



42327/52343

42327-52343 is a medium-hardness, semi-flexible two-component polyurethane adhesive designed for bonding applications requiring resilient bonds, non-sag application and enhanced adhesion to flexible substrates. 42327-52343 is suitable for bonding metals, ceramics, natural rubber, thermosetting polymers and select types of unprepared thermoplastic substrates such as ABS, Polycarbonate and Nylon.

Technology / Base	Polyurethane
Type of Product	Structural Adhesive
Components	Two Component
Curing	Room Temperature (secondary thermal cure)
Appearance / Color	Black
Consistency	Thixotropic Paste

Features and Benefits

- Excellent bond strength to a wide variety of substrates
- Low Exotherm
- Good thermal performance
- Good chemical resistance
- Non Sag
- High Flexibility

Technical Data

Rheology	Value	Condition/Method
Viscosity - Part A	16000 cPs	at 25°C
Viscosity - Part B	83,000 cPs	at 25°C
Viscosity - Mixed	Thixotropic Paste	
Uncured Material Characteristics		
Volume Mix Ratio	100 to 100	
Weight Mix Ratio	100 to 125	
Specific Gravity	1.31	
Gel Time	3 to 5 min	at 23°C
Tack Free Time	15 min	10 g
Full Cure	18 hours at 25 °C (77 °F) -or- 2 hours at 80 °C (176 °F)	
Shelf Life	6 months unopened	
Cured Mechanical Properties		
Hardness	65 Shore D	ASTM D2240
Tensile Strength	25.6 MPa (3709 psi)	ASTM D638, 25°C 50% RH
Elongation at Break	160%	ASTM D638, 25°C 50% RH
Overlap Shear Strength		
Cold Rolled Steel, abraded	20.7 MPa (3000 psi)	ASTM D1002, 25°C 50% RH
Aluminum, abraded	15.2 MPa (2200 psi)	ASTM D1002, 25°C 50% RH
Stainless Steel, abraded	22.3 MPa	ASTM D1002, 25°C 50% RH
Electrogalvanized Steel, IPA wipe	13.1 MPa (1900 psi)	ASTM D1002, 25°C 50% RH
E-Coat Steel, IPA wipe	24.9 MPa	ASTM D1002, 25°C 50% RH
Nylon 6-6, abraded	7.2 MPa	ASTM D1002, 25°C 50% RH
ABS, IPA wipe	4.4 MPa	ASTM D1002, 25°C 50% RH
PC, IPA wipe	13.8 MPa (2000 psi)	ASTM D1002, 25°C 50% RH
GFPC, abraded	14.3 MPa	ASTM D1002, 25°C 50% RH



General Instructions

Surfaces to be bonded must be clean, dry and free from grease, oil, wax, weak oxide films and other contaminants. Bring both components to room temperature prior to mixing. Measure out specified amounts of parts A and B and mix, without introducing bubbles, until homogenous. Meter-mix equipment equipped with an automatic purge is recommended for higher volume applications. Contact your H.B. Fuller representative for suggested application equipment to suit your specific needs. We recommend that containers be purged with nitrogen after they are opened to the air and not all the material is used.

Storage

These materials should be stored in a dry environment within a temperature range of 16 °C to 27 °C (60 °F to 80 °F). Extremes of temperature beyond this range may result in crystallization or polymerization of the materials. Introduction of a nitrogen blanket into the containers before closing will improve the storage life of the products. A wide variety of cleaning solutions are available for cured and uncured epoxies and polyurethanes. For more information on proper recommendations and procedures, contact the Technical Department.

Specifications and Approvals

Handling and Clean-Up

See SDS for handling and clean-up information.

Safety and Disposal

See SDS for safety and disposal information.

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