

TECHNOMELT PA 641 (e)

(Electronics) December 2015

PRODUCT DESCRIPTION

TECHNOMELT PA 641 (e) provides the following product characteristics:

Technology	Polyamide
Appearance	Amber
Application	Molding compound thermoplastic
Typical Applications	Encapsulation
Flammability Rating	UL 94 V0 @ 0.9 to 1.2 mm thickness
Operating Temperature	-40 to +125 °C

TECHNOMELT PA 641 (e) high performance thermoplastic polyamide is designed to meet low pressure molding process requirements. This product can be processed at low processing pressure due to its low viscosity, allowing encapsulation of fragile components without damage. This material produces no toxic fumes in process and provides a good balance of low and high temperature performance. TECHNOMELT PA 641 (e) is particularly useful in applications which require increased strength and hardness.

LIQUID-STATE TYPICAL PROPERTIES

Viscosity @ 225 °C, mPa·s (cP)	4,500
Specific Gravity @ 25 °C	0.98
Softening Point, °C	170 to 180

TYPICAL PROCESS DATA

Handling:

Molding Temperature, °C	210 to 240
-------------------------	------------

TECHNOMELT PA 641 (e) has been formulated to provide the best possible moldability and as wide a molding latitude as possible. Much of the final molding parameters will be determined by the mold design. Although molding and curing conditions will vary from situation to situation, recommended starting ranges are shown above.

SOLID-STATE PROPERTIES

Physical Properties

Shore Hardness, Shore A	92
Elongation, at break, %	800

Electrical Properties

Dielectric Constant / Dissipation Factor, IEC 60250:	
1MHz	3.4 / 0.061
1.8 GHz	2.8 / 0.013
Dielectric Strength, kV/mm	25
Volume Resistivity, ohms-cm	3.2×10^{12}

TYPICAL PERFORMANCE OF SOLID-STATE MATERIAL

Lap Shear Strength, ISO 4587:

Steel	N/mm ²	380
	(psi)	(55,100)
FR4	N/mm ²	1,340
	(psi)	(194,300)

PERFORMANCE AND RELIABILITY DATA

Surface Insulation Resistance (SIR) Testing IPC-TM-650	Pass
---	------

GENERAL INFORMATION

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

TECHNOMELT PA 641 (e) will absorb moisture from the air. Material from opened containers should be transferred immediately into air tight containers. Material should be stored in sealed containers in a cool dry location in order to maximize shelf life.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
$\text{kV/mm} \times 25.4 = \text{V/mil}$
$\text{mm} / 25.4 = \text{inches}$
$\text{N} \times 0.225 = \text{lb}$
$\text{N/mm} \times 5.71 = \text{lb/in}$
$\text{psi} \times 145 = \text{N/mm}^2$
$\text{MPa} = \text{N/mm}^2$
$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
$\text{mPa}\cdot\text{s} = \text{cP}$

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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.



In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:

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. 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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Trademark usage

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 0.4

Americas
+1.888.943.6535

Europe
+32.1457.5611

Asia
+86.21.3898.4800

For the most direct access to local sales and technical support visit: www.henkel.com/electronics