



# Product Data Sheet

## UNI-REZ<sup>®</sup> 2638

### HOT MELT POLYAMIDE ADHESIVE

#### FEATURES

- Excellent high / low temperature cycling
- Adhesion to plastics including plasticized PVC
- Moderate to long open time
- Low temperature flexibility
- FDA approval 175.105

#### APPLICATIONS

- Cabinet assembly
- Converting / packaging
- Multipurpose assembly
- Low pressure molding

PROPERTIES	SPECIFICATIONS
<b>Softening Point</b> , °C, Ring & Ball, ASTM E 28	135-150
<b>Viscosity</b> , LVT Brookfield, Spindle # 31, cps/mPa-s at 190°C, ASTM D 3236	3500-5500
<b>Color</b> , 40% in n-Butanol, Gardner	7 Maximum
	TYPICAL VALUES
<b>Acid Value</b> , mg KOH/g	0.8
<b>Amine Value</b> , mg KOH/g	10
<b>Color</b> , 40% in n-Butanol, Gardner	5
<b>Tensile Strength</b> , psi (MPa), ASTM D 1708	200 (1.4)
<b>Elongation</b> , %, ASTM D-1708	200
<b>Tensile Modulus</b> , psi (MPa), ASTM D 638	4500 (31)
<b>Peel Strength</b> , pli (N/25mm), plasticized PVC to itself, ASTM D 1876	20 (88)
<b>Mandrel Bend Flexibility</b> (1" diameter), pass, °C, ASTM D 3111	-30
<b>Open Time</b> , sec., 10 mil film, ASTM D 4497	20
<b>Shear Adhesion Failure Temperature (SAFT)</b> , 1 kg. wt. °C, ASTM D 4498	130
<b>Water Absorption</b> , ASTM D-570: after 24 hours, % after 7 days, %	1.0 2.2
<b>Pounds per Gallon</b> , (g/cc), 25°C	8.2 (0.98)
<b>Flash Point</b> , °C, COC	271 (520°F)

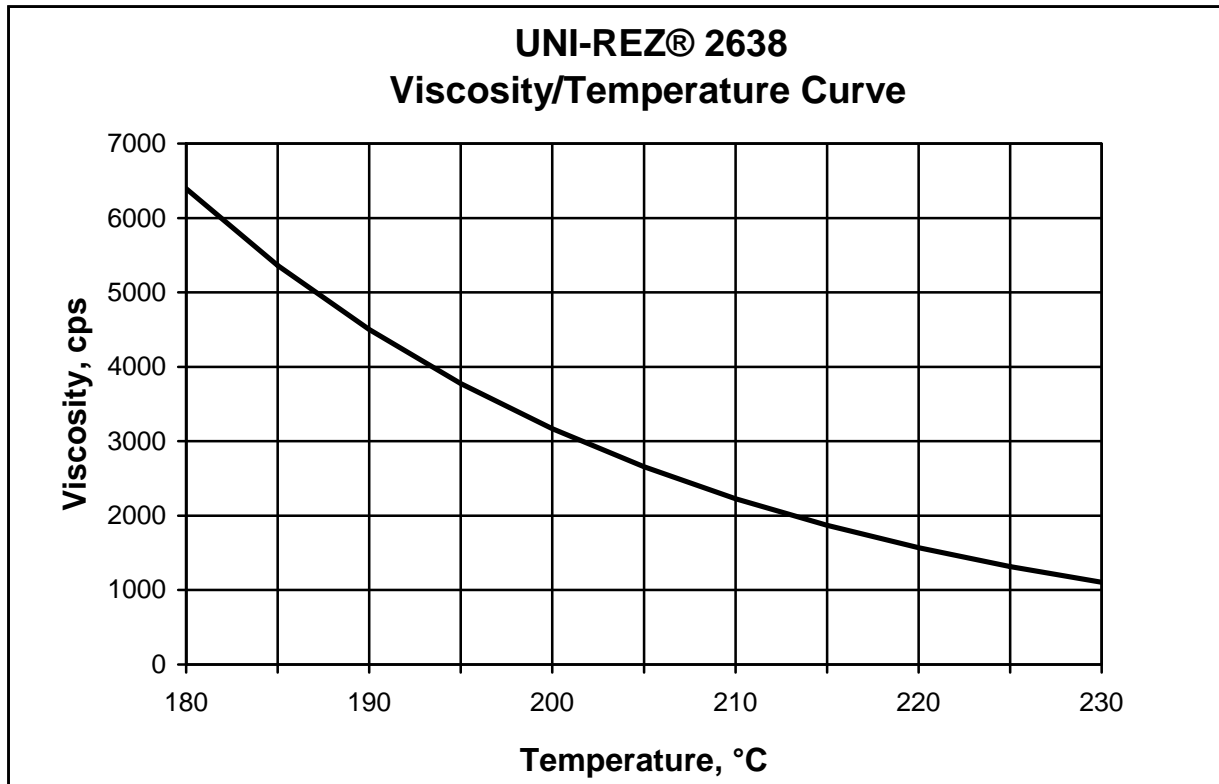


Technical Service: Savannah, GA (912) 238-6556  
Sales Service: Jacksonville, FL - (800) 733-1374

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<b>Hot Melt Stability:</b>	Molten <b>UNI-REZ® 2638</b> may be exposed to air for up to 5 hours at 210°C (410°F) or 12 hours at 190°C (374°F) without skin formation or significant viscosity increase. A nitrogen blanket is essential for longer melt pot residence times.
<b>Handling and storage:</b>	<b>UNI-REZ® 2638</b> 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.
<b>FDA Status:</b>	<b>UNI-REZ® 2638</b> 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
<b>TSCA Status:</b>	<b>UNI-REZ® 2638</b> is listed on the TSCA inventory.
<b>DOT Shipping Classification:</b>	Non-hazardous.
<b>Shipping:</b>	<b>UNI-REZ® 2638</b> is available in pellet form, packaged in poly-foil lined multi-wall bags, 50 lb. net.

9/03



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