



H.B. Fuller Company
P.O. Box 64683
St. Paul, MN 55164-0683

PD2128D
PRODUCT NUMBER

Page 1 of 5

TECHNICAL DATA SHEET

TruTac 2128 Insulation Adhesive

Product Description

PD-2128D is a fast-tack, high solids, acrylic, water-based pressure sensitive (PSA) adhesive developed for rapid assembly of fiberglass insulation, nonwovens, and light-weight materials. PD2128D bonds while still wet and resists heat, humidity, moisture and freezing temperatures.

Product Features

- Instant, aggressive, permanent tack for fast assembly
- High solids / High coverage rates
- Spray, roll coat, or brush application
- One component
- Low viscosity
- Meets the safety challenge: no solvent, no caustic, low odor, non-flammable in wet state
- Zero VOC
- UL Certified
- Higher mileage than conventional high viscosity waterbase products
- Easy clean up

Performance Standards / Certifications

- Certified Underwriters Laboratories. Listing MAGW2 (Adhesives, Insulation Component)
HBF File Number MH-7871

Underwriter's Laboratories, Inc. Tunnel Test – ASTM E-84		
Measurement	UL Requirement	TruTac 2128 Test Results
Flame Spread	<25	1.38
Smoke Development	<50	0.1

Typical Physical Properties

Property	Value
COLOR	WHITE
DENSITY	8.6 lb-mass/gal
PH	3.5 - 4.5
SHELF LIFE	1 year
SOLID CONTENT (NON-VOLATILES)	54 - 58 percent
VISCOSITY	20 - 1,100 cP



Application Methods

- Spray
- Roll Coat
- Brush

This adhesive is designed to be applied by spray, roll coat or brush methods. Contact your H.B. Fuller representative to help you select the right system for your operation. H.B. Fuller has trained technicians who can help set up and train personnel in the operation of most application equipment.

Application Guidelines

Surface Preparation: Surfaces must be free of dust, dirt, oil, grease and moisture to assure proper adhesion.

Application: PD2128D can be applied by spray, roll coat, or brush application.

Coverage: Coverage rates depend on the porosity of the substrates and method of application.

Fiberglass Insulation:

- Spray the adhesive on one side of fiberglass insulation at a coverage of 3 – 6 grams wet/ft²
- Allow up to 30 to 60 seconds depending on temperature and humidity
- Attach to steel or aluminum surface using hand pressure only

Mineral Wool to itself:

- Spray the adhesive to both surfaces
- Allow up to 30 to 60 seconds depending on temperature and humidity
- Combine with hand pressure
- Mineral Wool failure should occur once the water has completely dissipated (depends on temperature and humidity)

Fiberglass Facing Material to Mineral Wool and Fiberglass insulation:

- Spray or roll coat the adhesive onto the facing material
- Within 30 – 60 seconds combine facing to mineral wool or fiberglass insulation using light pressure.

Spray / Pump Equipment Recommendations

- Graco, Binks, and DeVilbiss HVLP hand guns
- Pressure Feed Systems are recommended for best control to achieve desired delivery rate and spray pattern. The adhesive can be dispensed into the spray guns in several ways: Pressure Pot: Stainless Steel; or plastic liner; intake tube must be stainless steel
- Pumping Equipment: Double Action diaphragm pump, Graco Husky 1040.
- Gravity Feed: Feed from 300 gallon tote bin positioned on elevated tower.

HVLP Starting Recommendations				
Type	Fluid Nozzle	Air Cap	Fluid Pressure	Atomization Pressure
Graco 239542	239592	192315	5-10 psi	30-50 psi
Binks BBR	20	905P	5-10 psi	30-50 psi
DeVilbiss JGA 510	FX	98	5-10 psi	30-50 psi

Cleanup Procedures

- When still wet, use warm soapy water

For dry adhesive removal: MEK, isopropyl alcohol, or "environmentally safe" solvents such as Citrex (Inland Technology)

Storage and Handling

- Protect from freezing
- Storage temperatures between 60-85° F (15-30°C) are recommended.

No special handling instructions due to toxicity. This product contains limited amounts of residual monomer. Under normal handling and use conditions the residual monomer should not present a hazard. In storage, the monomer will migrate from the emulsion and establish an equilibrium between the headspace in the storage container and the liquid emulsion. Levels in excess of acceptable exposures can accumulate in non-vented headspaces above the emulsion. All procedures appropriate for a confined space entry should be completed prior to performing any work in a bulk storage tank.

Shelf Life

12 months from date of manufacture when stored in original, unopened container at recommended temperature conditions.

LIMITED WARRANTY AND TERMS

H.B. FULLER COMPANY

H.B. Fuller Company ("Fuller") warrants that, for a Warranty Period of one year (or the period specified on the applicable Technical Data Sheet, whichever is less) from the date of shipment from Fuller to the Initial Purchaser, that this Fuller product was manufactured in accordance with Fuller's specifications in effect on the date of manufacture. These specifications are available upon request. This Warranty does not cover test data, or any defects, damages or other harms caused to any extent or in any way by failure to follow applicable Fuller instructions, if any, or abuse or misuse of the product.

WARRANTIES DISCLAIMED — THE WARRANTY STATED IN THE PARAGRAPH ABOVE IS IN PLACE OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. Fuller EXPRESSLY DISCLAIMS ANY OTHER WARRANTIES, INCLUDING WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. ALTHOUGH Fuller MAY HAVE SUGGESTED THE PRODUCT OR DEVELOPED THE PRODUCT AT THE PURCHASER'S REQUEST, IT IS THE PURCHASER'S RESPONSIBILITY TO TEST AND DETERMINE THE SUITABILITY OF THE PRODUCT FOR THE PURCHASER'S INTENDED USE AND PURPOSE, AND PURCHASER ASSUMES ALL RISK AND LIABILITY WHATSOEVER REGARDING SUCH SUITABILITY.

LIMITATIONS OF REMEDIES AND DAMAGES — FOR ANY VALID CLAIM PRESENTED UNDER THE LIMITED WARRANTY, Fuller WILL REPLACE THE PRODUCT, OR AT ITS OPTION, REFUND THE PURCHASE PRICE. THIS REPLACEMENT/REFUND REMEDY IS THE PURCHASER'S SOLE AND EXCLUSIVE REMEDY AGAINST Fuller. THE PURCHASER AGREES THAT NO OTHER REMEDY (INCLUDING BUT NOT LIMITED TO LOST PROFITS, LOST SALES, INJURY TO PERSON OR PROPERTY OR ANY OTHER INCIDENTAL OR CONSEQUENTIAL LOSS) SHALL BE AVAILABLE TO PURCHASER FOR CLAIMS ARISING OUT OF ANY USE OF THE PRODUCT REGARDLESS OF THE LEGAL THEORY (CONTRACT, TORT OR OTHER). IN NO EVENT WILL Fuller BE OBLIGATED TO PAY DAMAGES TO PURCHASER IN ANY AMOUNT EXCEEDING THE PRICE THAT THE PURCHASER PAID FOR THE PRODUCT.

NO INDEMNITIES — Except as expressly stated herein, in no event will Fuller be liable to indemnify or to hold Purchaser harmless against any form of liability.

LIMITATION OF ACTIONS AND VENUE — Any claim made or action commenced by Purchaser under Fuller's limited warranty as set forth herein must be brought within one year from the date of shipment from Fuller to the Purchaser. Purchaser agrees that all disputes arising from Fuller's sale of product to Purchaser shall be brought, if at all, in and before a court located in the State of Minnesota, to the exclusion of the courts of any other state.

ARBITRATION — Purchaser agrees that any claim of less than \$100,000 shall be submitted for binding arbitration before a single arbitrator and shall be governed by the rules and procedures of the American Arbitration Association. The arbitrator and the American Arbitration Association shall be paid by the Purchaser.

CONDITIONAL ACCEPTANCE — Fuller's acceptance of Purchaser's order for this product is expressly

ADEQUATE TESTS: The information contained in this bulletin we believe is correct to the best of our knowledge and tests. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that adequate tests be made in your laboratory or plant to determine if this product meets all of your requirements.



H.B. Fuller

H.B. Fuller Company
P.O. Box 64683
St. Paul, MN 55164-0683

PD2128D
PRODUCT NUMBER

Page 4 of 5

H.B. FULLER'S ACCEPTANCE OF ANY ORDERS FOR THIS PRODUCT IS EXPRESSLY CONDITIONAL UPON PURCHASER'S ASSENT TO THE TERMS SHOWN ON THE REVERSE SIDE.



LIMITED WARRANTY AND TERMS

H.B. Fuller Company ("Fuller") warrants that, for a Warranty Period of one year (or the period specified on the applicable Technical Data Sheet, whichever is less) from the date of shipment from Fuller to the Initial Purchaser, that this Fuller product was manufactured in accordance with Fuller's specifications in effect on the date of manufacture. These specifications are available upon request. This Warranty does not cover test data, or any defects, damages or other harms caused to any extent or in any way by failure to follow applicable Fuller instructions, if any, or abuse or misuse of the product.

WARRANTIES DISCLAIMED -- THE WARRANTY STATED IN THE PARAGRAPH ABOVE IS IN PLACE OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. Fuller EXPRESSLY DISCLAIMS ANY OTHER WARRANTIES, INCLUDING WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. ALTHOUGH Fuller MAY HAVE SUGGESTED THE PRODUCT OR DEVELOPED THE PRODUCT AT THE PURCHASER'S REQUEST, IT IS THE PURCHASER'S RESPONSIBILITY TO TEST AND DETERMINE THE SUITABILITY OF THE PRODUCT FOR THE PURCHASER'S INTENDED USE AND PURPOSE, AND PURCHASER ASSUMES ALL RISK AND LIABILITY WHATSOEVER REGARDING SUCH SUITABILITY.

LIMITATIONS OF REMEDIES AND DAMAGES -- FOR ANY VALID CLAIM PRESENTED UNDER THE LIMITED WARRANTY, Fuller WILL REPLACE THE PRODUCT, OR AT ITS OPTION, REFUND THE PURCHASE PRICE. THIS REPLACEMENT/REFUND REMEDY IS THE PURCHASER'S SOLE AND EXCLUSIVE REMEDY AGAINST Fuller. THE PURCHASER AGREES THAT NO OTHER REMEDY (INCLUDING BUT NOT LIMITED TO LOST PROFITS, LOST SALES, INJURY TO PERSON OR PROPERTY OR ANY OTHER INCIDENTAL OR CONSEQUENTIAL LOSS) SHALL BE AVAILABLE TO PURCHASER FOR CLAIMS ARISING OUT OF ANY USE OF THE PRODUCT REGARDLESS OF THE LEGAL THEORY (CONTRACT, TORT OR OTHER). IN NO EVENT WILL Fuller BE OBLIGATED TO PAY DAMAGES TO PURCHASER IN ANY AMOUNT EXCEEDING THE PRICE THAT THE PURCHASER PAID FOR THE PRODUCT.

LIMITATION OF ACTIONS AND VENUE -- Any claim made or action commenced by Purchaser under Fuller's limited warranty as set forth herein must be brought within one year from the date of shipment from Fuller to the Purchaser. Purchaser agrees that all disputes arising from Fuller's sale of product to Purchaser shall be brought, if at all, in and before a court located in the State of Minnesota, to the exclusion of the courts of any other state.

CONDITIONAL ACCEPTANCE -- Fuller's acceptance of Purchaser's order for this product is expressly conditional on Purchaser's assent to terms and conditions set forth herein.

ADEQUATE TESTS: The information contained in this bulletin we believe is correct to the best of our knowledge and tests. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that adequate tests be made in your laboratory or plant to determine if this product meets all of your requirements.