

BS-865 Black

Polyamide Hot Melt Resin

- ❑ Excellent adhesion
- ❑ Good brittleness resistance at low temperature
- ❑ Flammability UL94:V0

BS-865 black is a pure copolymer polyamide hot melt resin, non reactive and solvent free, specially designed for Low Pressure Molding applications. BS-865 is mainly used for molding of electronic/electric components, connectors and cables.

Properties

Physical Properties	Value	Unit
Viscosity [ASTM D3236]	2.5-3.5	Pa·s
Softening Point [ASTM D3461]	149-165	°C
Water Content	<0.2	%
Density	~1	g/cm ³
Water Absorption, immersed at 23 °C [ISO 62]	3.0	%
Thermal Properties	Value	Unit
Vicat Temperature [ISO 306]	31	°C
Glass Transition Temperature	-50	°C
Mechanical Properties	Value	Unit
Yield Strength, 50 mm/min at 23 °C [ISO 527]	>2.8	MPa
Strength at Break, 50 mm/min at 23 °C [ISO 527]	3.0	MPa
Elongation at Break, 50 mm/min at 23 °C [ISO 527]	>200	%
Young Modulus, 50 mm/min at 23 °C [ISO 527]	32	MPa
Hardness [ISO 868]	31	D
Electrical Properties	Value	Unit
Transversal Resistivity [IEC 60093]	2.8×10^{11}	$\Omega \cdot \text{cm}$
Dielectric Rigidity [IEC 60243-1]	18	kV/mm
Relative Permittivity, 50Hz at 23 °C [IEC 60250]	5.7	F/m

Supplied by all CAPLINQ Global entities

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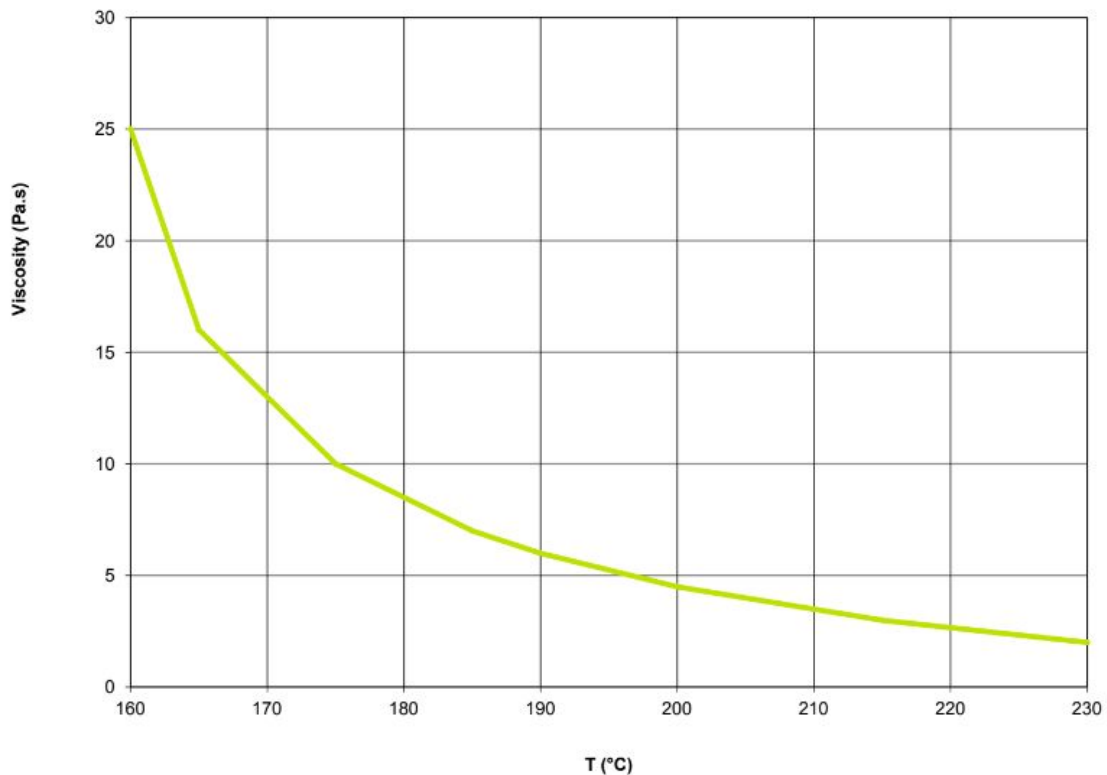
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Recommended Processing Conditions

Processing Conditions	Value	Unit
Melting Temperature Range	190-210	°C
Mold Temperature Range	20-60	°C
Drying Time	8	h
Drying Temperature	70	°C
Processing Moisture Content	<0.2	%

Viscosity curve versus temperature



Packaging

20kg bag

Storage and Shelf life

The product has a shelf life of 12 months when properly stored in a cool and dry location in closed original packing. BS 865 will absorb moisture from the air. Because of risk of moisture absorption, we highly recommend to store any open bag in a close container.

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