

10:1 Polyurethane adhesive sealant for transportation market



SPECIFICATIONS

MATERIAL SUPPLIER

3M

INDUSTRY

Transportation

APPLICATION

Machine applied urethane assembly adhesive and sealant dispensing 1/8 in to 1/2 in (3.175 to 12.7 mm) diameter beads to panels and structures

MATERIAL SPECS

3M™ 550 Polyurethane Adhesive Sealant (A) can be mixed with 3M™ B550 Adhesive (B)

Sealant Booster (B) for faster curing. Mixing is typically done in line with special two component dispensing equipment.

Typical Properties

- Ratio (A:B) by volume: 1:10
- Viscosity
- 650,000 cps using spindle 7 at 50 rpm
- 50,000 cps for booster
- Chemistry: Polyurethane
- Colors: White

GRACO EQUIPMENT

Graco HFR™ Metering System

CONFIGURATION*

- Part number: HFR-21AAKANN
- Fixed ratio
- Stainless steel
- 230/1 power requirement
- Blue Side (B) Pump: 100 cc
- Red Side (A) Pump: 10 cc
- Heat zones: Ambient
- Hoses:
 - 1 in x 10 ft (25 mm x 3 m) hose to HFR inlet on 550 and B550
 - 3/4 in x 10 ft (19 mm x 3m) necked down to 1/2 in x 5 ft (12 mm x 1.5 m) to MD2 for 550 Adhesive
 - 1/4 in x 15 ft (6 mm x 4.6 m) to MD2 gun for B550

Accessories:

- .024-in orifice inlet on the booster
- D200 ram assembly for the base material drum (Part Number: CM2F58)
- S20 ram assembly for the booster 5 gallon pail (Part Number: CM6C3F)
- 1/2 in (13 mm) x 24 element mixer

Delivery Method

- MD2 hand held gun stainless steel (Part Number: 24D525)
- Electric switch cable



Graco achieved 600 cc per minute flow rate with 1/2 in (13 mm) x 24-element mixer.

* Exact equipment configuration will vary and depend on factors such as rate of output, length and size of hoses, bead size desired, and container sizes.
Graco Material Test: DR286

For more information, contact us at 1-877-844-7226 or info@graco.com. Visit us at www.graco.com

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