

THERMELT 865 Black

POLYAMIDE HOT MELT RESIN

KEY FEATURES

- Excellent adhesion
- Good brittleness resistance at low temperature
- Flammability UL94 : V0 (UL file E116659)



DESCRIPTION

THERMELT 865 black is a pure copolymer polyamide hot melt resin, non reactive and solvent free, specially designed for Low Pressure Molding applications.

APPLICATIONS

THERMELT 865 is mainly used for molding of electronic/electric components, connectors and cables.

SPECIFICATIONS			
PHYSICAL PROPERTIES		VALUE	STANDARD TEST
Viscosity Brookfield (210°C, SC4, 50 RPM)	[Pa.s]	2.5-3.5	ASTM D3236
Softening point	[°C]	149-165	ASTM D3461
Water content	[%]	< 0.2	Bostik
Yield strength (50 mm/min, 23°C)	[MPa]	> 2.8	ISO 527
Elongation at break (50 mm/min, 23°C)	[%]	> 200	ISO 527
Commercial shape		Pellets	
Packaging		20Kg bag	

INDICATIVE VALUE					
THERMAL PROPERTIES		VALUE	STANDARD TEST		
Vicat temperature (A 120, 10N, 120°C/h)	[°C]	31	ISO 306		
Glass transition (DSC)	[°C]	- 50	Bostik		
MECHANICAL PROPERTIES		VALUE	STANDARD TEST		
Strength at break (50 mm/min, 23°C)	[MPa]	3.0	ISO 527		
Young modulus (50 mm/min, 23°C)	[MPa]	32	ISO 527		

INDICATIVE VALUE				
MISCELLANEOUS PROPERTIES	VALUE	STANDARD TEST		
Density	~1	Internal test		
Water absorption (immersed, 23°C) [%]	3,0	ISO 62		
Hardness [Shore D] (23°C)	31	ISO 868		
ELECTRICAL PROPERTIES	VALUE	STANDARD TEST		
Transversal resistivity [Ω.cm] (500V)	2,8.10 ¹¹	IEC 60093		
Dielectric rigidity [kV.mm ⁻¹]	18	IEC 60243-1		
Relative permittivity [F.m ⁻¹]	5.7	IEC 60250		

PROCESSING CONDITIONS		
RECOMMENDED PARAMETERS		VALUE
Melt Temperature Range	[°C]	190-210
Mold Temperature Range	[°C]	20-60
Drying Time (Air oven, thin layer)	[h]	8
Drying Temperature	[°C]	70
Processing Moisture Content	[%]	< 0.2

THERMELT 865 can be used in both melterand extruder.

T (°C)

200

190

STORAGE STABILITY

0 160

The product has a shelf life of 12 months when properly stored in a cool and dry location in closed original packing. Thermelt 865 will absorb moisture from the air. Because of risk of moisture absorption, we highly recommend to store any open bag in a close container.

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REGULATION

No substance mentioned in the candidate list of SVHC for authorization published by the European Chemical Agency (16/12/2013), is present at a concentration higher than 0,1% (w/w).

We certify that our products comply with the European directive 2011/65/EU, also called the RoHS directive. We don't introduce intentionally phthalate derivatives or Phosphorus Elemental (CAS 7723-14-0) manufacturing of our Polyamide adhesives.

MSDS is available on www.quick-fds.com

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The information given and recommendations made herein are based on Bostik's research only and are not guaranteed to be accurate. The performance of the product, its shelf life, and application characteristics will depend on many variables, including the kind of materials to which the product will be applied, the environment in which the product is stored or applied, and the equipment used for application. Any change in any of these variables can affect the product's performance. It is the buyer's obligation, prior to using the product, to test the suitability of the product for an $% \left(1\right) =\left(1\right) +\left(1\right) +$ intended use under the conditions that will exist at the time of the intended $% \left(1\right) =\left(1\right) \left(1\right) \left($ use. Bostik does not warrant the product's suitability for any particular application. The product is sold pursuant to Bostik's Terms and Conditions of Sale that accompanies the product at the time of sale. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents $% \left(1\right) =\left(1\right) \left(1\right$ or to constitute permission, inducement, or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

SMART HELP

Please contact your local representative



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