ[®] 2635

HOT MELT POLYAMIDE ADHESIVE

FEATURES

- Chemical and grease resistance
- Moderate to long open time
- Low temperature flexibility
- Excellent high / low temperature cycling
- Good adhesion to plastic including plasticized PVC
- FDA approval 175.105

APPLICATIONS

- Cabinet and furniture assembly
- Multipurpose assembly
- Adhesion to preheated metals

PROPERTIES	SPECIFICATIONS
Softening Point , °C, Ring & Ball, ASTM E 28	135-145
Viscosity , LVT Brookfield, Spindle # 31, cps/mPa.s at 190°C, ASTM D 3236	3000-4700
Color , 40% in n-Butanol, Gardner	7 Maximum
	TYPICAL VALUES
Acid Value , mg KOH/g	0.9
Amine Value , mg KOH/g	7.5
Color , 40% in n-Butanol, Gardner	5
Tensile Strength , psi (MPa), ASTM D 1708	280 (1.9)
Elongation , %, ASTM D-1708	200
Tensile Modulus , psi (MPa), ASTM D 638	3000 (21)
Peel Strength , pli (N/25mm), plasticized PVC to itself, ASTM D 1876	20 (88)
Mandrel Bend Flexibility , (1" diameter), pass, °C, ASTM D 3111	-30
Open Time , sec., 10 mil film, ASTM D 4497	25
Shear Adhesion Failure Temperature (SAFT) , 1 kg. wt. °C, ASTM D 4498	130
Water Absorption , ASTM D-570: after 24 hours, % after 7 days, %	1.70 3.11
Pounds per Gallon , (g/cc), 25°C	8.0 (0.96)
Flash Point , °C, COC	271 (520°F)

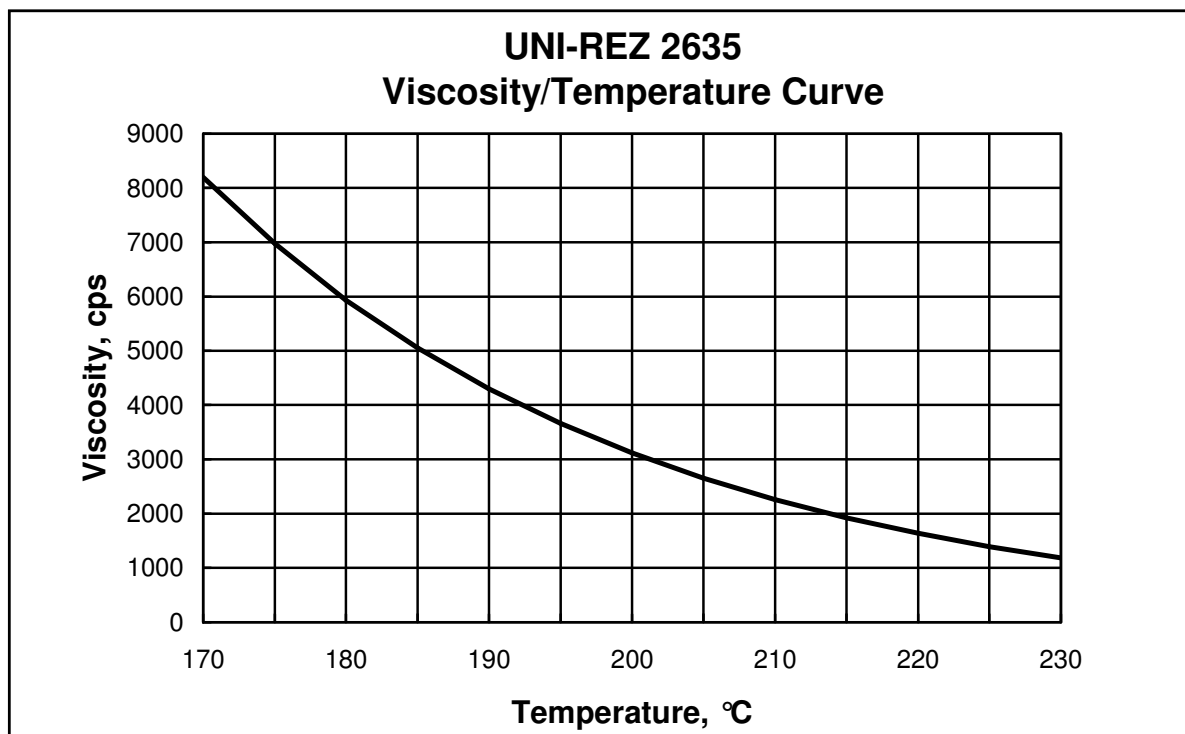


Technical Service: Savannah, GA (912) 238-6556
Sales Service: Jacksonville, FL - (800) 733-1374

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Hot Melt Stability:	Molten UNI-REZ 2635 may be exposed to air for up to 4 hours at 210°C (410°F) or 8 hours at 190°C (374°F) without skin formation or significant viscosity increase. A nitrogen blanket is essential for longer melt pot residence times.
Handling and storage:	UNI-REZ 2635 will slowly absorb moisture from the air, which may cause foaming when the resin is melted and may result in inadequate bonds. Partially used containers should be closed tightly or the remaining resin should be transferred into an airtight container and kept in a cool, dry area.
FDA Status:	UNI-REZ 2635 meets the ingredient requirements of the following section of the Code of Federal Regulations, Title 21 when used according to the regulations and any limitations that may apply: 175.105 Adhesives
TSCA Status:	UNI-REZ 2635 is listed on the TSCA inventory.
DOT Shipping Classification:	Non-hazardous.
Shipping:	UNI-REZ 2635 is available in pellet form, packaged in poly-foil lined multi-wall bags, 50 lb. net.

8/10



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