



SANHO CHEMICAL CO., LTD.

NO. 1 CHUNG SHAN S. RD., LU-CHU, KAOSHIUNG, TAIWAN.
TEL : 886-7-6962211~3 http : // www.sanho.com.tw
FAX : 886-7-6976993 (Sales) E-mail : sanho@sanho.com.tw
FAX : 886-7-6961782 (Export) E-mail : sanho@so-net.net.tw

TOHMIDE 390

TOHMIDE 390 is a solid-type fatty polyamide resin especially designed for HOT-MELT STRUCTURAL ADHESIVE uses.

It has superior processing properties for its ready-to-apply nature due to the lower molten viscosity. Optimum application temperature of TOHMIDE 390 is in the range of 190°C~220°C.

TOHMIDE 390 shows excellent adhesion onto various types of plastics, and steel, as well as onto many other surfaces, giving very tough bonding and sealing strength.

TOHMIDE 390 may be applied either by hand or manually operated "hand-guns." An automatic dispensing equipment with a nozzle or a wheel applicator may also be benefited.

1. SALES SPECIFICATIONS OF TOHMIDE 390

Appearance	: Brown Pellets
Softening Point (°C)	: 180 ± 5°C
Molten Viscosity (mPa·s, at 200°C)	: 200 ~ 400
Colour (Gardner)	: 12 Max.

2. SOLUBILITY

Solvent	Mixing Ratio(*)	TOHMIDE 390	Result (**)
Methanol / Toluene	1 / 1	25%	S
Isopropanol / Toluene	1 / 1	15%	S
Methanol / Chloroform	1 / 3	25%	S

* : Mixing Ratio in Weight ** : S means Stable more than one week

3. COMPATIBILITY (1)

Plasticizer	Concentration of plasticizer (% in weight)		
	10%	15%	25%
Phosphoric ester	C	C	C
Epoxidized fatty-acid ester	C	C	H
Rosin ester	C	C	C

COMPATIBILITY (2)

Plasticizer	Concentration of plasticizer (% in weight)		
	20%	50%	80%
Rosin	C	C	C
Ester gum	C	C	C
Rosin modified maleic resin	C	C	C
Phenol	C	C	C
Ethylene Vinyl Acetate	I	I	H

C : Compatible SH : Slight Turbid H : Turbid I : not Compatible



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4. OPEN TIME

OPEN TIME of TOHMIDE 390 was measured by the following manner; Bonded two sheets of corrugated board at an ambient temperature by employing molten resin at 200°C of TOHMIDE 390, maintaining its glue speed at 167gr. per every mm to make 3mm width of bead on the board.

※OPEN TIME measured : 22 ~ 23 second

5. MECHANICAL PROPERTIES

Hardness (Shore-A)	: 96, at 23°C
Elongation, at 20°C	: 20%
Tensile Strength, at 20°C	: 122 kg · f / cm ²
Yield Point, at 20°C	: 82 kg · f / cm ²

6. IMPACT RESISTANCE TEST AT LOW TEMPERATURE.

(by Du Pont Impact Test)

Impact resistance test was conducted as per follow : Dropping the plumb onto a specimen from a height of 20cm to measure the toughness of moulded TOHMIDE 390 in disk shape.

Specimen employed : Cool-off TOHMIDE 390 at pre-arranged minus 20°C for more than two hours after moulding the resin into the disk. Then take out it without loss of time to implement the Du Pont Impact Test.

Plumb : 300gram in weight with its diameter 1.27mm on its tip.

※Du Pont Impact Test Result at the low temperature : 4 / 5 (n = 5 pieces)