

Tekniske data for Henkel's Macromelt.

Modstandsdygtighed.

Adhesive properties	Standard	Macromelt OM652/657	Macromelt OM633/638	Macromelt OM673/678	Macromelt OM710	Macromelt OM433
Motoroil, Synthetic Mobil 1 OW-40	24 hours, RT	+++++	+++++	+++++	+++++	+++++
Motoroil, Synthetic Mobil 1 OW-40	28 days, RT	+++	+++	+++	+++++	+
Motoroil, Synthetic Mobil 1 OW-40	24 hours, 80°C	+++	+++	+++	+++++	+++++
Motoroil, Synthetic Mobil 1 OW-40	28 days, 80°C	+	+	+	+++++	-
Motoroil, 15W40, Texaco Havoline Formula 3	24 hours, RT	+++++	+++++	+++++	+++++	+++++
Motoroil, 15W40, Texaco Havoline Formula 3	28 days, RT	+++	+++	+++	+++++	+++++
Motoroil, 15W40, Texaco Havoline Formula 3	24 hours, 80°C	+++	+++	+++	+++++	+
Motoroil, 15W40, Texaco Havoline Formula 3	28 days, 80°C	+	+	+	+++	-
Transmission oil, ATF Ravenol	24 hours, RT	+++	+++	+++	+++++	+++++
Transmission oil, ATF Ravenol	28 days, RT	+++	+++	+++	+++++	+++++
Transmission oil, ATF Ravenol	24 hours, 80°C	+	+++	+++	+++++	+
Transmission oil, ATF Ravenol	28 days, 80°C	+	+	+	+++++	-
Wicos-VA (cutting oil)	5 days, RT	+++	+++	+++	+++++	+++++
Parafin	5 days, RT	+++	+++	+++	+++	+++
Toluene	5 days, RT	-	-	-	-	-
Acetone	5 days, RT	-	-	-	-	+
Spirit	5 days, RT	-	-	-	-	+++
Petrol	1 hour, RT	+++	+++	+++	+++++	+++++
Diesel	1 hour, 80°C	+++	+++	+++	+++	+++
Resistance: +++++ extremely good, ++++ very good, +++ good, ++ satisfactory, + adequat						

Klæbeevne.

Adhesive properties	Standard	Macromelt OM652/657	Macromelt OM633/638	Macromelt OM673/678	Macromelt OM710	Macromelt OM433
PVC		+++++	+++	+++	+++++	+++++
PA 6,6		+++++	++	+	+	+
PC		+++	++	+	+	+++
ABS		+++	++	+	+	+++
PBT		+++	+	+	+	+
PES		+++	+++	++	+	+
PEI		+++	+++	++	+	++
PUR		+++	+++	++	+	+++++
PE crosslinked (radiation)	Without corona	++	+	+	+	+
PE crosslinked (radiation)	With corona	+++	+++	+++	+	+++
Steel	RT	+	+	+	+	+
Steel	Prehea-ted	+++	+++	+++	+	+++
Resistance: +++++ extremely good, ++++ very good, +++ good, ++ satisfactory, + adequat						

Egenskaber.

Adhesive properties	Standard	Macromelt OM652/657	Macromelt OM633/638	Macromelt OM673/678	Macromelt OM710	Macromelt OM433
Color		Amber/Black	Amber/Black	Amber/Black	Amber	Black
Chemical base		Polyamide	Polyamide	Polyamide	Polyamide	Polyurethane
Thermal properties						
Service temperature (°C)	*	-40/+100	-40/+130	-40/+140	-20/+140	-40/+140
Glass transition temperature (°C)	DSC 2.Run	-45	-36	-45	-10	-
Cold flexibility (°C)	ASTM D3111	-50	-30	-40	-20	<-50
Temperature stability (°C)	Henkel Method HM11	125	155	165	160	-
Softening point (°C)	ASTM E28	155	175	185	170	-
Injection temperature (°C)		180-230	200-240	210-240	200-240	130-180
Thermal expansion coefficient (1/K)	PVT(50-80)°C	5x10 ^{^-4}	5x10 ^{^-4}	5x10 ^{^-4}	-	-
Flamability	UL94	V0	V0	V0	-	-
Mechanical properties						
Density (g/cm3)	DIN 53479	0,98	0,98	0,98	-	1,1
Shore-A hardness	DIN 53505	77	90	90	-	-
Shore-D hardness		-	-	-	40	45
Tensile stress at yield (N/mm2)	DIN 53455	2,6	4,5	5,1	4,5	10
Tensile strength at rupture (N/mm2)		2,7	5,2	5,6	26	12
Elongation at rupture (%)		400	400	400	600	800
Electrical properties						
Dielectric constant (1 KHz)	VDE 0303 part 4	5-7	5-7	-	-	-
Volume resistivity (?.cm)	VDE 0303 part 3	10 ^{^12}	10 ^{^13}	10 ^{^12}	-	-
Dialectric strength (kV/mm)	VDE 0303 part 2	-20	-20	-20	-	-
Application properties						
Viscosity at 180°C (mPas)	ASTM D3236	9500/8600	-	-	-	12000 at 130°C
Viscosity at 190°C (mPas)		7000/6500	-	-	-	-
Viscosity at 200°C (mPas)		5400/4900	5000	-	19000	-
Viscosity at 210°C (mPas)		4100/3700	37000	3000/3300	13000	-
Viscosity at 220°C (mPas)		-	2900	2200/2500	9000	-
Viscosity at 230°C (mPas)		-	2300	1600/1900	6100	-
Injection temperature (°C)		180-230	200-240	210-240	200-240	130-180
Water absorption						
Water absorption (%)	DIN 53495; 24h RT	1,4	1	1	5	0,25
* It depends on the project.	DIN 53495; 72h 85°	4,8	4,5	4	-	5