



BOSTIK

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	

THERMELT®

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

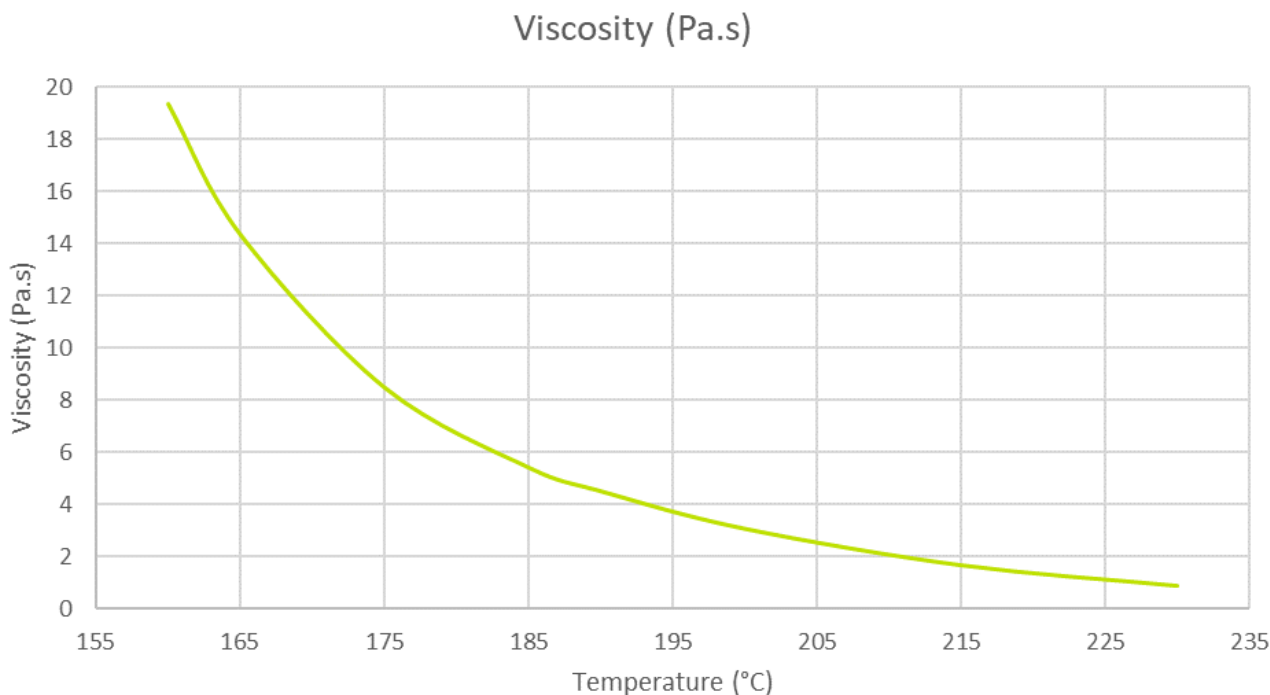
ELECTRICAL PROPERTIES

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)	6.8	IEC 62631-2
	4.2	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.



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)

The information given and recommendations made herein are based on Bostik's research only and are not guaranteed to be accurate. The performance of the product, its shelf life, and application characteristics will depend on many variables, including the kind of materials to which the product will be applied, the environment in which the product is stored or applied, and the equipment used for application. Any change in any of these variables can affect the product's performance. It is the buyer's obligation, prior to using the product, to test the suitability of the product for an intended use under the conditions that will exist at the time of the intended use. Bostik does not warrant the product's suitability for any particular application. The product is sold pursuant to Bostik's Terms and Conditions of Sale that accompanies the product at the time of sale. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute permission, inducement, or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

SMART HELP

Please contact your local representative

