

PC-3139 Rigid Foam Adhesive

Tan, Pour-in-Place Foam Adhesive with 200% Rise

PC-3139 is a two component, rigid, unfilled urethane base adhesive. This system was developed to replace conventional elastomers, in terms of lower cost per part, reduced weight, and higher productivity.

Key Features

- Low Initial Mixed Viscosity
- Quick Gelling for Fast De-mold Times
- Excellent Adhesion to Metal & Plastic Substrates
- Excellent Dimensional Stability
- Excellent Chemical & Thermal Resistance

Typical Uncured Properties

Color

PC-3139 Resin (Polyol Component)	Brown Amber
PC-3139 Hardener (Isocyanate Component)	Brown Amber

Viscosity (Brookfield) @ 25°C ± 1°C (77°F ± 2°F); cPs

PC-3139 Resin	2,450
PC-3139 Hardener	225

Density @ 25°C ± 1°C (77°F ± 2°F); Lbs./Gal. (g/cm³)

PC-3139 Resin	8.90 (1.07)
PC-3139 Hardener	10.20 (1.22)

Mixing Specifications & Characteristics

Mix Ratio

Parts by Weight	100 parts Resin : 83 parts Hardener
Parts by Volume	1.39 parts Resin : 1.00 part Hardener

Processing Times @ 25°C ± 1°C (77°F ± 2°F); min:sec

Crème Time	0:50–1:00
Gel Time (100 gram mass; 250 mL beaker)	1:15
De-mold Time	4:00–8:00
Full Cure	7 Days

Percent Blowing @ 25°C ± 1°C (77°F ± 2°F); % 150–200

Processing Instructions

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

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Technical Bulletin



Filter sealed with Rigid Foam Adhesive

Note: Black version shown. PC-3139 is tan in color.



Rigid Foam Adhesive on Filter End-Cap

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-3139 Resin and PC-3139 Hardener is 6 months @ 25°C (77°F) in unopened containers.

Safety Information

Avoid direct contact. Use safety goggles or safety glasses with side shields and impervious gloves when handling PC-3139 Resin and PC-3139 Hardener. If skin contact occurs, wash with soap and water. If PC-3139 Resin or PC-3139 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 further information.