



MACROMELT OM 730

24 March 2010

This is an experimental product, and the relevant Technical Data may change.

PRODUCT DESCRIPTION

MACROMELT OM 730 provides the following product characteristics:

Technology	Polyamide
Product Type	Hotmelt
Cure	Physical setting Moisture curable
Components	One component
Application	Molding
Color	Amber

Application Areas

MACROMELT OM 730 is used for molding applications.

The product is a moisture curable polyamide hotmelt with a form stability at temperatures $\geq 200^{\circ}\text{C}$.

TECHNICAL DATA

Macromelt OM 730:

Softening point before curing, $^{\circ}\text{C}$	175
Softening point after curing, $^{\circ}\text{C}$ ASTM E28 (in glycerine)	> 200
Melting Viscosity at 200°C , mPas ASTM D 3236 (RVT, spindle 27)	approx. 2,000
Shore D hardness ISO 868/15s	42
Break Strength, N/mm ² ISO 527 Specimen no.5 Cross-head-speed: 50mm/min	9.0
Elongation, % ISO 527, Specimen no.5 Cross-head-speed: 50mm/min	150
Temperature creep resistance, $^{\circ}\text{C}$ Henkel method MH 11	> 200
Low temperature flexibility, $^{\circ}\text{C}$ ASTM D 3111	-15
Low temperature storage, $^{\circ}\text{C}$ Henkel method MH 40/1000 h	-40

DIRECTIONS FOR USE

Preliminary Statement:

Prior to application 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.

Preparation:

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

Application:

Application Temperature : 200 to 240°C

Application System: Hotmelt application system for moisture curable adhesives

Hotmelt gun for cartridges

Foil bag adhesive applicator

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.

The molding material cures exclusively by moisture and gains the final strength after some days, but exhibits high handling strength instantly after cooling. The curing depends on the following parameters: Level of humidity, humidity of the substrate and thickness of the hot melt.

2 days: 1,3 mm

3 days: 2,1 mm

9 days: 3,5 mm

14 days: 4,1 mm

The product will react with moisture, therefore it is necessary to avoid any contact with moisture during storage and application.

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 Purmelt Cleaner 2 (see separate technical information).

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information
Transport Regulations
Safety Regulations

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 9 months.

ADDITIONAL INFORMATION

Disclaimer:

The information provided herein, especially recommendations for the usage and the application of our products, is based upon our knowledge and experience. Due to different materials used as well as to varying working conditions beyond our control we strictly recommend to carry out intensive trials to test the suitability of our products with regard to the required processes and applications. We do not accept any liability with regard to the above information or with regard to any verbal recommendation, except for cases where we are liable of gross negligence or false intention.

This datasheet replaces all former versions.

Reference 0.0

