

TECHNICAL DATA SHEET

PRODUCT # UR-2139

DESCRIPTION

This product is an extremely good plastic and all purpose adhesive. It has achieved good bonds to polycarbonate, polyvinyl chloride, polysulfone, styrene butadiene, rubber blended with natural rubber, acrylics, many metals, woods, and most painted surfaces.

SUGGESTED USES

Batteries, shoes, flooring, automotive, appliances, sporting goods, and as an all purpose flexible adhesive.

TYPICAL PHYSICAL PROPERTIES AND GENERAL INFORMATION

| Property | Part A | Part B | Blend |
|--|-----------|---------|-----------|
| BLENDING RATIO BY VOLUME | 100 | 50 | |
| BLENDING RATIO BY WEIGHT | 100 | 62.5 | |
| COLOR | COLORLESS | AMBER | COLORLESS |
| DENSITY, ASTM D0792, WEIGHT PER U.S. GALLON (lb-mass/gal) | | | |
| EXPANSION, COEFFICIENT – LINEAR THERM EXPAN | | | 0.000074 |
| GEL TEMPERATURE, TMTS144, GEL TIME TEMPERATURE (F.) (deg. F) | | | 76 - 78 |
| GEL TIME, GEL TIME IN MINUTES (162.5 GRAMS MIN: 161.5 MAX:163.5) (minute) | | | 35 - 65 |
| HARDNESS, SHORE A, HARDNESS = SHORE A | | | 90 |
| ODOR INTENSITY | MILD | | |
| ODOR | | NEUTRAL | |
| PEEL, ASTM D1876, T-PEEL (lb-mass/in) | | | 34.3 |
| SHELF LIFE | 365 | 180 | |
| SOLID CONTENT (NON-VOLATILES), TMWB052, SOLIDS (percent) | 100 | 100 | 100 |
| TENSILE STRENGTH, ASTM D1002, TENSILE LAP SHEAR STR. ALUM @ -40 F-1072 (lb-f/in ²) | | | 5, 553 |
| TENSILE STRENGTH, ASTM D1002, TENSILE LAP SHEAR STR. ALUM @ 180 F-1072 (lb-f/in ²) | | | 190 |
| TENSILE STRENGTH, ASTM D1002, TENSILE LAP SHEAR STR. ALUM @ 77-1072 (lb-f/in ²) | | | 1, 400 |
| VISCOSITY, TMTS001, VISCOSITY (cP) | 700,000 | 900 | 22,000 |
| VOLATILE ORGANIC CONTENT (VOC), EPA 450, VOC AS IS – THEORETICAL METHOD (g/L) | 0 | | 0 |
| VOLATILE ORGANIC CONTENT LESS WATER, EPA 450, VOC LESS WATER & EXEMPT-THEO. METH. (g/L) | 0 | | 0 |

APPLICATION AND EQUIPMENT SUGGESTIONS

Suitable two part metering and mixing equipment is available. Contact your H.B. Fuller representative for suggested application equipment to suit your specific needs.

DIRECTIONS FOR USE

SURFACE: Surfaces must be clean, dry and free from grease, oil, wax, weak oxide films and other surface contaminants.
PROPORTIONING AND MIXING: Hand mixing may be difficult. We suggest using meter-mix equipment with an automatic purge.

HANDLING STRENGTH: 12 – 16 hours at 77°F

***CURE SCHEDULE:** 3 – 7 days at 77°F, 3 – 5 at 158°F

* Allow additional time for parts to warm to curing temperature.

PERFORMANCE CHARACTERISTICS

Tensile Strength and Elongation per ASTM D-638 pulled at 1"/min.

| | Tensile Strength | Elongation |
|-------|------------------|------------|
| 73°F | 2100 psi | 380% |
| 140°F | 295 psi | 115% |
| 180°F | 180 psi | 65% |

Lap Shear Tensile Strength per ASTM D-1002, pulled at 0.05"/min. Acid etched 2024-T3 Aluminum to itself.

| | |
|-------|----------|
| 73°F | 1400 psi |
| 140°F | 450 psi |
| 180°F | 190 psi |

STORAGE AND HANDLING

Use good personal hygiene. Avoid eye and skin contact. Wash contaminated clothing before reuse. Store material in closed container in a cool, dry place.

IMPORTANT: We recommend that containers be purged with nitrogen after they are opened to the air and not all the material is used.

CAUTION

Respiratory irritant. Vapors harmful. Sensitizers. Eye and skin irritant. Harmful if swallowed. Consult the containers label and Material Safety Data sheets for additional cautionary information before using.

7/2008