

URE-BOND™ 90

Urethane Adhesive



www.smooth-on.com

PRODUCT OVERVIEW

URE-BOND™ 90 is a two component, slightly expanding urethane adhesive that offers a strong, rigid bond between many different surfaces. It is often used to bond segments of tooling board as well as other porous and non-porous, rigid substrates.

Working time is 8 minutes, handling time is 4 hours and full cure time is 16 hours at room temperature (73°F / 23°C).

TECHNICAL OVERVIEW

Mix Ratio: 1A : 1B by volume, 100A : 88B by weight

Mixed Viscosity, cps: 6,500 (ASTM D-2393)

Specific Gravity, g/cc: 1.11 (ASTM D-1475)

Pot Life: 8 minutes (73°F / 23°C) (ASTM D-2471)

Handling time: 4 hours (73°F / 23°C)

Cure time: 16 hours (73°F / 23°C)

Color: Amber

Shore D Hardness: 90 (ASTM D-2240)

Specific Volume: 25 cu. in./lb.

* All values measured after 7 days at 73°F/23°C

PROCESSING RECOMMENDATIONS

PREPARATION... Safety - Use in a properly ventilated area ("room size" ventilation). Wear safety glasses, long sleeves and rubber gloves to minimize contamination risk.

Store and use material at room temperature (73°F/23°C). This product has a limited shelf life and should be used as soon as possible.

Surface preparation - It is essential that the surface of both substrates to be bonded be absolutely clean and dry. Porous surfaces should be sanded until clean and any excess dust removed thoroughly. Non-porous surfaces should be degreased, dried and abraded by sanding, sandblasting or chemical etching - the etching being required for certain surfaces. Solvent wash the surface and let the solvent fully dry before applying adhesive.

MEASURING & MIXING...

Pre-mix Part B before dispensing and mixing with Part A. After dispensing equal amounts of Parts A and B into mixing container, mix thoroughly for 3 minutes making sure that you scrape the sides and bottom of the mixing container several times.

APPLYING, CURING & PERFORMANCE...

Pour or brush on to prepared surface. Position and affix other surface to substrate and clamp together for 4 hours. Cure time can be reduced by applying mild heat.

IMPORTANT: Shelf life of product is reduced after opening. Remaining product should be used as soon as possible. Immediately replacing the lids on both containers after dispensing product will help prolong the shelf life of the unused product. XTEND-IT® Dry Gas Blanket (available from Smooth-On) will significantly prolong the shelf life of unused liquid urethane products.

Safety First!

The material safety data sheet (MSDS) for this or any Smooth-On product should be read before using and is available on request. All Smooth-On products are safe to use if directions are read and followed carefully. **Keep Out of Reach Of Children.**

Be Careful. Part A (Yellow Label) contains methylene diphenylisocyanate. Vapors, which can be significant if heated or sprayed, may cause lung damage and sensitization. Use only with adequate ventilation. Contact with skin and eyes may cause severe irritation. Flush eyes with water for 15 minutes and get immediate medical attention. Remove from skin with soap and water.

Part B (Blue Label) is irritating to the eyes and skin. Avoid prolonged or repeated skin contact. If contaminated, flush eyes with water for 15 minutes and get immediate medical attention. Remove from skin with soap and water. When mixing with Part A, follow precautions for handling isocyanates.

IMPORTANT - The information contained in this bulletin is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained from the use thereof, or that any such use will not infringe a copyright or patent. User shall determine suitability of the product for the intended application and assume all associated risks and liability.



Call Us Anytime With Questions About Your Application.

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The new www.smooth-on.com is loaded with information about mold making, casting and more.

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