

EL629DM

A high performance, medium curing polyurethane resin system

Application

- Rubber repair
- Connectors and cable joints

Key Properties

- Enhanced elongation and toughness
- High adhesion
- Excellent abrasion resistance

Description

- Basic Two-component polyurethane system
- Resin RL629DM
- Hardener HL629DM

Physical Data (approx. – values)	Resin	Hardener	Mixed
Colour	Black	Light Amber	Black
Specific Gravity	1.1	1.1	1.1
Viscosity (mPas) @ 25°C	800	1500	1300

Cure Schedule (150ml)	Working Life	Gel Time	Light Handling	Full Cure
Temperature	(minutes)	(minutes)	(minutes)	(hours)
RT	10	20	90	24
40°C	3	5	30	8
60°C	-	1	20	4

*RT is defined as 20-25°C

The above are typical values and will vary depending on the cured mass and application. Hotter temperatures may be used for faster cure but will result in higher post cure shrinkage and higher cure exotherm. Experimentation and testing is suggested to avoid side effects. EL629DM may cure with a tacky surface if cured at low temperatures and/or small volumes – Contact our technical service department for advice.

Processing

Mix ratio by weight 0.88:1

Mix ratio by volume 1:1

Approvals

RoHS compliant	Yes
UL94 V-0	No
REACH (SVHC concentration)	Refer to SDS

Typical Properties	Result	Unit
Shrinkage (volume)	0.5	%
Thermal Conductivity	0.2	W/mK
Operating Temperature	-55 to +125	°C (application & geometry dependant)
Hardness	70	Shore A
Heat deflection	Flexible	
Elongation at Break	1000	%
Tensile Strength	12	MPa
Tack Free (10g @ RT)	240	minutes
Tear resistance	30	MPa

Packaging & Part Numbers

EL629DM is available in Bulk, Twinpacks & Cartridges

Availability

Available through distribution and sales@robnor.co.uk

Cartridge Mixing Part Numbers

EL629DM/BK/050TC	
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It is essential for best results that the cartridge is 'balanced' before use to ensure correct mixing. Loading the cartridge into the gun before attaching the mixer element and pumping the gun to push a small amount of the contents forward will achieve this. Wipe the excess from the cartridge tip and add the static mixer. The cartridge is now ready for use.

Cartridges that are foil wrapped and desiccant packed should be stored horizontally

Twinpacks Part Numbers

EL629DM/BK/250	
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Twinpacks are pre-weighed resin and hardener components contained in a tough flexible film, separated by a removable clip and rail. Once the clip and rail is removed the resin and hardener is thoroughly mixed within the bag and is immediately ready for use. Mixing will normally take ~ 2 minutes due to the viscosity; but pay special attention to the corners. Twinpacks are ideal for small to medium production runs, prototyping and on-site or field use. The twinpack weight/volume may also be tailored to a specific size on request.

For further details please visit www.robnor-resinlab.com

Bulk Materials Part Numbers

Available on request	
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Both resin and hardener are supplied in 5kg, 25kg and 200ltr drums and fully evacuated and ready for use. Care should be taken to ensure when mixing the resins air is not entrained in the mixture. If this is unavoidable the mixed resin and hardener should be re-evacuated before dispensing. The bulk resin and hardener materials can be dispensed from suitable dispensing machinery, details provided by Fluid Research on request.

Kits and Sets Part Numbers

EL629DM/BK/10KGKIT	
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Kits and Sets are provided in separate containers to the correct ratio.

In Kit form, pour the smaller container into the larger container and use it as a mixing vessel.

Stir well using an appropriate mixer until homogeneous.

Note: Incomplete mixing will be characterised by erratic or partially incomplete cure even after extended time periods.

Cleaning

All equipment contaminated with mixed material should be cleaned before the material has hardened. TS130 is a suitable non-flammable cleaning agent, although other solvents may be found suitable. TS130 will also remove cured material provided it can soak for several hours.

Storage and Shelf Life

6 months at 25 °C 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 +/- 5 °C (60 °F to 86 °F) is recommended to ensure full shelf life.

Health and Safety

Please refer to RL/HL629DM Health and Safety data or our Technical Service Department for individual/specific advice.

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The results and information above does not constitute a specification and is given in good faith and without warranty. The information is derived from test/or extrapolations believed to be reliable and is quoted for guidance only. The product is offered for evaluation on the understanding the customer satisfies himself that the product is suitable for the intended application by proper evaluation and testing.

Contact Details

Robnor Resinlab Limited
31 Athena Avenue
Elgin Industrial Estate
Swindon
SN2 8EJ
United Kingdom

Tel: +44 (0) 1793 823741
Fax: +44 (0) 1793 827033
Email: support@robnor.co.uk
Web: www.robnor-resinlab.com
Buy Online: www.resins-online.com (UK only)