



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)

