



Product Data Sheet

UNI-REZ[®] 2641

HOT MELT POLYAMIDE ADHESIVE

FEATURES

- Heat resistance
- Adhesion to plastic including plasticized PVC
- Light color
- Good hot melt stability
- Chemical and grease resistance
- FDA approval 175.105

APPLICATIONS

- Packaging
- Automotive
- Multipurpose assembly

PROPERTIES	SPECIFICATIONS
Softening Point , °C, Ring & Ball, ASTM E 28	135-150
Viscosity , LVT Brookfield, Spindle # 31, cps/mPa·s at 190°C, ASTM D 3236	6000-11000
Color , 40% in n-Butanol, Gardner	7 Maximum
	TYPICAL VALUES
Acid Value , mg KOH/g	10
Amine Value , mg KOH/g	0.6
Color , 40% in n-Butanol, Gardner	4-
Tensile Strength , psi (MPa), ASTM D 1708	520 (3.6)
Elongation , %, ASTM D-1708	700
Tensile Modulus , psi (MPa), ASTM D 638	7000 (48)
Peel Strength , pli (N/25mm), plasticized PVC to itself, ASTM D 1876	30 (131)
Mandrel Bend Flexibility , (1" diameter), pass, °C, ASTM D 3111	-10
Open Time , sec., 10 mil film, ASTM D 4497	40
Shear Adhesion Failure Temperature (SAFT) , 1 kg. wt. °C, ASTM D 4498	130
Water Absorption , ASTM D-570: after 24 hours, % after 7 days, %	0.6 1.6
Pounds per Gallon , (g/cc), 25°C	8.2 (0.98)
Flash Point , °C, COC	271 (520°F)

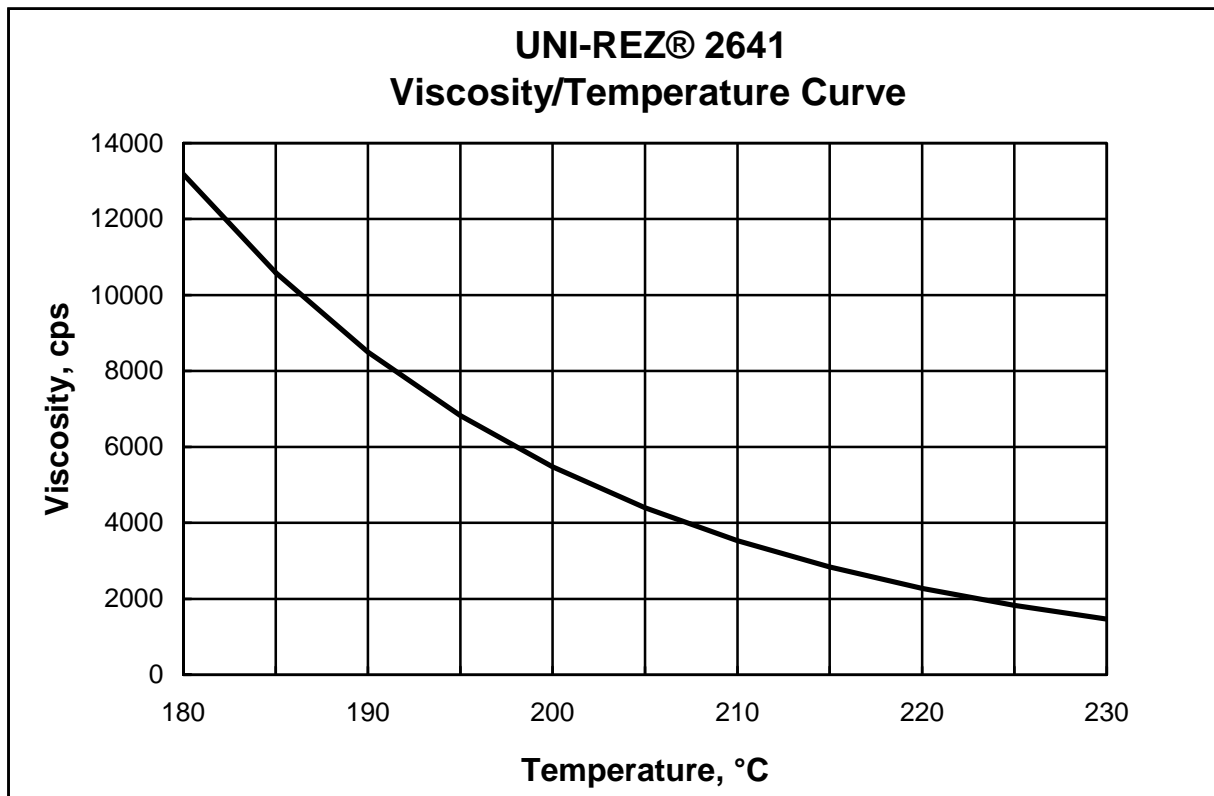


Technical Service: Savannah, GA (912) 238-6556
Sales Service: Jacksonville, FL - (800) 733-1374

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Hot Melt Stability:	Molten UNI-REZ® 2641 may be exposed to air for up to 5 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® 2641 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® 2641 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® 2641 is listed on the TSCA inventory.
DOT Shipping Classification:	Non-hazardous.
Shipping:	UNI-REZ® 2641 is available in pellet form, packaged in poly-foil lined multi-wall bags, 50 lb. net and poly-foil lined fiber drums, 212 lb. net.

9/03



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