



# Product Data Sheet

## UNI-REZ<sup>®</sup> 2647

### HOT MELT POLYAMIDE ADHESIVE

#### FEATURES

- Moderate open time
- Flexibility
- Impact resistance
- Adhesion to plastic including plasticized PVC
- Good high / low temperature cycling
- Low fogging index
- FDA approval 175.105

#### APPLICATIONS

- Automotive
- Bonding of preheated metal
- Packaging / converting

PROPERTIES	SPECIFICATIONS
<b>Softening Point</b> , °C, Ring & Ball, ASTM E 28	132-142
<b>Viscosity</b> , LVT Brookfield, Spindle # 31, cps/mPa·s at 190°C, ASTM D 3236	3500-7000
<b>Color</b> , 40% in n-Butanol, Gardner	7 Maximum
	TYPICAL VALUES
<b>Acid Value</b> , mg KOH/g	11
<b>Amine Value</b> , mg KOH/g	0.3
<b>Color</b> , 40% in n-Butanol, Gardner	5
<b>Tensile Strength</b> , psi (MPa), ASTM D 1708	350 (2.4)
<b>Elongation</b> , %, ASTM D-1708	350
<b>Tensile Modulus</b> , psi (MPa), ASTM D 638	5200 (36)
<b>Peel Strength</b> , pli (N/25mm), plasticized PVC to itself, ASTM D 1876	25 (110)
<b>Mandrel Bend Flexibility</b> , (1" diameter), pass, °C, ASTM D 3111	-30
<b>Open Time</b> , sec., 10 mil film, ASTM D 4497	30
<b>Shear Adhesion Failure Temperature (SAFT)</b> , 1 kg. wt. °C, ASTM D 4498	125
<b>Water Absorption</b> , ASTM D-570: after 24 hours, % after 7 days, %	0.9 2.2
<b>Pounds per Gallon</b> , (g/cc), 25°C	8.2 (0.98)
<b>Flash Point</b> , °C, COC	271 (520°F)

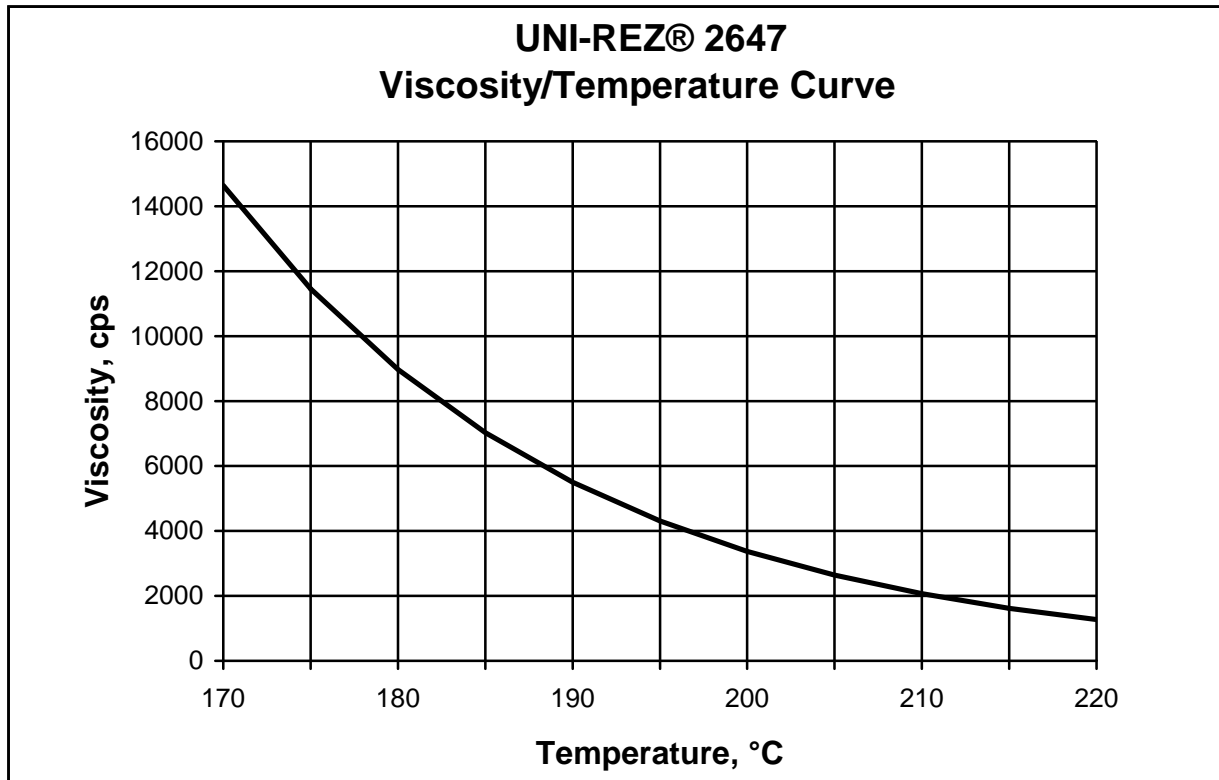


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<b>Hot Melt Stability:</b>	Molten <b>UNI-REZ® 2647</b> may be exposed to air for up to 2 hours at 210°C (410°F) or 6 hours at 190°C (374°F) without skin formation or significant viscosity increase. A nitrogen blanket is essential for longer melt pot residence times.
<b>Handling and storage:</b>	<b>UNI-REZ® 2647</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® 2647</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® 2647</b> is listed on the TSCA inventory.
<b>DOT Shipping Classification:</b>	Non-hazardous.
<b>Shipping:</b>	<b>UNI-REZ® 2647</b> is available in pellet form, packaged in poly-foil lined multi-wall bags, 50 lb. net.

9/03



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