



TECHNICAL DATA SHEET PUA505H

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DESCRIPTION

Tacusil PUA505H is a two-parts fast gel polyurethane adhesive. It has good adhesion to versatile substrate including metal, ceramic and plastic. Tacusil PUA505 was formulated to a 1A:1B volume mix ratio for use in side-by-side dispensing cartridges and meter/mix and dispense equipment. it will reach full cure after 72 hours under ambient conditions, elevated temperature will fast curing speed, 2hrs at 70 °C or 1hr at 90 °C are sufficient. Full cured PUA505 is tough with flexibility and has good chemical resistance and mechanical impact resistance.

TYPICAL PROPERTIES

<i>Property:</i>	<i>Value:</i>	<i>Test Method or Source:</i>
Color	Black/ Brown	Visual
Mix Ratio By weight	Part A to Part B 100 to 136	Calculated
By Volume	1:1	
Cure Schedule	72hours @RT 1Hr@90C	
Viscosity – Part A Viscosity – Part B Viscosity - Mixed	4500cps @1/s 15000cps @1/s 67000cps @1/s	Rheometer parallel plate 25mm@1/s
Specific Gravity – Part A Specific Gravity – Part B Specific Gravity - Mixed	1.13 1.54 1.32	Calculated
Pot Life	40mins	Rheometer parallel plate 25mm@1/s
Gel Time	100minutes/20cc sample	Gardco Hot Pot Gel Timer
Glass Transition Temperature/Tg	20°C	DSC
Hardness 72Hrs 1H@90C	72D 75 Shore D	ASTM D2240
Water Absorption	0.3% after 24 hours	ASTM D570
Tensile Properties: Strength Elongation	4000 psi 100% 15000 psi	ASTM D638/MTS
Bulk Resistivity	1.0E12 ohm-cm	Jandel 4 point probe
Non volatile content	100 %	

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DIRECTION OF USE

- Cartridge format: Mixer should be attached keeping the cartridge vertical and any air pocket purged this way. Attach a new static mixer with each cartridge, then pre-bleed the first 3 inches of dispensed material or until a uniform color is obtained. Maintain adequate velocity during dispensing to ensure complete mixing.
- Bulk format: stir until homogeneous weigh and mix parts A and B accurately and thoroughly, scraping sides of container often. Do not pour from mixing container, transfer to a new container as residual unmixed material may cause a tacky spot on the surface of the casting.
- Allow to cure undisturbed until product is fully gelled or tack-free to the touch.
- Clean up uncured resin with suitable organic solvent such as MEK, acetone or other organic solvent.

STORAGE & SHELF LIFE

6 months at 25 °C in cartridge with Aluminum foil package Specialty packaging may be less.

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