

## PC-3102 Urethane Filter Adhesive

Blue, Pool/Spa filter with Shore A 85 hardness

## Technical Bulletin

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PC-3102 is a two component, room temperature cured, unfilled, tough elastomeric urethane adhesive designed for cast-in-place operation. The combination of low viscosity and unique gelling characteristics of the material at moderate processing temperature (125°F - 150°F) yields a fast de-mold time that is ideal for filter manufacturing.

### Typical Uncured Properties

Color	
Resin	Blue
Hardener	Clear
Mixed	Blue
Viscosity, cps @ 77°F +/- 3°F	
Resin	500–900
Hardener	1000–1200
Mixed	~1000
Density, Lbs/Gal @ 77°F +/- 3°F	
Resin	8.10–8.20
Hardener	10.00–10.05
Mixed	9.00–9.08

### Mixing Specifications & Characteristics

Mix Ratio:	
By Weight	100 parts resin to 90 parts hardener
By Volume	1.37 parts resin to 1 part hardener
Gel Time, min:sec @ 77° +/- 3°F	
190 Gram Mass	2:00–2:30
Cure Cycle (Full Cycle)	7 Days

### Typical Cured Properties

Color	Translucent Blue
Hardness (Shore A)	85
% Weight Loss, 7 Days @ 225°F	0.5
Tensile Strength (psi)	1400
% Elongation	80
Tear (DIEC) oli	110
Max. Operating Temperature (°F)	
Continuous	180°
Intermittent	212°



### Processing Instructions

For good results, automatic mixing and dispensing equipment should be used. Please consult with Polyset technical staff before making final processing decisions.

### Storage

Keep away from flames. Material should be used once container is opened. Long term storage of opened material should be under nitrogen. Shelf life of both resin and hardener is 6 months @ 25°C (77°F) in unopened containers. Storage temperatures for the hardener (isocyanate) should be maintained at 18-35°C. Under these storage conditions, the hardener will remain clear for periods of up to six months.

If solidification should occur because of exposure to temperatures below 18°C, the product can be reheated up to 60°C in a well ventilated oven for the minimum amount of time necessary to render it clear. Excessive heating causes dimerization, loss of NCO, and increase in viscosity. In the event of crystallization, please contact Polyset for recommendations.

### Safety Information

Avoid direct contact. Use gloves when handling resin and hardener, if skin contact occurs, wash with soap and water. If resin or hardener enters the eyes, flush with cool water for at least 15 minutes and call a physician immediately. Refer to SDS on PC-3102 for further details.

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