

## WHT-6232

<b>Description</b>	WHT-6232 is polyester-based TPU hot-melt adhesive, supplied in form of transparent or slightly yellowish pellets with the characteristics of soft grade, good adhesion strength to PVC, PU, fabric and genuine leather.
<b>Application</b>	hot-melt adhesive film and tape
<b>Working instructions</b>	<p>According to our experience, the characteristics of the extruder that are suitable for processing WHT-6232 are the followings:</p> <ul style="list-style-type: none"> <li>• L/D ratio between 25:1 and 30:1 for extrusion.</li> <li>• The extruder screw must have 3 zones and a compression ratio between 2:1 and 3:1. Screws with a compression ratio greater than 4:1 should be avoided.</li> <li>• The extruder screw should have a continuous regulation device and a working power higher than for processing other plastics.</li> </ul>

For optimum results, previous drying of the product during 3-6 hours at 50~60°C is advisable, in a hot air circulatory, vacuum or desiccant-air dryer. The suggested processing-temperature profiles for injection are depicted in the table below.

### Property

PROPERTY	Method	Units	6232
<b>Hardness</b>	ASTM D 2240	Shore A	80
<b>Density</b>	ASTM D 792	g/cm <sup>3</sup>	1.2
<b>Tensile Strength</b>	ASTM D 412	MPa	25
<b>Ultimate Elongation</b>	ASTM D 412	%	700
<b>MI (150 °C, 2.16kg)</b>	ASTM D 1238	g/10min	2~8
<b>Flow Beginning Temperature</b>		°C	115
<b>Ring-ball Softening Temperature</b>	ASTM D 6493	°C	140
<b>Tack-free Time</b>		min	8

These products can only be ordered in typical quantities. Please contact your sales representative for details.

### T-die Extrusion Guideline for WHT-6232

Product	Die (°C)	Metering (°C)	Compression(°C)	Feed (°C)	Drying temperature(°C)	Drying time (h)
6232	140~160	140~160	130~150	110~130	50-60	3-6

**Note:** The actual processing temperature should be adjusted properly while auxiliary materials were used.

### Regrind usage

Where end-use requirements permit, up to 20% resin regrind may be used with virgin material, provided that the material is kept free of contamination and is properly dried (see section on Drying). Any regrind used must be generated from properly molded/extruded parts, sprues, runners, trimmings, and/or films. All regrind used must be clean, uncontaminated, and thoroughly blended with virgin resin prior to drying and processing. Under no circumstances should degraded, discolored, or contaminated material be used for regrind. Materials of this type should be discarded. Improperly mixed and/or dried regrind may diminish the desired properties. It is critical that you test finished parts produced with any amount of regrind to ensure that your end-use performance requirements are fully met.

### Disclaimer

The information provided here is for reference only. The specification will be provided in the quality certificate or in the contract. It is the user's responsibility to test the material and its suitability for a process. We have no control over what another party does with the material and we cannot take any responsibility for another party's action. Nor will we be responsible for any indirect damages while using our products. The user is welcome to contact our customer and technical service center with questions on our products



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Page 1 / 1