



FH3503

FH3503 is a two-component, liquid, castable, polyurethane elastomer that contains no MDA, TDI, or MOCA. The material has a low mixed viscosity and cures to a brown, semi-transparent, high modulus, high hardness elastomer at room temperature.

Technology / Base	Polyurethane
Type of Product	Casting and Encapsulation Compound
Components	Two Component
Curing	Room Temperature (secondary thermal cure)
Appearance / Color	Light Amber Semi-transparent
Consistency	Liquid

Features and Benefits

- No MDA
- High Abrasion Resistance
- Insensitive to Typical Environmental Moisture
- Longer Pot Life
- Low Viscosity
- Excellent bond strength to a wide variety of substrates
- No TDI or MOCA

Technical Data

Rheology	Value	Condition/Method
Viscosity - Part A	5,500 cPs	at 25°C
Viscosity - Part B	190 cPs	at 25°C
Viscosity - Mixed	4,300 cPs	at 25°C
Density		
Specific Gravity	1.06	
Uncured Material Characteristics		
Volume Mix Ratio	100 to 28.3	
Weight Mix Ratio	100 to 28	
Pot Life		
Gel Time	30 to 40 min	at 23°C 0
Handling Time	16 to 24 hours	
Full Cure @ 23°C	5 to 7 days	
Full Cure @ 70°C	4 to 5 hours	
Shelf Life	12 months unopened	
Cured Mechanical Properties		
Hardness	90 Shore A	ASTM D2240
Tensile Strength	28.3 MPa (4,100 psi)	ASTM D638, 25°C 50% RH
Elongation at Break	500%	ASTM D638, 25°C 50% RH
Overlap Shear Strength		
Aluminum, abraded		



General Instructions

Surfaces to be bonded must be clean, dry and free from grease, oil, wax, weak oxide films and other contaminants. Bring both components to room temperature prior to mixing. Measure out specified amounts of parts A and B and mix, without introducing bubbles, until homogenous. Meter-mix equipment equipped with an automatic purge is recommended for higher volume applications. Contact your H.B. Fuller representative for suggested application equipment to suit your specific needs. We recommend that containers be purged with nitrogen after they are opened to the air and not all the material is used.

Specifications and Approvals

Storage

Product should be stored in a cool dry place out of direct sunlight. The shelf life is from date of manufacture. Shelf life is based on the products being stored properly at temperatures between 18°C and 26°C. Exposure to temperatures above 26°C will reduce the shelf life. This product should not be frozen. Purge opened containers with dry nitrogen inert blanketing gas before resealing.

Handling and Clean-Up

See SDS for handling and clean-up information.

Safety and Disposal

See SDS for safety and disposal information.

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