THERMELT® 865 Natural

POLYAMIDE HOT MELT RESIN

KEY FEATURES

- Good flexibility at cold temperatures
- Good wettability
- Flammability UL94: V0

PRODUCT DESCRIPTION

Resin Thermelt® 865 natural is a pure copolyamide hot melt resin and non-reactive, specially designed for Low Pressure Molding applications.

FEATURES

- Improved flexibility at cold temperatures,
- Good wettability at application temperature,
- Soft material.

This resin is in accordance with UL 94 V0 class.

APPLICATIONS

Resin Thermelt® 865 natural is mainly used for molding of electronic/electric components, connectors and cables.

PHYSICAL PROPERTIES

INDICATIVE DATA		VALUE	STANDARD TEST
Viscosity Brookfield (210°C, SC4-S27, 50 RPM)	**[Pa.s]**	3.1	ASTM D3236
Softening point (Cup and Ball)	**[°C]**	157	ASTM D3461
Water content	**[%]**	<0.2	Bostik
Hardness (23°C, 15s)	**[Shore D]**	15	ISO 868
Density		~1	Internal test
Water absorption (Immersed 7 days, 23°C)	**[%]**	3	ISO 62
Glass transition (DSC)	**[°C]**	-55	Bostik
Flammability (UL file E116659)		V0	UL 94
Colour		Natural	
Commercial shape		Pellets	

MECHANICAL PROPERTIES

INDICATIVE DATA		VALUE	STANDARD TEST
Max Stress (50 mm/min, 23°C)	**[MPa]**	>2	ISO 527
Elongation at break (50 mm/min, 23°C)	**[%]**	>200	ISO 527
Young modulus (50 mm/min, 23°C)	**[MPa]**	30	ISO 527

ELECTRICAL PROPERTIES

INDICATIVE DATA		VALUE	STANDARD TEST
Transversal resistivity (500V)	**[Ω.cm]**	$4.9.10^{10}$	IEC 62631-3
Dielectric rigidity (23°C)	**[kV.mm^{-1}]**	20	IEC 60243-1
Relative permittivity (50Hz, 23°C) (1kHz, 23°C) (1MHz, 23°C) (1GHz, 23°C) (5GHz, 23°C)	**[F.m^{-1}]**	6.8 4.2 - - -	IEC 62631-2 IEC 62631-2 ASTM D150 ASTM D150 ASTM D2520

PROCESSING CONDITIONS

RECOMMENDED PARAMETERS		VALUE
Melt Temperature Range	**[°C]**	180 - 210
Mold Temperature Range	**[°C]**	20 – 60
Drying Time (Air oven, thin layer)	**[h]**	6
Drying Temperature	**[°C]**	80

Resin Thermelt® 865 natural can be used in both melter and extruder.

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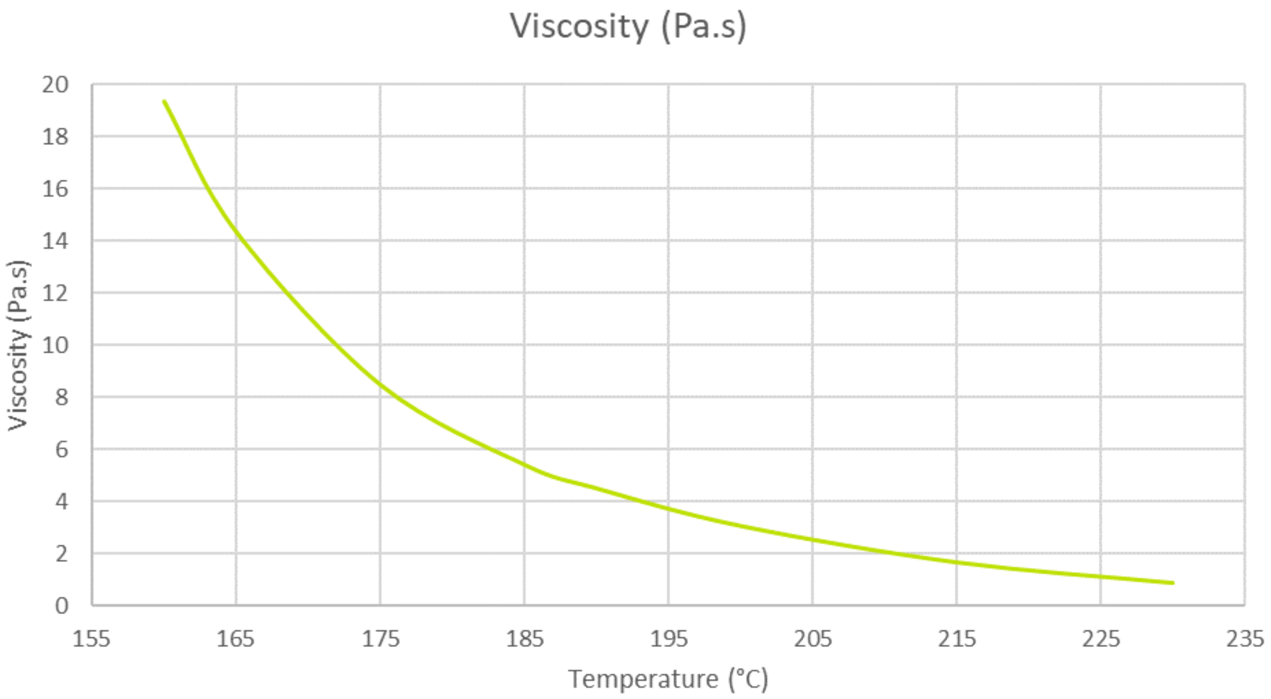

PACKAGING

For existing packaging sizes, please call your Bostik sales representative.

STORAGE STABILITY

The product has a shelf life of 18 months when properly stored in a cool and dry location in closed original packing. Resin Thermelt® 865 natural will absorb moisture from the air. Because of risk of moisture absorption, we highly recommend to store any open bag in a close container.

FURTHER INFORMATION

The following publication is available on request:

- Safety Data Sheets (SDS)
- Regulatory Information Sheet (RIS)

SMART HELP

Please contact your local representative