



Product Data Sheet

UNI-REZ® 2671

HOT MELT POLYAMIDE ADHESIVE

FEATURES

- Heat resistance
- High green strength
- High humidity resistance
- Adhesion to plastic including plasticized PVC
- FDA approval 175.105

APPLICATIONS

- Multipurpose assembly
- Packaging

PROPERTIES	SPECIFICATIONS
Softening Point , °C, Ring & Ball, ASTM E 28	155-165
Viscosity , LVT Brookfield, Spindle # 31, cps/mPa-s at 190°C, ASTM D 3236	6000-9500
Color , 40% in n-Butanol, Gardner	6 Maximum
	TYPICAL VALUES
Acid Value , mg KOH/g	9.0
Amine Value , mg KOH/g	0.6
Color , 40% in n-Butanol, Gardner	4
Tensile Strength , psi (MPa), ASTM D 1708	1000 (6.9)
Elongation , %, ASTM D-1708	500
Tensile Modulus , psi (MPa), ASTM D 638	12500 (86)
Peel Strength , pli (N/25mm), plasticized PVC to itself, ASTM D 1876	15 (66)
Mandrel Bend Flexibility , (1" diameter), pass, °C, ASTM D 3111	-10
Open Time , sec., 10 mil film, ASTM D 4497	5-10
Shear Adhesion Failure Temperature (SAFT) , 1 kg. wt. °C, ASTM D 4498	135
Water Absorption , ASTM D-570: after 24 hours, % after 7 days, %	0.8 1.9
Pounds per Gallon , (g/cc), 25°C	8.2 (0.98)
Flash Point , °C, COC	271 (520°F)

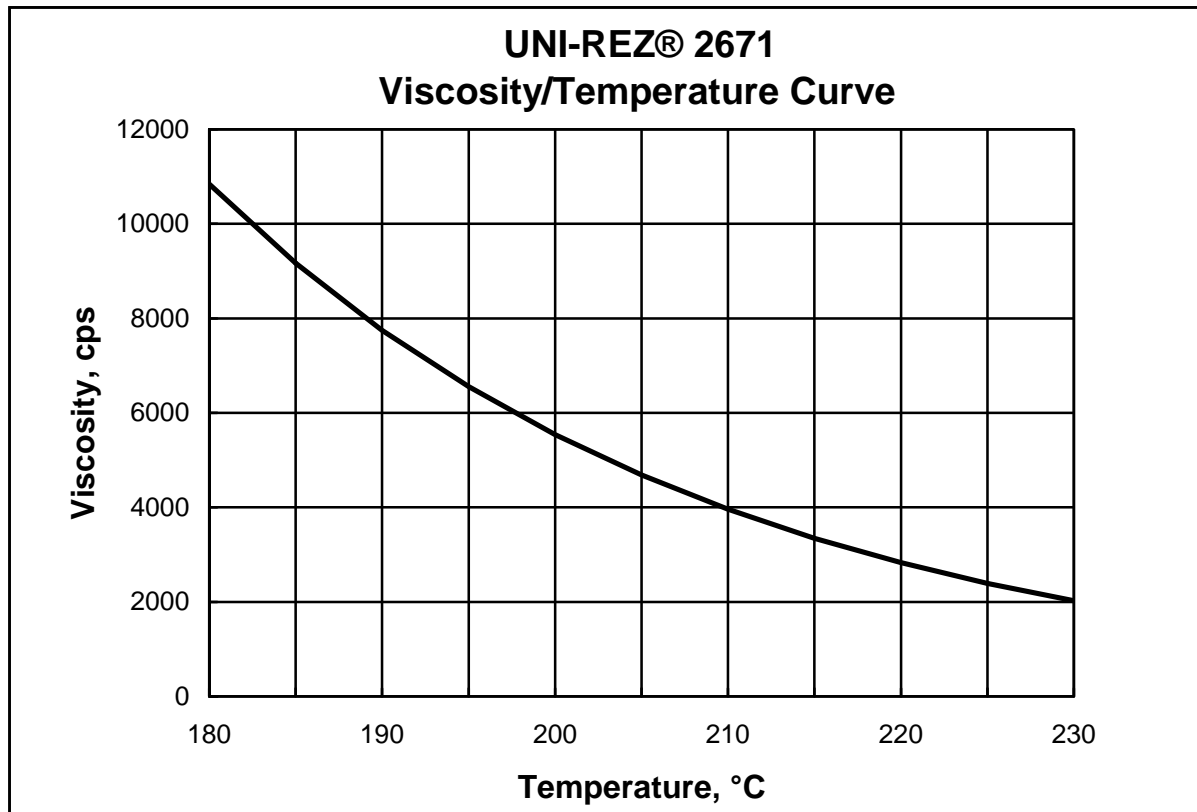


Technical Service: Savannah, GA (912) 238-6556
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Hot Melt Stability:	Molten UNI-REZ® 2671 may be exposed to air for up to 3 hours at 210°C (410°F) or 7 hours at 190°C (374°F) without skin formation or significant viscosity increase. A nitrogen blanket is essential for longer melt pot residence times.
Handling and storage:	UNI-REZ® 2671 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® 2671 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® 2671 is listed on the TSCA inventory.
DOT Shipping Classification:	Non-hazardous.
Shipping:	UNI-REZ® 2671 is available in pellet form, packaged in poly-foil lined multi-wall bags, 50 lb. net.



12/03

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