1441 Branding Avenue, Suite 110
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TECHNICAL DATA SHEET

PRODUCT NAME: SPECTRA-MELT 282

PRODUCT DESCRIPTION:
Thermoplastic hotmelt polyamide resin with the good high-temperature creep resistance. Good resistance against automotive fluid splash exposure.

CHEMISTRY: polyamide

MARKET USE: electronics encapsulation

Product Property	TEST METHOD	Specification	Unit of Measure
Softening point	ASTM E 28	170-180	°C
Viscosity	ASTM D 3236 (RVT spindle 27)	225C 3000-6000	Centipoise
Low Temp. Flexibility	ASTM D 3111	-40	°C
Water Absorption	DIN 53495	0.2-0.6	%
Hardness	ASTM-D-2240	90 A	SHORE
Color		Blaze Orange	Visual

APPLICATION TEMPERATURE: 205-225°C

OPERATING TEMPERATURE: -40-125°C

HANDLING SUGGESTIONS: Before applying, it is necessary to read the Safety Data Sheet (SDS) for information about precautionary measures and recommendations. For chemical products exempt from compulsory labelling, the relevant precautions should always be observed.

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When substrates with high heat conductivity need to be bonded, the use of the higher temperature limit will be necessary for good wetting of the surface. The substrate surface must be free of dust, oils and flux residues. The surface can be cleaned with a suitable solvent and when necessary, plasma treated.

The hot melt product should never be heated above the application temperature range. When the material is not being used, the temperature in the tank must be reduced to avoid oxidation and degradation of the material. The optimal standby temperature range for this material is 125°C for a maximum of 18 hours.

RESERVOIR CLEANING: Most hot melts used in Low Pressure Molding are from the polyamide family. Off-grade or expired polyamides, polyolefins and EVA's can be used to purge through the tank. Purge all hot melt from the reservoir and remove any charred product from the sides of the tank. Purge approximately 3 lbs of material through tank, hoses and nozzle to complete changeover.

SAFETY PRECAUTIONS: No health hazards are expected when the hot melt is in the solid form. However, once melted, it can produce severe burns. The appropriate safety precautions should be used. If the molten adhesive makes contact with the operator's skin, cool the affected area immediately with cold water. Do not try to remove the adhesive from the skin, instead seek professional medical attention.

FORM OF SUPPLY: pellets or small blocks on release liner

STORAGE: Keep in cool dry place in original closed container for up to 24 months from date of manufacturing.

The information above, particularly the recommendations for application and use of our products is based on our knowledge and experience. Due to the different substrates and conditions of application, which is beyond our knowledge and control, we strongly recommend carrying out sufficient tests to ensure that the product is suitable for the intended process and applications.