

Fusor[®] 2200/2201 Sealer/Adhesive

Description

LORD Fusor[®] 2200/2201 sealer/adhesive is a black, two-component urethane adhesive system used to bond fiberglass reinforced plastics (FRP), sheet molded compounds (SMC) and other plastics with little surface preparation where bond strengths greater than the substrate are desired. This adhesive system also bonds primed metals and various combinations of dissimilar substrates.

Features and Benefits

Durable – demonstrates high strength and excellent durability for structural and sealing applications.

Environmentally Resistant – provides excellent resistance to sunlight, weathering, humidity and salt spray.

Chemically Resistant – solvent resistant when cured. Painting and most cleaning processes do not affect bond strength.

Non-Sag – remains in position when applied on vertical surfaces or overhead surfaces, allowing for greater process flexibility.

Application

Surface Preparation – Remove soil, grease, oil, fingerprints, dust, mold release agents, rust and other contaminants from the surfaces to be bonded by solvent wiping or dry rag wipe.

Mixing – Mix Fusor 2200 resin with Fusor 2201 curative at a ratio of 1:1, by volume. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Automatic meter/mix/dispense equipment should be set accordingly and static mixing tips should contain minimum of 24 mixing elements.

Applying – Apply adhesive directly to bond surfaces using handheld cartridges or automatic meter/mix/dispense equipment. Place assembly in desired position within the working time of the adhesive. Clamp in position until adhesive reaches handling strength.

Curing – Fusor 2200/2201 sealer/adhesive will cure to full strength within 24 hours at room temperature [77°F (25°C)]. Cure rate can be accelerated by applying modest temperatures up to 250°F (121°C).

Cleanup – Clean excess adhesive off the bonded assembly, as well as equipment, prior to the adhesive cure with organic solvents such as isopropyl alcohol.

Typical Properties*

| | 2200 Resin | 2201 Curative |
|---|---------------------------------------|--|
| Appearance | Brown Paste | Black Paste |
| Viscosity, cP @ 77°F (25°C) Brookfield HAT | 15,000-105,000 Spindle T-D, 10 rpm | 225,000-640,000 Spindle T-F, 10 rpm |
| Density | | |
| lb/gal | 12.5-12.8 | 10.8-11.2 |
| (kg/m ³) | (1497.8-1533.8) | (1294.1-1342.1) |
| Solids Content by Weight, % | 99.5 | 100 |
| Flash Point (Closed Cup), °F (°C) | >200 (>93) | >200 (>93) |

*Data is typical and not to be used for specification purposes.

LORD TECHNICAL DATA

Once adhesive has cured, heat the adhesive to 300°F (149°C) or above to soften the adhesive. This allows the parts to be separated and the adhesive to be more easily removed. Some success may be achieved with commercial adhesive strippers.

Shelf Life/Storage

Shelf life is six months from date of shipment when stored in a clean, dry environment at 65-85°F (18-29°C) in original, unopened container.

After opening, protect material from excessive exposure to moisture by installing desiccant cartridges and/or using dry nitrogen as an inert cover.

Cautionary Information

Before using this or any LORD product, refer to the Material Safety Data Sheet (MSDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

Typical Mixed Properties*

| | |
|--|-------------|
| Mix Ratio, Resin to Curative | |
| by Weight | 1: 0.87 |
| by Volume | 1:1 |
| Working Time, min @ 75°F (24°C) | 3-5 |
| Purge Time, min @ 75°F (24°C) | 3 |
| Time to Handling Strength, min @ 75°F (24°C) | 30 |
| Mixed Appearance | Black Paste |

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Values stated in this technical data sheet represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

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