

65A Adhesive

Adhesion Promoting Polyurethane

© RAMPF Tooling Solutions GmbH & Co. KG

PC - Rev.-Status: 01- 2016/07/25

Page 1 of 2

Key Properties

- Excellent physical properties
- Low Peak Exotherm
- Free of mercury, MOCA or TDI

Applications

- Formulated for room temperature hand-batch or meter-mix casting methods.

Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	56	100
		pbv	50	100
Density	ASTM D-792	g/cm ³	ca. 1.22	ca. 1.09
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 700	ca. 3,800

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 1,950
Gel time at 77°F (25°C)		min	22-32
Demold time at 77°F (25°C)		h	16-24

Cured / Mechanical Properties (approximate values)

Cure : 7 days at 77°F

			Cure
Aspect	visual		Gray
Density	ASTM D-792	g/cm ³	1.15
Shore hardness A	ASTM D-2240		60-70
Tensile strength	ASTM D-638	psi	700
Elongation at break	ASTM D-638	%	120
Tear strength	ASTM D-624	pli	105
Linear shrinkage	ASTM D-2566	in/in	0.001-0.005

Processing

The processing and material temperature should be between 68-77°F (20-25°C).

Formulated for hand-batch equipment or meter-mix equipment. It is recommended that dry nitrogen be used to protect the material from oxidizing and being moisture contaminated.

Agitate the hardener before use to ensure that the formula is homogeneous.

Packaging

IE-3251 Quart Kit	3.12 lbs.
IE-3251 1 Gal. Kit	12.48lbs.
IE-3251 5 Gal. Kit	62.4 lbs.
IE-3251 Drum Kit	702 lbs.

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (15°C to 30°C). If properly stored the products have the shelf-life indicated on the product label.

Partly used containers should always be sealed appropriately and used up as soon as possible.

Handling Precautions

Good workplace ventilation is to be ensured during processing. At the same time, the employer's liability insurance association's industrial hygiene safety regulations regarding the handling of reaction resins and their hardeners are to be observed. Please take heed of the appropriate safety data sheets.
