



Product Data Sheet

UNI-REZ[®] 2646

HOT MELT POLYAMIDE ADHESIVE

FEATURES

- Chemical and grease resistance
- Flexibility
- Fast set
- Adhesion to plastics
- FDA approval 175.105 and 175.320

APPLICATIONS

- Laminating
- Packaging
- Converting

PROPERTIES	SPECIFICATIONS
Softening Point , °C, Ring & Ball, ASTM E 28	115-128
Viscosity , LVT Brookfield, Spindle # 31, cps/mPa·s at 190°C, ASTM D 3236	2500-3500
Color , 40% in n-Butanol, Gardner	7 Maximum
	TYPICAL VALUES
Acid Value , mg KOH/g	1.0
Amine Value , mg KOH/g	6.5
Color , 40% in n-Butanol, Gardner	5+
Tensile Strength , psi (MPa), ASTM D 1708	600 (4.1)
Elongation , %, ASTM D-1708	350
Tensile Modulus , psi (MPa), ASTM D 638	14000 (96)
Peel Strength , pli (N/25mm), plasticized PVC to itself, ASTM D 1876	20 (88)
Mandrel Bend Flexibility , (1" diameter), pass, °C, ASTM D 3111	-10
Open Time , sec., 10 mil film, ASTM D 4497	10
Shear Adhesion Failure Temperature (SAFT) , 1 kg. wt. °C, ASTM D 4498	110
Water Absorption , ASTM D-570: after 24 hours, % after 7 days, %	0.6 1.8
Pounds per Gallon , (g/cc), 25°C	8.1 (0.97)
Flash Point , °C, COC	271 (520°F)

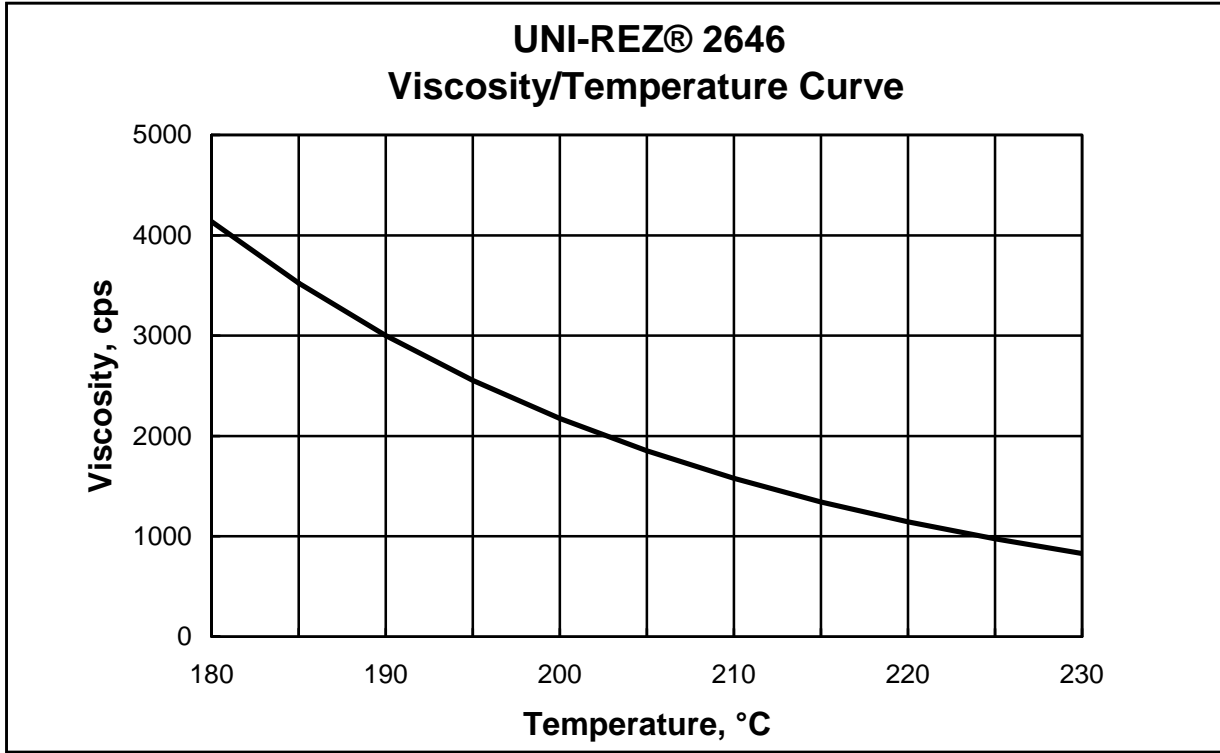


Technical Service: Savannah, GA (912) 238-6556
Sales Service: Jacksonville, FL - (800) 733-1374

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Hot Melt Stability:	Molten UNI-REZ® 2646 may be exposed to air for up to 1 hour 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® 2646 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® 2646 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 175.320 Resinous and Polymeric Coatings for Polyolefin Films (For use only in coatings for polypropylene films that contact food at temperatures not to exceed room temperature).
TSCA Status:	UNI-REZ® 2646 is listed on the TSCA inventory.
DOT Shipping Classification:	Non-hazardous.
Shipping:	UNI-REZ® 2646 is available in pellet form packaged in poly-foil lined multi-wall bags, 50 lb. net.

9/03



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UNI-REZ® 2646

POLYAMIDE RESIN For Printing Ink Applications

UNI-REZ® 2646 POLYAMIDE RESIN is a medium molecular weight polyamide designed to provide laminating inks with a combination of excellent adhesion and good viscosity stability. It has good alcohol solubility, low odor and the fast solvent release needed to obtain a low level of retain solvent in laminates.

TYPICAL PROPERTIES

Softening Point, Ring & Ball, °C	125
Viscosity, 40% in n-Propanol, 25°C Gardner	V – W
Viscosity, 20% in n-Propanol, 25°C Gardner	A – B
Gardner Color, 40% in n-Propanol	5 – 6
Melt Viscosity, Brookfield, cps at 190°C	2910
Acid Number	<2
Amine Number	<5

FDA Status:	<p>UNI-REZ® POLYAMIDE RESIN meets the requirements of the Code of Federal Regulations, Title 21, under the following sections:</p> <p>175.105 Adhesives 175.320 Coatings for Polyolefin Films</p>
DOT Shipping Classification:	Non-hazardous.
Shipping:	Pellet form, packaged in multi-wall bags, 50 lbs. net.
Storage:	The shelf life of this product can be extended by storing in a cool, dry area.

08/01



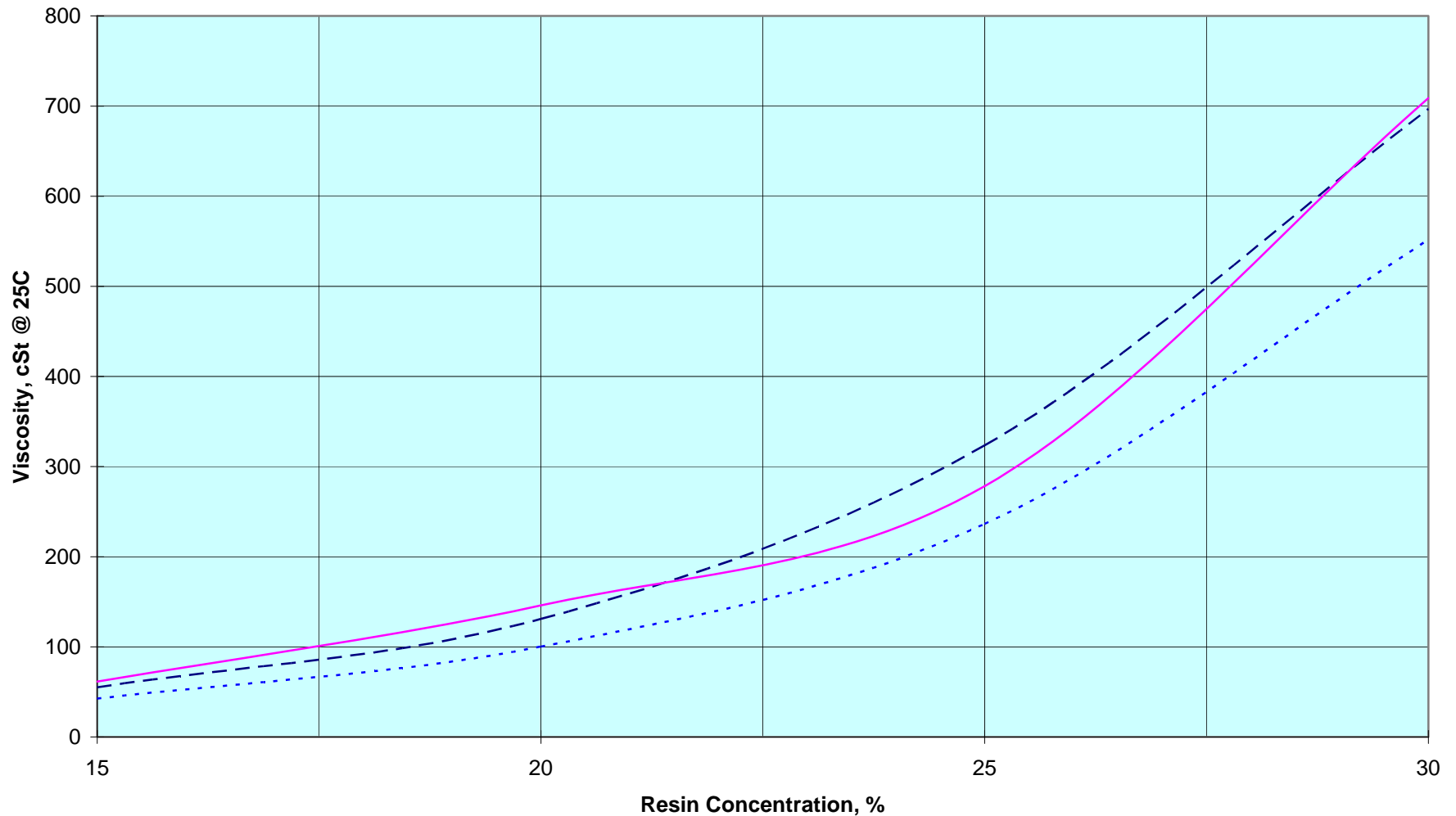
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UNI-REZ® 2646 Solution Properties



--- Isopropanol — n-Propanol - - - Ethanol:IPA, 60:40

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www.arizonachemical.com

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