

UNI-REZ™ 2635 Hot Melt Polyamide Adhesive

PRODUCT DATA SHEET

UNI-REZ 2635 hot melt polyamide adhesive is a resin based on dimer acid. UNI-REZ 2635 hot melt polyamide adhesive has good low temperature flexibility and adhesion to various plastic substrates.

FEATURES:

- Chemical and grease resistance
- Moderate to long open time
- Low temperature flexibility
- Excellent high/low temperature cycling
- Good adhesion to plastic, including plasticized PVC

POTENTIAL APPLICATIONS:

- Cabinet and furniture assembly
- Packaging
- Multipurpose Assembly
- Cornerbead

SALES SPECIFICATIONS

Property	Test Method*	Specification
Softening Point (°C), Ring & Ball	ASTM E28 (AOCM 003)	135 - 145
Viscosity LVT Brookfield, Spindle #31, cps/mPA.s 190°C	ASTM D3236 (AOCM 146)	3000 - 4700
Color, 40% in n-Butanol, Gardner	AOCM 002	Max. 7

*Kraton test methods are available upon request

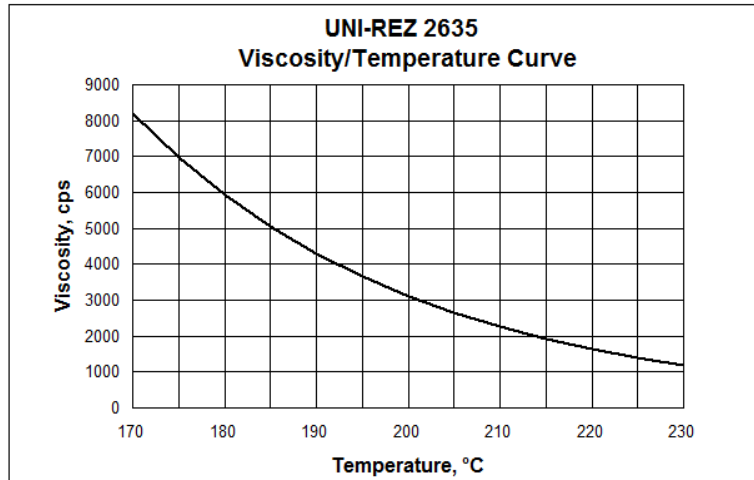
TYPICAL VALUES

Property	Test Method*	Typical Value
Acid Value mg KOH/g	AOCM 001	0.7
Amine Value mg KOH/g	AOCM 139	7.2
Color 40% in n-Butanol, Gardner	AOCM 002	5
Moisture Quintel Moisture Analyzer, %	AOCM 056	0.3
Tensile Strength psi (MPa)	ASTM D1708	280 (1.9)
Elongation %	ASTM D1708	200
Tensile Modulus psi (MPa)	ASTM D638	3000 (21)
Peel Strength pli (N/25mm), plasticized PVC to itself	ASTM D1876	20 (88)
Mandrel Bend Flexibility (1" diameter), pass, °C	ASTM D3111	-30
Open Time seconds, 10 mil film	ASTM D4497	25
Shear Adhesion Failure Temp (SAFT), 1 kg. wt. °C	ASTM D4498	130
Shore A and D Hardness	ASTM D2240-97	A70 / D20
Water Absorption % after 24 hours	ASTM D570	1.7
Water Absorption % after 7 days	ASTM D570	3.11
Pounds per gallon (g/cc), 25°C	ASTM D792	8.0 (0.96)
Flash Point °C, COC	ASTM D92-16	271 (520°F)

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HOT MELT STABILITY	UNI-REZ 2635 hot melt polyamide adhesive may be exposed to air for up to 4 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.
SOLUBILITY	UNI-REZ 2635 hot melt polyamide adhesive is designed to be used as a hot melt. However, if this polyamide should need to be cut into a solvent for testing, the recommended solvents include n-butanol, n-propanol or a 50/50 blend of isopropyl alcohol and toluene.
PACKAGING	UNI-REZ 2635 hot melt polyamide adhesive is in pellet form, packaged in poly-foil lined multi-wall bags, 40 or 50 lb. net.
STORAGE RECOMMENDATION	This product will slowly absorb moisture from the air, which may cause foaming when the resin is melted and could result in inadequate bonds. Partially used containers should be closed tightly, or the remaining resin transferred into an airtight container and kept in a cool, dry area.

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