



THERMELT 867 HV Experimental

POLYAMIDE HOT MELT RESIN

THERMELT 867 HV is a pure copolymer polyamide hot melt resin, non reactive and solvent free, specially designed for Low Pressure Molding applications.

CHARACTERISTICS

THERMELT 867 HV is compliant with RoHS directive (2002/95/EC) and SVHC.

This product is phthalates free.

INDICATIVE VALUES *

PHYSICAL PROPERTIES	VALUE	STANDARD TEST
Maximum tensile strenght (50 mm/min, dry) [MPa/23°C]	7,8	ISO 527
Yield strenght (50 mm/min, dry) [MPa/23°C]		ISO 527
Young modulus (50 mm/min, dry) [MPa/23°C]		-
Elongation at break (50 mm/min, dry) [%/23°C]	450	ISO 527

APPLICATIONS

THERMELT 867 HV is exclusively used for molding of electronic/electric components.

ELECTRICAL PROPERTIES	VALUE	STANDARD TEST
Dielectric strength [kV.mm ⁻¹]		IEC 60243-1
Volume resitivity [Ω.cm]		IEC 60093
CTI [V]		IEC 60112

SPECIFICATIONS

PHYSICAL PROPERTIES	VALUE	STANDARD TEST
Viscosity Brookfield (SC4, 50 RPM) [Pa.s/220°C]	10,0 – 14,0	ASTM D3236
C&B [°C]	175 – 190	ASTM D3461
Commercial shape	Pellets	-
Color	Amber	-

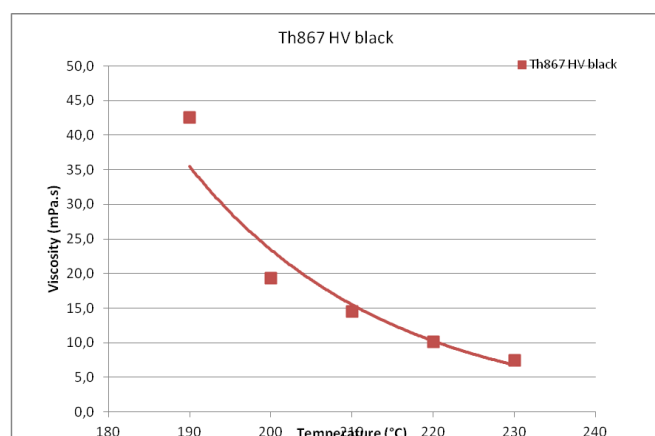
THERMAL PROPERTIES	VALUE	STANDARD TEST
Molding shrinkage (normal, parallel) [%]	-	ISO 294-4
HDT (0,45 MPa) [°C]	-	ISO 75-1/-2
Vicat (A120) [°C]	-	ISO 306
Glass transition temperature [°C]	- 50	ISO 11357-2

PROCESSING CONDITIONS

MISCELLANEOUS PROPERTIES	VALUE	STANDARD TEST
Hardness (instantaneous) [Shore D]		ISO 868
Density	0,98	ISO 1183
Water absorption (saturation, immersed) [%/23°C]	2,8	ISO 62
GWFI [°C]		
GWIT [°C]		
Flammability UL94 (UL file number E116659)	VO	IEC 60695-11-10

PROCESSING CONDITIONS	TYPICAL VALUES
Melt Temperature Range [°C]	210-230
Mold Temperature Range [°C]	20-60
Drying Time, Dehumidified Dryer [h]	4-6
Drying Temperature [°C]	70
Processing Moisture Content [%]	< 0.2

VISCOSITY DATA



STORAGE CONDITIONS / SHELF LIFE

The product have a shelf life of 18 months when properly stored in a cool, dry location at a temperature included between 5 and 50°C in closed original packing.

These values are provided in good faith by our laboratory for guidance only and will in no case involve Bostik's liability. The user will remain solely responsible for correct application and use of our products: considering the multiplicity of uses and service conditions, users are requested to proceed with their own approval testing before any use. In order to improve quality and performances of its products, Bostik SA reserves the right to modify their composition or properties at any time without prior notification.

BOSTIK HOTLINE

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