



H.B. Fuller UR4515G

This is a two component, polyurethane adhesive designed for structural bonding of metals and plastics. This product offers high lap shear strength, good thixotropy for easy application, and good work life.

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

Features and Benefits

- No solvents, plasticizers, or low volatile components
- 1:1 mix ratio by volume, designed for easy use with automated dispense systems
- Excellent moisture penetration seal
- Extreme environmental and abrasion resistance
- Room temperature curing, no heat required
- Non-conductive, non-corrosive
- Outstanding chemical resistance
- High impact strength
- Will not induce stress cracking in polycarbonate or polyethylene parts

Technical Data

Uncured Material Characteristics	Value	Condition/Method
Viscosity - Part A	1,500,000 cPs	at 25°C
Viscosity - Part B	25,000 cPs	at 25°C
Viscosity - Mixed		
Specific Gravity	1.25	
Volume Mix Ratio	1 to 1	
Weight Mix Ratio	100 to 84	
Pot Life		
Gel Time	15 min	at 23°C 100 gram
Handling Time		
Full Cure @ 23°C	2 to 3 days	
Full Cure @ 70°C	1 to 2 hours	
Shelf Life	12 months unopened	
Cured Mechanical Properties		
Hardness	80 Shore D	ASTM D2240
Tensile Strength	12.8 MPa	ASTM D638, 25°C 50% RH
Elongation at Break	60%	ASTM D638, 25°C 50% RH
Overlap Shear Strength		
Aluminum, abraded	25.96 MPa (3765 psi)	ASTM D1002, 25°C 50% RH
Stainless Steel, abraded	20.36 MPa (2950 psi)	ASTM D1002, 25°C 50% RH
E-Coat Steel, IPA wipe	24.16 MPa (3500 psi)	ASTM D1002, 25°C 50% RH
Polycarbonate, 20% Glass Fill, abraded	18.38 MPa (2660 psi)	ASTM D1002, 25°C 50% RH
Nylon 6-6, abraded	7.00 MPa (1010 psi)	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.

Specifications and Approvals

MIS 31867 Rev. G

Storage

Product should be stored in a cool dry place out of direct sunlight. The shelf life is from date of manufacture. Shelf life is based on the products being stored properly at temperatures between 16°C and 25°C. Exposure to temperatures above 25°C will reduce the shelf life. This product should not be frozen. Purge opened containers with dry nitrogen inert blanketing gas before resealing.

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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