



Product Data Sheet

UNI-REZ[®] 2678

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
Softening Point , °C, Ring & Ball, ASTM E 28	135-150
Viscosity , LVT Brookfield, Spindle # 31, cps/mPa-s at 190°C, ASTM D 3236	3000-5500
Color , 40% in n-Butanol, Gardner	7 Maximum
	TYPICAL VALUES
Acid Value , mg KOH/g	0.8
Amine Value , mg KOH/g	10
Color , 40% in n-Butanol, Gardner	5
Tensile Strength , psi (MPa), ASTM D 1708	275 (1.9)
Elongation , %, ASTM D-1708	170
Tensile Modulus , psi (MPa), ASTM D 638	6070(41.9)
Peel Strength , pli (N/25mm), plasticized PVC to itself, ASTM D 1876	15.4 (67.4)
Mandrel Bend Flexibility (1" diameter), pass, °C, ASTM D 3111	-35
Open Time , at 190°C, sec., 10 mil film, ASTM D 4497	5
Shear Adhesion Failure Temperature (SAFT) , 1 kg. wt. °C, ASTM D 4498	111
Water Absorption , ASTM D-570: after 24 hours, % after 7 days, %	1.0 2.2
Pounds per Gallon , (g/cc), 25°C	8.2 (0.98)
Flash Point , °C, COC	271 (520°F)



Technical Service: Savannah, GA (912) 238-6558

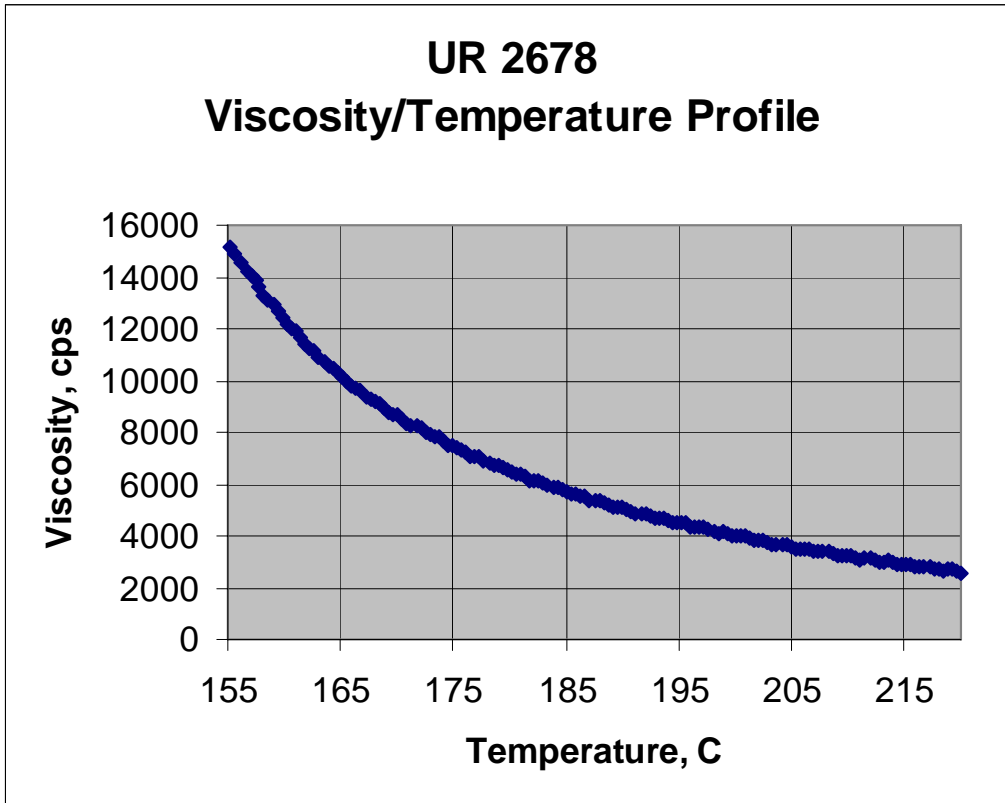
Sales Service: Jacksonville, FL - (800) 733-1374

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Hot Melt Stability:	Molten UNI-REZ 2678 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.
Handling and storage:	UNI-REZ 2678 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 2678 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 2678 is listed on the TSCA inventory.
DOT Shipping Classification:	Non-hazardous.
Shipping:	UNI-REZ 2678 is available in pellet form, packaged in poly-foil lined multi-wall bags, 50 lb. net.

04/10



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