

ADINOFLEX PU 323

HIGH MODULUS PU SEALANT

TECHNICAL DATA SHEET

ADINO™ Polyurethane Adhesive Sealant **ADINOFLEX PU 323** is a one component, fast curing adhesive which forms a rigid yet elastic permanent bond. ADINOFLEX PU 323 bonds to a wide variety of materials including metal, glass, acrylic, polycarbonate, and many other materials.

FEATURES / ADVANTAGES

| FEATURE | ADVANTAGE |
|---|--|
| One component/moisture curing | No mixing Simplifies production |
| Bonds dissimilar materials | Gives design flexibility |
| Adheres to commonly used materials | Multiple uses and design flexibility |
| High strength | Provides long lasting bonds |
| Fast curing | Speeds production |
| Higher modulus / High Shore A Hardness | Ideal for bonding Gives high strength bonds |

TECHNICAL DATA

| PROPERTIES | ADINOFLEX PU 323 |
|---|----------------------------|
| Tack-Free Time @ 73F and 50% RH | 25 - 40 minutes |
| Rate of Cure @ 73F and 50% RH | >1/8" (3.5 mm) per 24 hour |
| Shore A Hardness (DIN 53505) | 55 +/- 5 |
| Tensile Strength (ASTM D412) | 1450 psi (10 MPa) |
| Elongation at Break (ASTM D412) | >700% |
| 100% Modulus (ASTM D412) | >870 psi (>6 MPa) |
| Specific Gravity | 1.28 |
| Consistency | Thixotropic paste |
| Application Temperature | 40°F - 95°F (5°C - 35°C) |
| Shearing resistance at 5 hours /23°C/50%RH | >130 psi |
| Shearing resistance at 7 days/23°C/50%RH | >500 psi |

STRONGMAN CHEMICALS

Agape World Pvt. Ltd.

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APPLICATION IDEAS

| Market | ADINOFLEX PU 323 |
|-------------------|---------------------------------|
| Marine | ✓ |
| Specialty Vehicle | ✓ |
| | Bonds metal, glass and plastics |

PERFORMANCE DATA

Heat Resistance:

Long term exposure to temperatures greater than 212°F (100°C) will decrease tensile strength over time. Do not use these products in applications where the temperatures will continuously exceed 212°F (100°C).

DIRECTIONS FOR USE

SURFACE PREPARATION:

Surfaces to be sealed or bonded should be clean and dry. Surfaces should be free from grease, mold release, oil, water/condensation, and other contaminants that may affect the adhesion of the sealant. Abrading with 180 to 220 grit abrasive followed by a solvent wipe will improve the bond strength.

*When using solvents, use in a well-ventilated area. Extinguish all sources of ignition in the work area and observe product directions for use and precautionary measures. Refer to solvent label and MSDS for further precautions. Always pre-test solvent to ensure it is compatible with substrates.

PRIMER:

Use of a primer is recommended for window bonding using ADINO™ Polyurethane Adhesive Sealant ADINOFLEX PU 323. Surface prep consists of the appropriate ADINO PPRIMER 327 to both bonding surfaces. In areas with VOC restrictions, it is imperative that bonding surfaces are clean of contaminants. It may be acceptable to bond fritted glass without primer if the frit area is abraded with abrasive to improve adhesion.

Do not apply ADINOFLEX PU 323 on frozen or wet surfaces. Do not apply over silicone nor in the presence of curing silicone.

ALIGNMENT:

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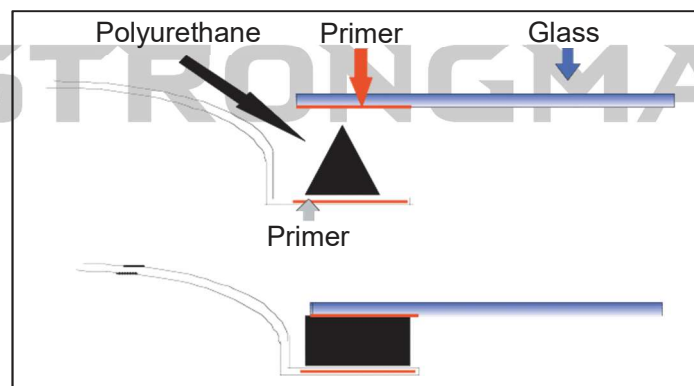
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Dry-set glass and align for uniform fit. Adjust setting blocks as required. Apply masking tape to the corners and frame to aid with alignment when bonding. Clean entire surface of main body using a solvent or non-greasy cleaner. Clean entire surface of window of vehicle using a non-greasy glass cleaner: clean back side first, then flip over and clean front side (bonding side) second.

APPLY APPROPRIATE ADINO PRIMER 327 TO SUBSTRATES WHEREVER REQUIRED:

Shake appropriate ADINO Primer for 30 seconds after you hear the ball moving inside the bottle. Dip a clean wool dauber into the primer. Roll the dauber around the edge of the bottle to squeeze out excess primer. Replace cover on primer bottle. Apply a single continuous layer of primer to the surface. Wait 30 minutes to dry.

ADINO™ Polyurethane Adhesive Sealant ADINOFLEX PU 323 should be used within 24 hours after cartridge is opened. Dispense ADINOFLEX PU 323 onto the primed main body with the nozzle tip perpendicular to the substrate to insure uniform contact with the substrate. Press window into the frame until the triangle bead is squeezed to half its original height. The cross-section of the bond should be approximately 1/4" x 1/4" (5 mm x 5 mm) square after application:



Apply clamps if necessary. Curing time is dependent upon the temperature and humidity. Please see attached chart for reference.

STORAGE

ADINO™ Polyurethane Adhesive Sealant ADINOFLEX PU 323 must be stored in a controlled environment to maximize shelf life. Store the products in the original unopened containers below 77°F (25°C).

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SHELF LIFE

When stored at recommended conditions, the shelf life of cartridges and sausage packs is 12 months from the date of manufacture. For 5 and 55 gallon containers, the shelf life is 9 months from date of manufacture.

SAFETY

Please refer to safety data sheet which is available on request.

TYPICAL CURING TIME:

TIME (HOURS) TO REACH OVERLAP SHEAR STRENGTH

| | Time (hr) | 40°F (4°C) | 50°F (10°C) | 60°F (15.5°C) | 70°F (21°C) | 80°F (27°C) | 90°F (32°C) |
|---------|-----------|------------|-------------|---------------|-------------|-------------|-------------|
| 100 psi | >80% RH | 21 hr | 8.5 hr | 4 hr | 2.5 hr | 1 hr | 1 hr |
| | 75% RH | 24 hr | 10 hr | 5 hr | 3 hr | 1.5 hr | 1.5 hr |
| | 50% RH | 47 hr | 16.5 hr | 9 hr | 4 hr | 2.5 hr | 1.5 hr |
| 150 psi | >80% RH | 40 hr | 13 hr | 6.5 hr | 3 hr | 1.5 hr | 1 hr |
| | 75% RH | 43 hr | 14.5 hr | 7.5 hr | 4 hr | 2 hr | 1.5 hr |
| | 50% RH | 72 hr | 26 hr | 13 hr | 5 hr | 3.5 hr | 2.5 hr |
| 250 psi | >80% RH | 75 hr | 22 hr | 10 hr | 5.5 hr | 2.5 hr | 2 hr |
| | 75% RH | 77 hr | 24 hr | 12 hr | 6.5 hr | 3 hr | 2.5 hr |
| | 50% RH | 120 hr | 47 hr | 21.5 hr | 9 hr | 5.5 hr | 3.5 hr |

PRODUCT USE

Many factors beyond STRONGMAN CHEMICALS control and uniquely within user's knowledge and control can affect the use and performance of this product in a particular application. Given the variety of factors that can affect the use and performance of a STRONGMAN CHEMICALS product, user is solely responsible for evaluating the STRONGMAN CHEMICALS product and determining whether it is fit for a particular purpose and suitable for user's method of application.

LIMITATION OF LIABILITY

STRONGMAN CHEMICALS will not be liable for any loss or damage arising from the STRONGMAN CHEMICALS product, whether direct, indirect, special, incidental or consequential, regardless of

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the legal theory asserted, including warranty, contract, negligence or strict liability. Users have to ascertain applicability of the product for their specific usage.



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