

Product Description

Vibra-Tite 802 is a 2-component lamination adhesive system based on polyurethane. Vibra-Tite 803 HARDENER is a polyol blend which can be colored with pigment, and Vibra-Tite 802 RESIN is a formulated isocyanate with exceptional bonding and sealing properties to provide exceptional adhesion to a wide variety of engineering plastics, metals or other substrates. This system can be used with plural component extrusion equipment, or standard 1:1 meter mix (volumetric) dispensing machines that use static mixers. Its mixed viscosity of ~3500 cps at 75°F allows Vibra-Tite 802 to be spray applied using heavy particle size atomization process.

Substrate Compatibility

VT-802 is designed to provide exceptional bond performance to polycarbonate, acrylic, or ABS plastic, PVC films and various coatings including polyester types. The cured polymer is capable of withstanding most environmental variables including high chemical resistance, heat and cold, and high humidity.

Typical Performance

Density @ 25°C	HARDENER = 1.54 (12.84 #/gal) RESIN = 1.13 (9.38 #/gal)
Mix Ratio	VOL = 1 : 1 WT = 58 : 42 (100 : 72)
Viscosity @ 25°C	HARDENER = 9,500 cps RESIN = 2,000 cps MIXED= 3,500 – 4,000 cps
Physical Form @ 60°F	Viscous Liquid
Typical Application Temperature	60°F to 90°F
Shore Hardness	Shore D 45 - 55
Pot Life (100 g. mass)	3 minutes to 2.5 hours 25°C
Cure Schedule	12 – 24 hours @ 25°C; 4 hours @ 80°C

Strength Performance

Using ASTM D-1002, 0.5” overlap bond specimens were prepared using Aluminum Grade 2014 T3, and assembled with a gap of (1) 5 mils, and at (2) 0 mils. The results were as follows: 1) 420 psi average at RT; (2) 575 psi at RT.

Typical Applications

- Interior & Exterior wall panels
- Architectural and composite panels
- Insulated cooler and cold storage building walls
- RV Motorized & Travel Trailer walls, roofs, & floors
- Manufactured & Modular Housing construction
- Residential & Commercial entry doors
- Lamination of Structural Plastics and metals
- House boat composite wall lamination
- ABS & Vinyl film laminating

Handling and Mixing

Prior to mixing Vibra-Tite 802 (resin) and 803 (hardener), it is recommended to agitate the Vibra-Tite 803 (hardener) to re-disperse any solids which may have settled over time or during shipment. When mixing, the ideal manual method is to mix by weight using a scale to prevent off-ratio mixing. The mixing container should be placed on the scale and set to zero. The proper amount of HARDENER should be weighed, followed by the proper amount of RESIN. The material should then be stirred, ideally with a metal mixer to ensure that the 2 components are thoroughly blended. Failure to properly blend the 2 components could result in lack of curing between the substrates. When mixing larger volumes of Vibra-Tite 802, the pot life will be shorter due to the concentration of exothermic heat developing from the reaction. Shelf life is 3 months from date of manufacture for the HARDENER and 6 months for the RESIN.

Caution

Read MSDS prior to using VT-803 & VT-802. Basic safety precautions should be considered before installing product, such as use of appropriate glove, clothing and protective eyewear. Keep out of reach of children.



Packaging

Standard packaging includes 5 gal. pails, 55 gal. drums, and Intermediate Bulk Containers (275-330 gallon totes).