

D350 FAST BLACK POLYURETHANE ADHESIVE

PRODUCT DESCRIPTION

D350 is a two part, very fast setting, room temperature curing, polyurethane adhesive system which is ideal for structural repairs and bonding plastic parts. It cures by chemical reaction of the two components, which are contained in a two part cartridge and applied through a specially designed mixing nozzle. This ensures that the 1:1 mix ratio is achieved along with the necessary amount of mixing. The product forms a durable polymer which is resistant to elevated temperatures, fuel, moisture, many solvents and chemicals. D350 is specifically designed for small, quick and durable repair jobs also referred to as 'smart repair'.

PROPERTIES

- Fast setting time with convenient 1:1 mix ratio
- Excellent adhesion to wide variety of surfaces such as Aluminum, Stainless steel, ABS, PVC, Polyurethane, Composites, Thermoplastics, Thermosetting Plastics, Wood, Glass, Concrete without any use of primer.
- General bonding and sealing.
- Sandable and overpaintable.
- Easy and cost effective repair.
- High viscosity for vertical applications.

AREAS OF USE

- Automotive trims and fittings.
- Cosmetic plastic part repairs
- Cladding and panel bonding applications.
- Any high specification bonding use.

TECHNICAL DATA	TYPICAL UNCURED PROPERTIES			
		PART A	PART B	MIXED
Colour	Beige	Black	Black	
Viscosity @ 25°C	30,000	30,000	30,000	
Brookfield, cps Specific Gravity g/cm ³	1.40 - 1.45	1.40 - 1.45	1.40 - 1.45	
Mix Ratio by volume	1:1			
Mix Ratio by weight	1:1			
Working Time	60 - 100 seconds			
Fixture Time	10 - 14 Minutes			
Functional Cure	2 hours			
Full Cure	24 hours			
Service Temperature	-20°C to 120°C			

TECHNICAL DATA	TYPICAL CURED PROPERTIES		
	T-Peel Strength	65 - 75 Pli	ASTM D 1876
	Tensile Elongation	170%	ASTM D 638
	Shore Hardness	70D	ASTM D 2240
	Dielectric Strength	350 volts/mil	ASTM D 149
	Cure Shrinkage	0.0020 in./in.	ASTM D 2566
	Tear Resistance	450 Pli	ASTM D 624
	Tensile Strength	2,850 psi	ASTM D 638

TECHNICAL DATA	LAP SHEAR STRENGTH AFTER 7 DAYS AT 25°	
	ABS TO ABS	925 PSI
	Steel to Steel	1975 psi
	Glass to Glass	4050 psi
	SMC to SMC	1280 psi
	Aluminium to Aluminium	2650 psi
	Concrete to Concrete	1945 psi
	Galvanised Metal to Metal	2850 psi

SURFACE PREPARATION

Clean surface by solvent-wiping any deposits of heavy grease, oil, dirt, or other contaminants. Surface can also be cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. If working with metal, abrade or roughen the surface to significantly increase the surface area and increase the bond strength. For lacquered and coated surfaces we recommend to remove the layers by sanding and degreasing with a suitable solvent. For more detailed information, please contact Delta Technical Department.

MIXING PROCEDURE

Proper homogenous mixing of resin and hardener is essential for the curing and development of stated strengths.

1. Attach cartridge to 50ml manual or pneumatic dispensing systems.
2. Open or remove tip.
3. Extrude cartridge by squeezing out some material until both sides are uniform (ensures no air bubbles are present during mixing).
4. Attach mix nozzle to end of cartridge.
5. Apply to surface and attach other substrate quickly, as you have less than 2 minutes of working time to use the product. Substrates can be clamped with a bond line thickness as small as 0.2mm.

STORAGE	Store in cool, dry place.
SHELF LIFE	6 Months when stored in unopened packaging @ +5 to +25°C
HEALTH AND SAFETY	Refer to the relevant Material Safety Data Sheet (MSDS).
PACKAGING	Available in 50ml twin syringe.

LEGAL NOTICE

The data contained within this Technical Data Sheet is furnished for information only and is believed to be reliable at the time of issue. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the responsibility of the customer to determine the products suitability for use. Delta Adhesives Limited accepts no liability arising out of the use of this information or the product described herein.

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