

Sheldahl Abrasive Belt Adhesives

PRODUCT DESCRIPTION

Sheldahl[®] Brand Polyurethane Adhesive is designed to be used in conjunction with an isocyanate curing agent as a two-component system. These systems produce a tough, flexible, temperature and chemical resistant bond.

APPLICATIONS

Sheldahl[®] Brand Adhesives are specifically designed for splicing abrasive belts and may be used as a general adhesive for plastics, rubber, fabrics, leather, wood and paper.

GENERAL PROPERTIES

- **Composition** Linear polyesterurethane
- **Form** Light syrup
- **Color** Pearl gray/straw
- **Recommended Isocyanate Curative** NE-S
- **Pot Life** 4-6 Hours after Curative addition, depending on ambient conditions

TYPICAL FORMULA PROPERTIES

	A651-20	A651-15	A455-20	A455-15	A667-20	A667-15 & A667-15 RED
Solvent	Ethyl Acetate / Acetone	Ethyl Acetate / Acetone	MEK	MEK	Ethyl Acetate / Acetone	Ethyl Acetate / Acetone
Solids %	20	15	20	15	20	15
Viscosity cps @ 22°C	2200-4800	600-1300	1800-3800	350-600	1500-3500	300-500
Weight per gallon pounds (Kg)	7.65 (3.48)	7.55 (3.43)	7.28 (3.31)	7.05 (3.20)	7.60 (3.45)	7.45 (3.39)

Curative NE-S Addition

to: 1 Volume of Curative	12 volumes	16 Volumes	12 volumes	16 Volumes	12 volumes	16 Volumes
to: 1 Grams of Curative	11 grams	14.6 grams	11 grams	14.6 grams	11 grams	14.6 grams

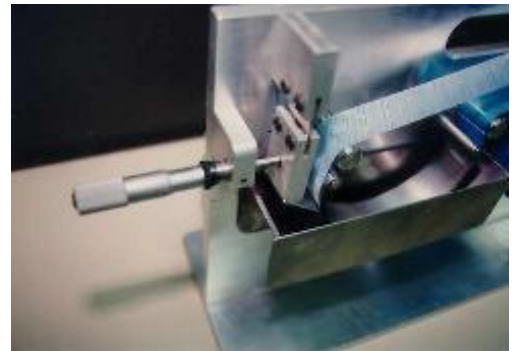
TRANSPORTATION DATA

Domestic Hazard Class Flammable Liquid

UN/NA UN1133

International Hazard Class 3.2

UN/NA UN1133



STORAGE AND USE

Sheldahl® Brand Adhesives are flammable liquids. Use only in well-ventilated areas. Extinguish all flames, including pilot lights. Avoid any spark producing equipment. Make a special effort to keep adhesives contained while processing. Store adhesives tightly sealed in cool, dry, well-ventilated area.

Properly stored adhesive may be used for up to 6 months before retesting. Gelling and separation is a common behavior of this high performance resin, especially when exposed to the cold during transport and storage.

*****All Sheldahl® Brand Adhesives must be well mixed before each use**

APPLICATION

Sheldahl® Brand Adhesives are used in abrasive belt manufacturing in three ways:

1. Applying adhesive to the belt ends, forming an overlap and bonding using heat and pressure.
2. Applying adhesive to the belt ends and to Uncoated Splicing Tape ([PB-1002](#)) then adhering the butted ends of the belt with the tape and bonding using heat and pressure.
3. Applying adhesive to the belt ends, then adhering the butted ends using Coated Splicing Tape ([PB-1001](#)) and bonding using heat and pressure.

Sheldahl® Brand Adhesive may be applied using a brush, roller, knife, or by spraying. A045500 is particularly well suited for spraying because it maintains a low viscosity at higher solids. A065100 is recommended for roller and tape coating. A066700 is lower viscosity adhesive without the aroma of MEK.

Sheldahl® Brand Materials are world leaders in a wide variety of adhesive-based products used in applications ranging from aerospace to automotive. We bring unique capabilities as the leading supplier of abrasive belt joining materials. Our engineers use state-of-the art laboratory and manufacturing equipment to assure that Sheldahl® brand materials meet the most rigorous test and performance requirements.

Sheldahl's technical and customer support staff are committed to provide the best total value through quality, delivery and service.

NOTICE

All statements and typical data regarding this product are believed to be true and accurate.

Recommendations are made without guarantee since conditions of use are beyond our control. Sheldahl disclaims any liability incurred in connection with the use of this product or information contained herein. The information contained shall not be construed as a recommendation to use any product in conflict with existing patents covering any material or its use.

It is Sheldahl's commitment and responsibility to produce high quality material that conforms to specification. Please consult instructions on this bulletin and on supplied Safety Data Sheet before use.