



Technical Data Sheet

POLYMARK A388

TWO COMPONENT POLYURETHANE ADHESIVE SYSTEM

Product Description:

Polymark A388 is a two component, room temperature curing polyurethane adhesive system. It is designed for general bonding applications. Polymark A388 provides excellent environmental protection while having good adhesion to various metals, plastics and other common assembly materials.

It is non-abrasive to dispensing equipment and well suited to automated operations. A388 is a DOT non-hazardous material and contains no TDI, MOCA, or other reportable substances.

Typical Product Handling Properties:

| <u>CHARACTERISTIC</u> | <u>VALUE</u> |
|--------------------------|--------------|
| Part A: | |
| Color | Black |
| Specific Gravity (g/cc) | 0.99 |
| Viscosity (10 rpm) 25°C | 900 cps. |
| Part B: | |
| Color | Amber |
| Specific Gravity (g/cc) | 1.22 |
| Viscosity, 25°C | 100 cps. |
| Mixed: | |
| Mix Ratio (Part A to B): | |
| by weight | 100 to 61 |
| by volume | 2 to 1 |
| Gel Time, 25°C | 8-10 min. |
| Time to Full Cure, 25°C | 2-3 days |

Typical Cured Physical Properties

| <u>CHARATERISTIC</u> | <u>VALUE</u> |
|----------------------------|--------------------|
| Cured Density (g/cc) | 1.07 |
| Cured Hardness (Shore D) | 40-50 |
| Color Cured | Black |
| Water Absorption | |
| 24 hrs @25°C | 0.20% |
| Dielectric Constant | 4.0 |
| Dissipation Factor (1 MHz) | 0.032 |
| Volume Resistivity | |
| (ohm-cm) (1 MHz) | 3×10^{15} |

The cured physical properties were developed using a cure schedule of 5 days at 25°C. The choice of the user's cure schedule will depend on the application and the user must determine suitability. The cure may be accelerated by heat.

Polymark A388 can be proportioned by weight or volume. These ratios are stoichiometrically calculated and should be closely followed. Automated meter-mix dispensing equipment may be used for high volume production. (A list of dispensing equipment manufacturers is available from Polymark.)

A388 part B is moisture sensitive and must be kept away from atmospheric moisture during storage. After opening a sealed container, thoroughly purge the remaining air space with dry nitrogen (or equivalent inert gas) before closing the container.

Handling Safeguards

Closely follow instructions on the labels of Polymark materials containing information on the hazards associated with each particular product. Most polyurethane resin systems are skin and eye irritants and can cause respiratory sensitization. Other problems, such as skin sensitization and more serious health hazards may exist. Consult the Material Safety Data Sheet for further information.

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Important Notice to Users: Typical properties are shown in this technical bulletin and should not be used or taken as specifications. Contact Polymark prior to establishing specifications. The information given for product description, handling properties and cured physical properties are offered solely to assist the purchaser's own testing. Polymark, its sales agents and distributors make NO WARRANTY OF MERCHANTABILITY OF THE PRODUCT OR THE FITNESS OF THE PRODUCT FOR ANY PARTICULAR PURPOSE. This product and all information supplied in connection with it is used at the purchaser's own risk, conditions of use being beyond Polymark's knowledge or control. The purchaser assumes all risk of use or handling of the product, whether in accordance with directions or not.