



TECHNICAL INFORMATION

HARDMAN[®] Urethane D-85 Adhesive DOUBLE/BUBBLE[®] Blue/Beige Package #04023

PRODUCT DESCRIPTION

Urethane D-85 is a rigid, two-component, extra fast setting, polyurethane structural adhesive system. It displays an excellent combination of shear strength and peel strength, with good impact resistance. It is highly recommended for bonding engineering thermoplastics, SMC, laminated surfaces and repair of urethane molded parts.

Urethane D-85 is recommended for the following substrates:

<u>Metal</u>	<u>Plastic</u>	<u>Other</u>
Carbon Steel	Epoxy	Stone
Stainless Steel	Phenolic	Glass
Aluminum	Polyester	China
Tin	Urethane	Leather

TYPICAL USES

Urethane D-85 can be used to repair urethane parts. It is recommended for repair of rubber hoses and flexible electrical connections.

PACKAGING

The DOUBLE/BUBBLE package is a handy, dual-pouch, one-shot, job-size packaging concept. It reduces the waste typically associated with the use of larger quantities of two-component adhesives. This unique packaging ensures that DOUBLE/BUBBLE adhesives are always factory fresh and accurately portioned for optimum adhesive performance.

Urethane D-85 is also available in poly bottles, 1-gallon cans, 5-gallon pails and 55-gallon drums.

HOW TO USE

Surface must be clean and dry before application. Remove all chemicals, dirt wax and oil.



FOLD SNIP SQUEEZE MIX/APPLY

Fold the DOUBLE/BUBBLE package along the center seal, snip the end, squeeze out the contents, mix thoroughly and apply.

TYPICAL UNCURED PROPERTIES

	<u>Part A</u>	<u>Part B</u>	<u>Mixed</u>
Color	Straw	White	Beige
Viscosity @ 25 °C, cps.	18,000	4,000	11,000
Weight per Gallon, lbs.	9.23	12.29	10.54
Specific Gravity @ 25 °C	1.11	1.47	1.26
Work time, minutes	---	---	5
Handling Strength, hours	---	---	1
Shelf Life, months	12	12	---

TYPICAL CURED PROPERTIES

(Tested at 25 °C unless otherwise indicated)

<u>Test</u>	<u>Result</u>
Hardness, Shore D	85
Tensile Strength, psi	3,350
Elongation, %	80
Tear Strength, pli	800
Maximum Service Temp.	93 °C (200° F)
Water Resistance	Very Good

The adhesive strength of acid-etched aluminum to aluminum cured for 24 hours at room temperature is shown below:

	<u>-40° C</u>	<u>25° C</u>	<u>82° C</u>	<u>149° C</u>
Lap Shear Strength, psi	4,105	4,075	485	275
T-Peel Strength, pli	3.9	10	2.6	---

STORAGE AND HANDLING

Store DOUBLE/BUBBLE adhesives at room temperature in a dry environment. Extreme low temperatures may cause crystallization. Extreme high temperatures may degrade the properties.

A wide variety of cleaning solutions are available for cured and uncured epoxies and polyurethanes.

SAFETY

These materials are intended for commercial and industrial use only, and the practices of good housekeeping, safety and cleanliness should be followed before, during and after use.

Although the system contains low volatility materials, care should be taken in handling. Use adequate ventilation in the work area.

These materials may cause dermatitis in susceptible individuals. Keep off skin and out of eyes. In case of accidental skin contact, wash thoroughly with soap and water. In case of eye contact, flush eyes thoroughly with water and consult a physician immediately.

Refer to Material Safety Data Sheet for additional information.

ADDITIONAL INFORMATION

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NOTE

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