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Polyurethane Adhesive

HPA 900A&B

TECHNICAL DATA SHEET 938

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DESCRIPTION

HPA 900 A&B is a 2 component polyurethane designed for bonding applications requiring adhesion to hard to bond surfaces. The product has excellent adhesion to many metals, plastics, and elastomers.

FEATURES

- Quick Cure Time at Room Temperature
- Good Adhesion
- Tough Cure

TYPICAL UNCURED PROPERTIES

	HPA 900 A	HPA 900 B	Mixture
Type	Isocyanate	Polyol Mixture	
Color	Amber	Pale Yellow	Yellow
Viscosity, cps	150	300	200

PROCESS PARAMETERS

Mix Ratio

	Part A	Part B
By Weight	100	80

Pot Life @ 25°C ~ 5 minutes

USAGE

Plastic parts should be wiped with acetone in the area to be bonded prior to applying the adhesive.

In a cup, add Part A and Part B at a weight ratio of 10:8.

Mix for 1 minute, the material will become an opaque yellow in color. Apply the mixture to the bond area and mate the surfaces. The bonded part must be taped down tightly to hold it in place and assure good contact with the adhesive as it cures. Since HPA 900 tends to foam during curing the bonded section should be fixtured tightly during curing. Excess adhesive should be wiped away from outside the bond area.

The tape may be removed when the adhesive is sufficiently set in approximately 8 hours. Full cure will occur 2 days at room temperature.

CURED PROPERTIES

(Typical properties values approximate)

Property	Units	Value
Hardness @25°C	Shore A	85
Color		Yellow
Tensile Strength	Psi	1200
Elongation	%	25

STORAGE AND HANDLING

Storage Room temperature
Safety Refer to MSDS for details

All values are considered typical based on tests believed to be accurate. Polysciences, Inc. may change the data as appropriate.

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