# TECHNICAL DATA SHEET

TDS# 2702

DATE: JUNE 2013

BACON INDUSTRIES

## FLEXOBOND 202A

The FLEXOBOND 200 series is a group of two-part light amber liquid urethane systems containing modified polybutadiene. The systems do not contain TDI, mercury, lead, asbestos or MOCA. The systems gel rapidly and cure to rubbery solids. These systems are found to have good adhesion to many organics and inorganics. The systems hold little water and should be considered as sealants, encapsulants, and general purpose adhesives. All six materials may be cured at either ambient or elevated temperatures. All the systems may be handled in less than one day at 73°F.

## RECOMMENDED MIXING AND HANDLING PARAMETERS

| | |
|---|---|
| Resin | Flexobond 202A |
| Activator | BA-400 |
| Color of resin (Gardner Color Scale) | 1.0 |
| Viscosity of resin at 77°F (cp) | 6700 |
| Viscosity of activator at 77°F (cp) | 56 |
| Parts by weight of activator required per 100 parts of resin | 35 |
| Viscosity of mixed material (65 g) | |
| at 77°F, RVT, #7 spindle, 20 rpm (cp) | 12,000 |
| Work life at room temperature, (50 g), minutes | 45 |
| Recommended cure, hr/°F | 2/212 |
| Alternate cure, days/°F | 21/77 |

## TYPICAL PROPERTIES OF CURED ADHESIVE:

| | |
|---|---|
| Tack Free Time, hours | 4 |
| Color | Translucent cream to tan |
| Specific Gravity | 1.02 |
| Hardness (Shore A/D) | |
| Recommended cure of 2 hrs at 212°F | 73/23 |
| + 24 hrs at 73°F | 82/30 |
| + one week at 73°F | 90/40 |
| + three weeks at 73°F | 90/41 |
| Alternate cure of three weeks at 73°F | 91/43 |
| Lap Shear Strength, aluminum to aluminum, psi | |
| one day | 420 |
| two days | 670 |
| three days | 750 |
| seven days | 850 |
| ten days | 950 |
| two hrs at 212°F | 900 |

(over)

16731 HALE AVENUE · IRVINE, CA 92606-5092 · (949) 863-1499 · FAX (949) 863-0105

| | |
|---|---|
| Moisture Absorption, in water, % cure of 4 hr/212°F | |
| one day at 73°F | 0.04 |
| seven days at 73°F | 0.04 |
| seven days at 200°F | -0.44 |

**FOR INDUSTRIAL USE ONLY! HAZARDOUS!**

CAUTION: FLEXOBOND 202A may cause skin irritation. Use with adequate ventilation. Avoid contact with skin or clothing. In case of contact, flush immediately with plenty of water. Keep container tightly closed when not in use.

WARNING: Activator BA-400 contains diisocyanate which is a strong skin sensitizer and may cause severe irritation to mucous membranes. Avoid contact with skin and eyes and avoid breathing vapors. Use with adequate ventilation. In case of skin contact, wash promptly with 99% isopropyl alcohol (rubbing alcohol is NOT suitable) to remove resin, then soap and water.

**SHELF LIFE:**

The shelf life of FLEXOBOND 202A is greater than one year when stored below 95°F in closed containers. If crystallized, preheat material (loosen cover) to 160°F. Allow material to cool to room temperature before mixing. The shelf life of Activator BA-400 is greater than six months when stored below 95°F. The ideal storage temperature for Activator BA-400 is between 80°F and 95°F. Below 80°F, Activator BA-400 may crystallize and, if crystallized, must be decrystallized before use. If crystallized (loosen cover), preheat to 140°F until clarity is obtained. Excessive heating degrades material. The total of all periods of time at 140°F should not exceed three hours. These materials are moisture sensitive and should be tightly capped. Back filling partially empty containers with dry nitrogen is recommended.

**AVAILABILITY:**

FLEXOBOND 202A is available in pint and quart kits. The quart kits are composed of a quart friction top can for the FLEXOBOND resin plus a one-half pint oblong can for the Activator BA-400. The pint kits contain a pint friction top can plus a one-half pint oblong can. The quart and pint kits contain totals of two pounds and one pound respectively.