Technical Data Sheet

TECHNOMELT® PA 6211

Known as Macromelt 6211
February 2024

Product description

TECHNOMELT® PA 6211 provides the following product characteristics:

Technology	Polyamide
Product type	Hotmelt
Cure	Physical setting
Condition	Thermoplastic
Components	One-component
Application	General assembly
Color	Amber

Application areas:
TECHNOMELT® PA 6211 is used for plastic substrates.

Technical data

Softening point, °C ASTM E28 (in glycerine)	140 to 150
Melting viscosity at 180°C, mPas	7,100
Melting viscosity at 190°C, mPas	4,900
Melting viscosity at 200°C, mPas	3,500
Melting viscosity at 210°C, mPas ASTM D 3236 (RVT, spindle 27)	2,000 to 3,000
Specific gravity, g/cm³ ASTM D 1963	0.97
Yield strength, N/mm² ASTM D 638	2.7
Break strength, N/mm² ASTM D 638	2.5
Elongation , % ASTM D 638	400
E-modulus 2%, N/mm² ASTM D 638	32
Mandrel test 100% pass, °C ASTM D 3111	-35

Direction for use

Preliminary statement:
Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Preparation:
The surfaces of the substrate must be dry and free from oil, grease and dust.

Application:
Application temperature : 180 to 210 °C
Application system : Hotmelt application systems

When bonding to a substrate with high thermal conductivity the use of a specific application temperature is required for good wetting. Do not heat the product above the specified application temperature range. When the product is not in use do not apply heat, this will degrade the quality of the product and in extreme cases cause carbonisation. The standby temperature for the product is approximately 50°C below the application temperature, but not for longer than 72 hours. TECHNOMELT® PA 6211 may absorb moisture from the air. This will not be apparent in the solid form, but may cause bubbles on heating and could affect the bond quality. It is important, therefore, that containers are kept closed and sealed when not in use.

Cleaning:
Carbonised and set (non thermoplastic) material must be removed mechanically. Removal of the thermoplastic material from the hot apparatus can be achieved with solvent free cleaning system, such as TECHNOMELT® PA 62 (see separate technical information).

Classification:
Please refer to the corresponding **Material Safety Data Sheets** for details on:

- **Hazards identification**
- **Transport information**
- **Regulatory information**

Storage:
When properly stored in a cool, dry location, with the container tightly closed when not in use, this product will have a shelf life of at least 24 months.

Additional information

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