



Sheldahl Abrasive Belt Adhesives

PRODUCT DESCRIPTION

Sheldahl Polyurethane Adhesive is designed to be used in conjunction with an isocyanate curing agent as a two-component system. These systems produce a tough, flexible, temperature and chemical resistant bond.

APPLICATIONS

Sheldahl Adhesives are specifically designed for splicing abrasive belts and may be used as a general adhesive for plastics, rubber, fabrics, leather, wood and paper.

GENERAL PROPERTIES

Composition	Linear polyesterurethane
Form	Light syrup
Color	Pearl gray/straw
Recommended Isocyanate Curative	Desmodur® RE or RFE
Pot Life	4-6 Hours after Curative addition, depending on ambient conditions

® Desmodur is a Product of Bayer AG

TYPICAL FORMULA PROPERTIES

	A651-20	A651-15	A455-20	A455-15	A667-20	A667-15 & A667-15 RED
Solvent	Ethyl Acetate / Acetone	Ethyl Acetate / Acetone	MEK	MEK	Ethyl Acetate/ Acetone	Ethyl Acetate/ Acetone
Solids %	20	15	20	15	20	15
Viscosity, cps @ 22°C	2200-4800	600-1300	1800-3800	350-600	1500-3500	300-500
Weight per gallon, pounds (Kg)	7.65 (3.48)	7.55 (3.43)	7.28 (3.31)	7.05 (3.20)	7.60 (3.45)	7.45 (3.39)
Desmodur® RE, RFE (curative) Addition						
to: 1 Volume of Curative	12 volumes	16 Volumes	12 volumes	16 Volumes	12 volumes	16 Volumes
to: 1 Grams of Curative	11 grams	14.6 grams	11 grams	14.6 grams	11 grams	14.6 grams

TRANSPORTATION DATA

Phone: 507-663-8145
Phone: 507-663-8531

1150 Sheldahl Road
Northfield, MN 55057

Fax: 507-663-8300
www.sheldahl.com
PB205 (B)



Domestic Hazard Class Flammable Liquid

UN/NA UN1133

International Hazard Class 3.2

UN/NA UN1133

STORAGE AND USE

Sheldahl Adhesives are flammable liquids. Use only in well-ventilated areas. Extinguish all flames, including pilot lights. Avoid any spark producing equipment. Make a special effort to keep adhesives contained while processing. Store adhesives tightly sealed in cool, dry, well-ventilated area.

Properly stored adhesive may be used for up to 6 months before retesting. Gelling and separation is a common behavior of this high performance resin, especially when exposed to the cold during transport and storage.

*****All Sheldahl Adhesives must be well mixed before each use.**

APPLICATION

Sheldahl Adhesives are used in abrasive belt manufacturing in three ways:

1. Applying adhesive to the belt ends, forming an overlap and bonding using heat and pressure.
2. Applying adhesive to the belt ends and to Uncoated Splicing Tape (see product bulletin PB 210) then adhering the butted ends of the belt with the tape and bonding using heat and pressure.
3. Applying adhesive to the belt ends, then adhering the butted ends using Coated Splicing Tape (see product bulletin PB 211) and bonding using heat and pressure.

Sheldahl Adhesive may be applied using a brush, roller, knife, or by spraying. A045500 is particularly well suited for spraying because it maintains a low viscosity at higher solids. A065100 is recommended for roller and tape coating. A066700 is lower viscosity adhesive without the aroma of MEK.

Sheldahl is a world leader in a wide variety of adhesive-based products used in applications ranging from aerospace to automotive. Sheldahl brings unique capabilities as the leading supplier of abrasive belt joining materials. Our engineers use state-of-the art laboratory and manufacturing equipment to assure that Sheldahl products meet the most rigorous test and performance requirements.

Sheldahl's technical and customer support staff are committed to provide the best total value through quality, delivery and service.

NOTICE

All statements and technical data regarding this product are believed to be true and accurate. Recommendations are made without guarantee since conditions of use are beyond our control. Sheldahl disclaims any liability incurred in connection with the use of this product or information contained herein. The information contained shall not be construed as a recommendation to use any product in conflict with existing patents covering any material or its use.

It is Sheldahl's commitment and responsibility to produce high quality material that conforms to specification. Please consult instructions on this bulletin and on supplied Material Safety Data Sheet before use.

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