

TECHNICAL DATA

PR-2701 General Purpose Elastomeric Adhesive

Description

PR-2701 is a Permapol® based two-part elastomeric, chemically curing adhesive. It exhibits excellent adhesion to properly prepared metal, plastic, wood, and ceramic surfaces. PR-2701 is characterized by retention of physical properties over a broad range of temperatures from -100°F (-73°C) to 200°F (95°C). It cures at room temperature to form a resilient sealant. The cure can be accelerated by heat.

PR-2701 is self-adhering to the following surfaces: (when cleaned with Methyl Ethyl Ketone or MIL-S-8802 cleaner): aluminum, copper, steel, glass, molded polyurethane (RIM), concrete, SMC, valox, nylon, EPDM, wood, PVC, nordel, ceramic, epoxy polyamide, fiberglass, noryl, neoprene, and mylar.

Application Properties (Typical)

Color			
Part A			Black
Part B			White
Mixed			Black
Mixing ratio			Part A:Part B
By weight			33:100
Base viscosity			
(Brookfield #7 @ 10 rpm),			
Poise (Pa-s)			3,500 (350)
Application life and cure time @ 77°F (25°C), 50% RH			
	Application life (minutes)	Tack free time (hours)	Cure time to 20 A Durometer (hours)
	10	1.5	2

Performance Properties (Typical)

Cured 7 days @ 77°F (25°C), 50% RH	
Ultimate cure hardness, Durometer A (ASTMD-2240)	50
Tensile strength, psi (KPa),	300 (2070)
Elongation, %	300
Flammability (MVSS 302)	Conforms
Lap shear (ASTM D1002), psi	260
Peel strength (ASTM D1781), pli (N/25 mm)	29 (129)
Electric properties, (ASTM D-150, D-257)	
14 days @ 77°F (25°C), 50% RH	
Volume resistivity, ohm/cm	4.5 X 10 ¹²
Surface resistivity, ohm/cm	4.2 X 10 ¹¹

Note: The application and performance property values above are typical for the material, but not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.

Surface Preparation

Immediately before applying sealant to primed substrates, the surfaces should be cleaned with solvents. Contaminants such as dirt, grease, and/or processing lubricants must be removed prior to sealant application.

A progressive cleaning procedure should be employed using the appropriate solvents and new lint-free cloth (Reclaimed solvents or tissue paper should not be used.) Always pour solvent on the cloth to avoid contaminating the solvent supply. Wash one small area at a time.

It is important that the surface is dried with a second clean cloth prior to the solvent evaporating to prevent the redeposition of contaminants on the substrate.

Substrate composition can vary greatly. This can affect sealant adhesion. It is recommended that adhesion characteristics to a specific substrate be determined prior to application on production parts or assemblies.

For a more thorough discussion of proper surface preparation, please consult the SAE Aerospace Information Report AIR 4069. This document is available through SAE, 400 Commonwealth Avenue, Warrendale, PA 15096-0001.

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Mixing Instructions

PR-2701 is supplied in a two-part kit. Mix according to the ratios indicated in the application properties section. Mix Part A and Part B separately to uniformity, then thoroughly mix entire contents of both parts of kit together taking care to avoid leaving unmixed areas around the sides or bottom of the mixing container.

Storage Life

The storage life of PR-2701 is at least 12 months when stored at temperatures below 80°F (27°C) in original unopened containers.

Health Precautions

This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Material Safety Data Sheet (MSDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An MSDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure.

For industrial use only. Keep away from children.

For emergency medical information call 1-800-228-5635.

Additional information can be found at: www.ppgaerospace.com

For sales and ordering information call 1-800-AEROMIX (237-6649).

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