

65A Adhesive

Enhanced Bonded Polyurethane

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Key Properties

- Excellent physical properties after RT cure
- Phthalate Free
- Free of mercury, MOCA or TDI

Applications

- Formulated for hand batch or meter-mix processing
- Formulated to bond to slippery, smooth surfaces such as ABS or other polyurethane substrates

Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	92
		pbv	100	100
Density	ASTM D-792	g/cm ³	ca. 1.19	ca. 1.09
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 8,500	ca. 250

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 1,300
Gel time at 77°F (25°C)		min	7-10
Demold time at 77°F (25°C)		min	ca. 60-120

Cured / Mechanical Properties (approximate values)

Cure 1: 7 days at 77°F

			Cure 1
Aspect	visual		Translucent
Density	ASTM D-792	g/cm ³	1.09
Shore hardness A	ASTM D-2240		60-70
Tensile strength	ASTM D-638	psi	1100
Elongation at break	ASTM D-638	%	218
Tear strength	ASTM D-624	pli	150
Linear shrinkage	ASTM D-2566	in/in	0.001-0.005

Processing

IE-3253 has been formulated for meter mix equipment or hand mix equipment or hand mix dispensing. Best results are achieved when using a 3/8 x 40 mix tube when metering this material. Ensure that sufficient material is used to wet out the meter mix tube before shooting into the mold. Improved flow rates can be accomplished if the resin side is warmed to 100°F. The viscosity at this temperature is reduced to approximately 3,500 cps. For best adhesion, abrade or sand the surface needing to be adhered, solvent wipe with Acetone and apply a primer such as Chemlock 213 before applying the IE-3253. There are ingredients that will settle out of solution in the hardener side. Ensure that it is agitated before use to ensure that the formula is homogeneous.

Packaging

IE-3253 Quart Kit	3.84 lbs.
IE-3253 1 Gal. Kit	15.36 lbs.
IE-3253 5 Gal. Kit	76.8 lbs.
IE-3253 Drum Kit	864 lbs.

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F. If properly stored the products have the shelf-life indicated on the product label. Partly used containers should always be sealed appropriately, blanketed with dry nitrogen to prevent moisture contamination, and used up as quickly 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.
