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ISO 9001:2000

TECHNICAL INFORMATION

KALEX® 17621A/16805B
Urethane Adhesive System

PRODUCT DESCRIPTION

KALEX 17621A/16805B is a semi-rigid, two–component, fast-setting polyurethane adhesive. It features an excellent combination of shear strength and peel strength, with good impact and fatigue resistance.

KALEX 17621A/16805B has a convenient 1:2 by volume mix ratio and it is designed to tolerate the conditions in an automotive filter environment.

MIXING AND CURING SCHEDULE

KALEX 17621A/16805B adhesive is designed to be mixed and dispersed by machine. It is a fast system. Dispense it immediately after mixing to prevent curing in the mixing chamber. Polyurethane adhesives require accurate measurement of the two components and adequate mixing. Machine mixing uses the volumetric ratio. Most machines are calibrated by weighing the components and adjusting the volume ratio. The mix ratios are shown below.

Ratio	Part A	Part B
By weight	40.5	100
By volume	50	100

KALEX 17621A/16805B features a working time of about two minutes at room temperature. It achieves its final cured properties after two to three days at room temperature.

2 – 3 days at 25 °C (77 °F).

TYPICAL UNCURED PROPERTIES

	Part A	Part B	Mixed
Color	Amber	Black	Black
Viscosity @ 25 °C, cps.	1,400	5,000	Thixotropic Paste
Weight per Gallon, lbs.	9.56	11.70	11.05
Specific Gravity @ 25 °C	1.15	1.41	1.32
Gel time, minutes,			
4 gm. mass @ 25 °C	– – –	– – –	4 min.
1.5 gm. mass @ 25 °C			6 min.
Filler Type	None	Non-Abrasive	Non-Abrasive
Shelf Life (in separate sealed containers), months	6	6	– – –

TYPICAL CURED PROPERTIES
(Tested at 25 °C unless otherwise indicated)

Test	Result
Hardness, Shore D	50

STORAGE AND HANDLING

These materials should be stored in a dry environment within a moderate temperature range. Extended exposure to temperatures above 35°C begins to degrade the Part A. Avoid exposing either component to moisture.

Moisture reacts with the A-side to create minor levels of by products. Low levels will not degrade the final polyurethane. Moisture contamination of the B-side will cause some gas bubbles in the mixed adhesive. Purge the container with dry air before closing to maintain the storage life.

When using meter-mixed dispense equipment (MMD) machines, reservoir should be blanketed with nitrogen or dry air to avoid moisture and other contamination.

Avoid contamination with oxidized metals (such as copper, brass, or mild steel), and rust or other metal oxides. The stability of the product is greatly reduced by materials such as strong acids or bases, sulfur compounds, amines, or reducing agents of any type.

SAFETY

These materials are intended for industrial use only, and the practices of good housekeeping, safety and cleanliness should be followed before, during and after use.

Although the system contains low volatility materials, nevertheless, care should be taken in handling. Adequate ventilation of work place and ovens is essential.

These materials may cause dermatitis in susceptible individuals. Keep off skin and out of eyes. In case of accidental skin contact, wash thoroughly with soap and water. In case of eye contact, flush eyes thoroughly with water and consult a physician immediately.

Refer to Material Safety Data Sheet for additional information.

ADDITIONAL INFORMATION

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NOTE

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