



1-800-375-0605 www.rudolphbros.com

TECHNICAL DATA SHEET

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)	7.9 - 8.1	10 - 10.2	8.55 - 8.95
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, ODOR INTENSITY	MILD		
ODOR		NEUTRAL	
PEEL, ASTM D1876, T-PEEL (lb-mass/in)			34.3
SHELF LIFE	365	365	
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 (lb-f/in ²)			190
TENSILE STRENGTH, ASTM D1002, TENSILE LAP SHEAR STR. ALUM @ 77 F (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 PREPARATION: 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 equipped with an automatic purge.

HANDLING STRENGTH: 12-16 hours at 77F

*CURE SCHEDULE: 3-7 days at 77F
3-5 hours at 158F

* 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
73F	2100 psi	380%
140F	295 psi	115%
180F	180 psi	65%

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

73F	1400 psi
140F	450 psi
180F	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 container label and Material Safety Data sheets for additional cautionary information before using.

LIMITED WARRANTY AND TERMS

H.B. Fuller Company ("Fuller") warrants that, for a Warranty Period of one year (or the period specified on the applicable Technical Data Sheet, whichever is less) from the date of shipment from Fuller to the Initial Purchaser, that this Fuller product was manufactured in accordance with Fuller's specifications in effect on the date of manufacture. These specifications are available upon request. This Warranty does not cover test data, or any defects, damages or other harms caused to any extent or in any way by failure to follow applicable Fuller instructions, if any, or abuse or misuse of the product.

WARRANTIES DISCLAIMED -- THE WARRANTY STATED IN THE PARAGRAPH ABOVE IS IN PLACE OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. Fuller EXPRESSLY DISCLAIMS ANY OTHER WARRANTIES, INCLUDING WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. ALTHOUGH Fuller MAY HAVE SUGGESTED THE PRODUCT OR DEVELOPED THE PRODUCT AT THE PURCHASER'S REQUEST, IT IS THE PURCHASER'S RESPONSIBILITY TO TEST AND DETERMINE THE SUITABILITY OF THE PRODUCT FOR THE PURCHASER'S INTENDED USE AND PURPOSE, AND PURCHASER ASSUMES ALL RISK AND LIABILITY WHATSOEVER REGARDING SUCH SUITABILITY.

LIMITATIONS OF REMEDIES AND DAMAGES -- FOR ANY VALID CLAIM PRESENTED UNDER THE LIMITED WARRANTY, Fuller WILL REPLACE THE PRODUCT, OR AT ITS OPTION, REFUND THE PURCHASE PRICE. THIS REPLACEMENT/REFUND REMEDY IS THE PURCHASER'S SOLE AND EXCLUSIVE REMEDY AGAINST Fuller. THE PURCHASER AGREES THAT NO OTHER REMEDY (INCLUDING BUT NOT LIMITED TO LOST PROFITS, LOST SALES, INJURY TO PERSON OR PROPERTY OR ANY OTHER INCIDENTAL OR CONSEQUENTIAL LOSS) SHALL BE AVAILABLE TO PURCHASER FOR CLAIMS ARISING OUT OF ANY USE OF THE PRODUCT REGARDLESS OF THE LEGAL THEORY (CONTRACT, TORT OR OTHER). IN NO EVENT WILL Fuller BE OBLIGATED TO PAY DAMAGES TO PURCHASER IN ANY AMOUNT EXCEEDING THE PRICE THAT THE PURCHASER PAID FOR THE PRODUCT.

LIMITATION OF ACTIONS AND VENUE -- Any claim made or action commenced by Purchaser under Fuller's limited warranty as set forth herein must be brought within one year from the date of shipment from Fuller to the Purchaser. Purchaser agrees that all disputes arising from Fuller's sale of product to Purchaser shall be brought, if at all, in and before a court located in the State of Minnesota, to the exclusion of the courts of any other state.

CONDITIONAL ACCEPTANCE -- Fuller's acceptance of Purchaser's order for this product is expressly conditional on Purchaser's assent to terms and conditions set forth herein.

ADEQUATE TESTS: The information contained in this bulletin we believe is correct to the best of our knowledge and tests. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that adequate tests be made in your laboratory or plant to determine if this product meets all of your requirements.