

PC-3115 Urethane Filter Adhesive

White, Chemically-Resistant Adhesive; Shore D 70

Technical Bulletin

Rev. Date: 6/13/2014

PC-3115 is a white, filled, two-component, fast gelling, room-temperature curing urethane system. This system has been formulated to possess excellent chemical resistance in hydraulic oil, gasoline, and water/ethylene glycol.

Key Features

- Fast Gel Time.
- Flexible, yet Tough.
- Excellent Adhesion to a Variety of Substrates.
- Excellent Chemical Resistance.
- High Temperature Resistance.
- Resistant to Jet Fuel .
- Quick Demold Time.
- TDI-free and Mercury-free Urethane System.

<u>Chemical Resistance</u> <u>(500 hour exposure)</u>	% Weight Change	% Hardness Change
Gasoline @ 25°C (77°F)	5.70	-40
Hydraulic Oil @ 122°C (250°F)	0.77	10
50/50 Water/Glycol @ 112°C (233°F)	7.00	0

Typical Uncured Properties

Color	
PC-3115 Resin (Polyol Component)	White
PC-3115 Hardener (Isocyanate Component)	White
PC-3115 Mixed	White
Viscosity (Brookfield) @ 25°C ± 1°C (77°F ± 2°F); cPs	
PC-3115 Resin	4,500
PC-3115 Hardener	2,500
PC-3115 Initial Mixed	4,000
Density @ 25°C ± 1°C (77°F ± 2°F); Lbs./Gal. (g/cm ³)	
PC-3115 Resin	11.72 (1.29)
PC-3115 Hardener	10.00 (1.20)
PC-3115 Mixed	9.90 (1.19)

Mixing Specifications & Characteristics

Mix Ratio	
Parts by Weight	100 parts Resin : 32.5 parts Hardener
Parts by Volume	2.65 parts Resin : 1.00 part Hardener
Processing Time @ 25°C ± 1°C (77°F ± 2°F); min:sec	
Gel Time (132.5 gram mass; 250 mL beaker)	2:15
Thin Section Gel Time	3:00
Recommended Cure Times; hours	
Room Temperature Cure	24
Oven Cure @ 85°C (185°F)	2
Oven Cure @ 100°C (212°F)	1

Typical Cured Properties

Color	White
Hardness; Shore D	70
Tensile Strength; psi	1,000
Elongation; %	150
Tear Strength (Die C); Lbs./in.	170

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 Information

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 PC-3115 Resin and PC-3115 Hardener is 6 months @ 25°C (77°F) in unopened containers.

Safety Information

Avoid direct contact. Use gloves when handling PC-3115 Resin and Hardener. If skin contact occurs, wash with soap and water. If PC-3115 Resin or Hardener enters the eyes, flush with cool water for at least 15 minutes and call a physician immediately. Refer to product Safety Data Sheets for detailed safety & handling information.

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