

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022  
262-253-5900 FAX 262-253-5919

**DESCRIPTION:**

*ResinLab® UR7001 Clear* is a two-part clear polyester polyurethane designed to provide outstanding adhesion to a variety of plastics, as well as metals. *UR7001 Clear* provides excellent water and chemical resistance.

*UR7001 Clear* was formulated to a 1A:1B volume mix ratio for use in side-by-side dispensing cartridges and meter/mix and dispense equipment. The product will reach full cure after 24 hours under ambient conditions. The cure can be accelerated through the addition of heat. Cure schedules of 30 minutes at 65 °C or 10 minutes at 100 °C are sufficient.

*UR7001 Clear* is suitable for use in medical device assembly, it has been tested and is proven non-toxic per ISO 10993-5. Manufacturers should test their own finished product for biocompatibility. Certificates of compliance are available upon request.

**TYPICAL PROPERTIES:**

All properties given are at 25 °C unless otherwise noted.

<b>Property:</b>	<b>Value:</b>	<b>Test Method or Source:</b>
<b>Color</b>	Clear Colorless	Visual
<b>Mix Ratio</b>	Part A to Part B	Calculated
<b>Mix Ratio by weight</b>	1.02 to 1	
<b>Mix Ratio by volume</b>	1 to 1	
<b>Cure Schedule</b>	24 hrs @ 25 °C 30 min @ 65 °C 10 min @ 100 °C	
<b>Viscosity - Part A</b>	17,000 cP	TA HR20 Rheometer 25mm parallel plate @ 1/s DCV6100723
<b>Viscosity - Part B</b>	3,900 cP	
<b>Viscosity - Mixed</b>	10,500 cP	
<b>Specific Gravity - Part A</b>	1.18	Calculated
<b>Specific Gravity - Part B</b>	1.16	
<b>Specific Gravity - Mixed</b>	1.17	
<b>Pot Life defined as the time it takes for initial mixed viscosity to double</b>	6 minutes	TA HR20 Rheometer parallel plate 25mm @ 1/s DCV6100723
<b>Gel Time 100cc Sample</b>	8 minutes	
<b>Peak Exotherm</b>	89 °C for 40 mL sample	455300005593 by Type K thermocouple
<b>Hardness</b>	72 Shore D	455300006287/ASTM D2240
<b>Glass Transition Temperature/Tg</b>	33 °C	453560822409 by DSC
<b>Water Absorption</b>	0.13 %	24 hr immersion 457561824543/ASTM D570

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022  
262-253-5900 FAX 262-253-5919

<b>Property:</b>	<b>Value:</b>	<b>Test Method or Source:</b>
<b>Tensile Properties:</b>		4535601224470/ASTM D638
<b>Strength</b>	5,700 psi	
<b>Elongation</b>	9 %	
<b>Modulus</b>	280,000 psi	
<b>Compressive Properties:</b>		4535601224467/ASTM D695
<b>Yield Strength</b>	7,000 psi	
<b>Ultimate Strength</b>	28,000 psi	
<b>Modulus</b>	176,000 psi	
<b>Thermal Conductivity by LFA</b>	< 0.1 W/m.K	453560822409/ASTM E1461
<b>AC Dielectric Strength</b>	22 kV/mm	DCV6101609; ASTM D149 Method A, immersed in ASTM D3487 Type II Oil
<b>Coefficient of Thermal Expansion by TMA:</b>		455300005340/ASTM E831 TMA, 5 °C/min
<b>below Tg</b>	71 ppm/°C	
<b>above Tg</b>	205 ppm/°C	
<b>Biocompatibility Biological Evaluation of Medical Devices</b>	Passes ISO 10993-5	MEM Elution Test
<b>Operating Temperature Range</b>	-40 to 125 °C**	
<b>Relative Thermal Index (RTI)</b>	50 °C	UL746B, Table 7.1 Generic Value Based on Composition

\* Asterisk denotes values considered typical to associated resin systems or extrapolated from other test results.

\*\* Operating Temperature Range is based on average design requirements and is not intended as a guarantee of suitability for all applications operating at that temperature.

\*\*\* This TDS contains values that have been updated. The values reported in this technical data sheet are typical values of the product, and are highly dependent on test conditions and methodology. We actively seek the most precise and accurate ways to measure and interpret performance of our products, and to update estimated values with measured values. The formula has not been revised or changed in any way. Although the values on paper have changed, you can expect the same performance of the product.

### **Additional Performance Data – Lap Shear Adhesion, 4535601224468/ASTM D1002:**

<b>Substrate Type</b>	<b>Strength</b>	<b>Test Temperature</b>	<b>Cure Schedule</b>	<b>Bond Line Thickness</b>
Al to Al	2,100 psi	25 °C	4 hr @ 65 °C	0.010 "
SS to SS	2,500 psi	25 °C	4 hr @ 65 °C	0.010 "
PC to PC	1,800 psi	25 °C	4 hr @ 65 °C	0.010 "
Acrylic to Acrylic	1,300 psi	25 °C	4 hr @ 65 °C	0.010 "
PVC to PVC	1,000 psi	25 °C	4 hr @ 65 °C	0.010 "
ABS to ABS	1,000 psi	25 °C	4 hr @ 65 °C	0.010 "

---

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022  
262-253-5900 FAX 262-253-5919

**INSTRUCTIONS:**

1. Bring to room temperature prior to use.
2. Cartridge format: Mixer should be attached keeping the cartridge vertical and any air pocket purged this way. After the mixer contains material, the mixer tip can be dropped to dispense pre-bleed amount. Attach a new static mixer with each cartridge, then pre-bleed the first 3 inches of dispensed material or until a uniform color is obtained. Maintain adequate velocity during dispensing to ensure complete mixing.
3. Bulk format: stir until homogeneous weigh and mix parts A and B accurately and thoroughly, scraping sides of container often. Do not pour from mixing container, transfer to a new container as residual unmixed material may cause a tacky spot on the surface of the casting. Maintain adequate velocity during dispensing to ensure complete mixing.
4. Allow to cure undisturbed until product is fully gelled or tack-free to the touch.
5. Clean up uncured resin with suitable organic solvent such as MEK or acetone.

**SHELF LIFE AND STORAGE:**

6 months at 25 °C Bulk.

12 months at 25 °C in cartridges that are foil bagged and desiccant packed.

Specialty packaging may be less.

Isocyanates are sensitive to moisture and should be kept in their original container or in a volume tank under dry nitrogen blanketing. Many isocyanates are prone to dimerization, the formation of a white precipitate. Products with minor amounts of this precipitate normally cure to full properties. Storage at 20 - 30 °C (68 °F to 86 °F) is recommended to ensure full shelf life.