

EL628FF

Is a flexible, two-part, room temperature curing polyurethane adhesive

Application

- Bonding of dissimilar materials
- Rubber to metal Bonding

Key Properties

- High adhesion
- Thixotropic
- High impact resistance

Description

- Basic Two-component polyurethane system
- Resin RL628FF
- Hardener HL628FF

Physical Data (approx. – values)

	Resin	Hardener	Composite
Colour	Translucent Straw	Amber	Translucent Amber
Specific Gravity	1.07	1.23	1.13
Viscosity (mPas) @ 25°C	Thixotropic	200	Semi thixotropic

Cure Schedule (150g)	Working Life	Gel Time	Light Handling	Full Cure
Temperature	(minutes)	(minutes)	(hours)	(hours)
10°C	6	-	5	24
RT	3-6	4-8	3	16
30°C	4	-	2	6

*RT is defined as 20-25°C

The above are typical values and will vary depending on the cured mass and application. Hotter temperatures may be used for faster cure but will result in higher post cure shrinkage and higher cure exotherm. Experimentation and testing is suggested to avoid side effects. For maximum properties a post cure may be required – Contact our technical service department for advice.

Processing

Mix ratio by weight 1.74:1
Mix ratio by volume 2:1

Approvals

RoHS compliant	Yes
UL94-V0	No
REACH (SVHC concentration)	Refer to SDS

Typical Properties	Result	Unit
Hardness	85-95	Shore A
Operating Temperature	-40 to +120	°C (Application and geometry dependant)
Thermal Conductivity	0.3	W/mK
Tensile Strength	6	mPa
Elongation at Break	150	%
Compressive Yield Strength	< 10	mPa
Coefficient of Linear Expansion	70 - 90	ppm/C
Volume Resistivity	10 ¹³	ohm.cm
Thixotropy	3-6	mm

Lap Shear Strength

Aluminium/Aluminium	14 Kg/cm ²
Stainless Steel/Stainless Steel	12 Kg/cm ²

Packaging & Part Numbers

EL628FF is available in Bulk, Twinpacks, Cartridges & kits

Availability

Available through distribution and sales@robnor.co.uk

Cartridge Mixing - Part Numbers

EL628FF/NC/050TC	
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It is essential for best results that the cartridge is 'balanced' before use to ensure correct mixing. Loading the cartridge into the gun before attaching the mixer element and pumping the gun to push a small amount of the contents forward will achieve this. Wipe the excess from the cartridge tip and add the static mixer. The cartridge is now ready for use.

Cartridges that are foil wrapped and desiccant packed should be stored horizontally

Twinpacks - Part Numbers

Available on request	
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Twinpacks are pre-weighed resin and hardener components contained in a tough flexible film, separated by a removable clip and rail. Once the clip and rail has been removed the resin and hardener is thoroughly mixed within the bag and is immediately ready for use. Mixing will normally take ~ 2 minutes due to the viscosity; but pay special attention to the corners. Twinpacks are ideal for small to medium production runs, prototyping and on-site or field use. The twinpack weight/volume may also be tailored to a specific size on request.

For further details please visit www.robnor-resinlab.com

Bulk Materials - Part Numbers

RL628FF/NC/25KG	
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	HL628FF/NC/25KG
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Both resin and hardener are supplied in 5kg, 25kg and 200ltr drums and fully evacuated and ready for use.

Care should be taken to ensure when mixing the resins air is not entrained in the mixture. If this is unavoidable the mixed resin and hardener should be re-evacuated before dispensing. The bulk resin and hardener materials can be dispensed from suitable dispensing machinery, details provided by Fluid Research on request.

Adhesive Kits and Sets - Part Numbers

Available on request	
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Kits and Sets are provided in separate containers to the correct ratio.

In Kit form, pour the smaller container into the larger container and use it as a mixing vessel.

Stir well using an appropriate mixer until homogeneous.

Note: Incomplete mixing will be characterised by erratic or partially incomplete cure even after extended time periods.

Cleaning

All equipment contaminated with mixed material should be cleaned before the material has hardened.

TS130 is a suitable non-flammable cleaning agent, although other solvents may be found suitable.

TS130 will also remove cured material provided it can soak for several hours.

Storage and Shelf Life

24 months at 25°C - Specialty packaging may be less.

Bulk containers should be inverted every two to three weeks to reduce the accumulation of the fillers on the bottom of the containers.

Isocyanates are sensitive to moisture and should be kept in their original container or in a volume tank under dry nitrogen blanketing.

Many isocyanates are prone to dimerization, the formation of a white precipitate. Products with minor amounts of this precipitate normally cure to full properties.

Storage at 20 +/- 5°C (60°F to 86°F) is recommended to ensure full shelf life.

Health and Safety

Please refer to RL/HL628FF Health and Safety data or our Technical Service Department for individual/specific advice.

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The results and information above do not constitute a specification and is given in good faith and without warranty. The information is derived from test/or extrapolations believed to be reliable and is quoted for guidance only. The product is offered for evaluation on the understanding the customer satisfies himself that the product is suitable for the intended application by proper evaluation and testing.

Contact Details

Robnor ResinLab Limited
31 Athena Avenue
Elgin Industrial Estate
Swindon
SN2 8EJ
United Kingdom

Tel: +44 (0) 1793 823741
Fax: +44 (0) 1793 827033

Email: support@robnor.co.uk

Buy Online: www.robnor-resinlab.com (UK only)