

## TECHNOMELT PS 6615 E

Known as Instaweld 6615 E

May 2013

### PRODUCT DESCRIPTION

TECHNOMELT PS 6615 E provides the following product characteristics:

<b>Technology</b>	Pressure Sensitive
<b>Product Type</b>	Hotmelt
<b>Application</b>	Assembly
<b>Cure</b>	Not applicable
<b>Appearance</b>	X-Tra Chubs à 1 kg Amber

### Application Areas

- Assembly bonding

### Product Properties

- Permanently sticky pressure-sensitive hotmelt
- Very good adhesion of wood, ABS, PP, PVC, metal, etc.
- Easily processable by nozzle application

### Technical Data

#### TECHNOMELT PS 6615 E:

Softening Point, Ring & Ball, °C ~115

Viscosity, Brookfield - 160 °C, mPa.s ~33,000

### DIRECTIONS OF USE

#### Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

### Instructions for Use

#### Working Temperature

Recommended working temperature:  
at the application nozzle, °C 140 to 180

Due to changing surfaces, gluability of materials can be very different. Therefore, pre-tests should be carried out in case of difficult-to-bond surfaces, e.g. lacquered and coated ones.

#### Open Time

long

### Cleaning

Hotmelts remnants e. g. on surfaces of machine parts, can be removed with cold cleaning agent based on organic solvents. Depending on extent of contamination the application equipment must be inspected and cleaned regularly. If a darkened glue film is present the equipment can be cleaned by flushing with fresh material or hot paraffin wax. Carbonized material caused by overheating can only be removed with the help of a strong solvent and mechanical means. TECHNOMELT CLEANER MELT-O-CLEAN from Henkel, based on re-generative natural raw materials, is recommended.

### Safety

Hotmelt adhesives give off vapours even when the specified working temperature is not exceeded. The smells emitted may often cause irritation. When the specified temperatures are considerably exceeded over a longer period of time, there is the additional danger of decomposition products being given off. Therefore measures to draw off the vapours need to be taken, e.g. through the provision of extraction equipment.

### STORAGE

Store in the original tightly closed packaging in a cool, dry place.

### Shelf life

Shelf-life (in unopened original packaging), years 1  
Protect from direct sunlight.

### Classification:

Please refer to the corresponding **safety data sheets** for details on:

### Hazardous Information

### Transport Regulations

### Safety Regulations

## ADDITIONAL INFORMATION

### Disclaimer

#### Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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