

# technical datasheet

## General description

Coloured, low viscosity, potting, encapsulation and knot/wood repair polyamide adhesive.

Tecbond 7718 has a very low viscosity that sets very hard. It is used for two main applications. Potting and encapsulation in the electronics industry as well as knot filling/wood repair in the woodworking industry.

Potting and Encapsulation: Tecbond 7718 has been tested for use in electrical / electronic applications and the electrical characteristics are listed below. The use of hotmelt speeds up assembly as there is no mixing and any unused adhesive remains in the glue gun ready for next time, so there is no waste. Setting time is usually less than 2 minutes. Coloured versions of the adhesive are available which can be useful to hide components or colour code for traceability.

Knot Filling / Wood Repair: The flow characteristics, hard setting and low shrinkage nature of Tecbond 7718 make it ideal for filling cracks and voids often found around knots in many types of wood. The adhesive is applied by glue gun, trimmed with a sharp knife or Mouseplane® and then sanded as usual before finishing. The adhesive is available in different colours to match the wood.

## Technical characteristics

Adhesive type: Synthetic polymer based hotmelt  
 Colour: 12mm Amber, Beige, Black, Cola, Cream, Oak, Bulk is only available in Amber.  
 Molten tack: Medium

	12mm	15mm	43mm	CT	Bulk
Form	12mm x 250mm	15mm x 250mm			Prills
Sticks per kilo (approx)	18	11			
Carton quantity	22lb ( 4 x foil 5.5lb)	22lb ( 4 x foil 5.5lb)			22lb
Alternative Pack	10 x 10 stick foil pack	10 x 6 stick foil pack			
Pallet weight:	1100lb	1100lb			1100lb
Suggested application temperature	350-420°F	350-420°F			350-420°F
Brookfield viscosity (POW-12-VISC) spindle 27	1000cps @ 350°F	1000cps @ 350°F			1000cps @ 350°F
Ring & ball softening point (ASTM E28)	320°F	320°F			320°F
Heat resistance (BS5350 Part H3)	275°F	275°F			275°F
Open time	Short	Short			Short
Low temperature flexibility (tg)	14°F	14°F			14°F
Surface resistivity MΩ BS6233	2.51 x 10 <sup>6</sup>	2.51 x 10 <sup>6</sup>			2.51 x 10 <sup>6</sup>
Volume resistivity MΩ/mm BS6233	1.38 x 10 <sup>6</sup>	1.38 x 10 <sup>6</sup>			1.38 x 10 <sup>6</sup>
Dielectric strength kV BS60243	30	30			30
Breakdown strength kV/mm BS60243	15.6	15.6			15.6

Tecbond Reference	Description	12mm	15mm	43mm	CT	Bulk
5	High delivery, low viscosity, long open time. Product assembly adhesive.	●		●	●	●
14	High delivery, vary fast setting packaging adhesive.	●	●	●		
1942	Product assembly adhesive for wood and many plastics.	●	●	●		
1X	Low viscosity, wood working & packaging adhesive. Medium open time.	●		●		
213	Economical, general purpose adhesive.	●	●	●		
214	Economical, fast setting, packaging adhesive.	●	●	●		
23	Medium viscosity multipurpose adhesive.	●	●	●		
232	Economical, clear, general purpose adhesive.	●	●	●		
232 Coloured	Coloured, medium open time, general purpose adhesive. Brown, Green, White, Black, Blue, Gold, Silver, Red, Yellow.	●				
232 Glitter	Multicolour, Red, Green, Silver, Gold.	●				
240	High delivery, long open time, multipurpose, clear adhesive.	●	●	●		
246	Clear and black versions, high performance, gap filling, difficult surfaces, dent pulling.	●				
260	High performance, long open time, tough, flexible adhesive.	●	●	●		
265	Long open time product assembly adhesive for smooth and shiny surfaces.			●		
267	High heat resistant, medium open time, product assembly adhesive.			●		
2169	Peelable adhesive, low tack, non-migrating, CD & credit card attachment, glue dots.				●	●
342	High viscosity, fast setting, white adhesive.	●		●		
410	Pallet stabilisation spray adhesive			●		
420	General purpose spray adhesive.			●		
425	High delivery, high performance, spray adhesive.			●		
430	High performance, long open time spray adhesive.			●		
4741	Full pressure sensitive, very aggressive, multipurpose, paper & plastic materials.				●	●
7718	Coloured, low viscosity, potting, encapsulation & knot filling / wood repair polyamide adhesive.	●	●			
7784	High temperature resistant multipurpose polyamide adhesive.	●	●	●		
7785	High temperature & chemical resistant multipurpose polyamide adhesive.	●	●	●		
9010	Reactive hotmelt. Heat & chemical resistant bonds, rigid bond, once set does not reactivate with heat.				●	
9030	Reactive hotmelt. Heat & chemical resistant bonds, flexible bond, once set does not reactivate with heat.				●	
LM44	Lowmelt, fast setting, high performance, white adhesive.	●		●		

#### Storage

Store in a clean dry place at temperatures between 5°C and 30°C with boxes closed. Do not expose to direct sunlight or localised heat sources such as radiators or hot pipes.

#### Removal of glue

Assembled components can be separated by heating assembly to a temperature slightly above the heat resistance figure.

EVA & Polypropylene:

Residues of EVA and polypropylene based hotmelts can be removed from components with white spirit.

Polyamide:

Residues of polyamide based hotmelt can be removed from components with acetone.

PUR:

Prior to cross linking adhesive can be removed with white spirit or ketone. Once fully cross linked the adhesive cannot be easily removed.

#### Please note

The information contained on this data sheet is for guidance only. It is the result of careful laboratory evaluations by trained and qualified staff using British Standard or similar test methods. However, no warranty is expressed or implied regarding the accuracy of the data or the suitability of the adhesive for any specific purpose. In every case, we strongly recommend that the user shall make their own test to determine to their own satisfaction the suitability of the adhesive for their particular purpose. Neither the seller nor manufacturer shall be liable for any injury, loss, damage, direct or consequential arising out of the use or inability to use the product. Further information is always available to help solve your adhesive problems. Should you require any further information on our adhesives please contact your nearest distributor.