



TECHNICAL DATA SHEET

TDS# 2730

DATE: JUNE 2013

BACON INDUSTRIES

FLEXOBOND 430

FLEXOBOND-430 is a two-part clear urethane system which does not contain TDI, mercury, or lead. This system has unusually good wetting properties. It gels rapidly and cures to a rubbery solid. The system may be utilized as an adhesive, encapsulant or casting compound. FLEXOBOND-430 may be cured at either ambient temperature or elevated temperature. It generally can be handled in less than six hours from the initiation of ambient cure. This material is similar to the harder FLEXOBOND-425 and FLEXOBOND-431.

RECOMMENDED MIXING AND HANDLING PARAMETERS

Resin	Flexobond 430
Activator	BA-430
Parts by weight of activator required per hundred of resin	50.0
Work life at Room Temperature (10 g), minutes	100
Gel Time at Room Temperature (10 g), minutes	150
Viscosity of FLEXOBOND 430 at 77°F, cp	850
Viscosity of Activator BA-430 at 77°F, cp	800
Viscosity of mixed material (100 g) at 77°F, cp	
<u>Minutes from time mixed</u>	<u>Viscosity, cp</u>
0	800
20	1,600
40	4,000
60	24,800
80	224,000
Recommended cure, hr/°F:	2/200
Alternate cure, day/°F:	1/77

TYPICAL PROPERTIES OF CURED ADHESIVE:

	<u>Rec. Cure</u>	<u>Alt. Cure</u>	<u>Weeks 77°F</u>		
			1	2	3
Specific Gravity	1.1	1.1	-	-	-
Hardness, Shore A	67	57	62	65	68
Hardness, Shore D	26	20	23	25	27
Color	Clear, sl amber	Clear, sl amber			
			<u>3 Weeks at R.T.</u>		
Lap Shear Strength to					
Aluminum (unprimed), psi	447			471	
Polycarbonate (unprimed), psi	665			690	

(over)

