



ReacTITE[®] R2032

ReacTITE R2032 is a 2-component, solvent-free polyurethane assembly adhesive with excellent durability. This self-leveling, room temperature curing product bonds well to metals, PVC, vinyl, fiberglass, and cellulosic materials. ReacTITE R2032 is formulated for hydraulic fluid and lubrication oil filter fabrication, and is particularly effective in bonding filter end caps and side seams.



PHYSICAL PROPERTIES

ReacTITE R2032

Viscosity @ 77° F (cps): 16,000 - 30,000

Color: Off-white liquid

Weight per Gallon (lbs): 14.2

Recommended Mix Ratio: 4 parts by volume

Pot Life @ 77° F: 3 - 9 minutes

Mixed Weight per gallon: 13.4 lbs

Freeze/Thaw Stable: Yes

Hardener 200

Viscosity @ 77° F (cps): 170 - 230

Color: Brown Liquid

Weight per Gallon (lbs): 10.3

Recommended Mix Ratio: 1 part by volume

KEY PRODUCT FEATURES

- Performs well in end cap potting or casting and edge/frame sealing
- Good heat resistance with temperatures below 180 degrees Fahrenheit
- Strong chemical resistance
- Room temperature cure in three to nine minutes; that can be heat accelerated
- Forms superior bonds to a wide variety of materials such as: metals, PVC, vinyl, fiberglass and cellulosic materials
- Recommended for air, water and oil filters
- Qualifies for FDA regulation, CFR 175.105, for indirect food contact.

PERFORMANCE PROPERTIES

Bond strength: ReacTITE R2032 bonds well to wood, metal, concrete, finishes, and many plastics. Strength testing on the substrates to be used should be conducted.

Shore D hardness: 80 - 82 (when fully cured)

Chemical resistance: ReacTITE R2032 is used in air, water, and oil filters. Long term exposure to solvents and synthetic oils are not recommended.

Heat resistance: ReacTITE R2032 is suitable for continuous use in temperatures up to 180 degrees Fahrenheit. Exposure to temperatures up to 250 degrees Fahrenheit for extended periods is possible as well.

Indirect food contact: ReacTITE R2032 cured with Hardener complies with CFR 175.105 regulations for indirect food contact. Please note, ReacTITE R2032 has not been submitted for approval by the NSF for use in water filters.

MIXING INSTRUCTIONS

ReacTITE R2032 is mixed with Hardener 200 at a ratio of 4 parts ReacTITE to 1 part Hardener by Volume. This ratio is approximately 5.2 parts ReacTITE to 1 part Hardener by Weight. Off-ratio mixes will result in slower setting rates and weaker ultimate bonds.

APPLICATION GUIDELINES

ReactTITE R2032 is available in bulk quantities and is generally applied with meter mix equipment.

Meter mix equipment: Meter-mix equipment permits accurate mixing and dispensing of two-part polyurethanes. This permits the purchase of ReactTITE R2032 and FilterFAB Hardener in bulk containers at a significant reduction in the price of adhesive. It is typically possible to payback the equipment cost of the meter mix system in less than 200 gallons of mixed material. We recommend a purge cycle timer to prolong the life of the disposable mix tip. In addition, the mix ratio should be checked periodically.

Typical working life: ReactTITE R2032 will generally remain usable for about three to five minutes after being mixed. ReactTITE will cure more rapidly in a large volume than in a thin film.

Heat acceleration: ReactTITE R2032 will cure faster with the application of heat. Temperatures of 150 degrees Fahrenheit or less are normally sufficient.

Ultimate cure: ReactTITE R2032 normally reaches handling strength in less than an hour. It will continue to become harder for the next 24 hours. A full cure is attained in about seven days.

Cleanup: ReactTITE R2032 may be cleaned up with many common solvents including acetone, lacquer thinner or mineral spirits. Cured ReactTITE R2032 can be removed mechanically.

HANDLING AND STORAGE

Shelf life: Mix before use for best results. Best if used within twelve months of date of manufacture.

Safety and disposal: Hardener 200 is a polymeric isocyanate. Use of gloves and other protective equipment is recommended. Consult SDS before use for additional information.

Storage of opened containers: ReactTITE R2032 should be kept in a closed container. It will absorb moisture from the air. Enough moisture will cause the mixed but uncured adhesive to foam. FilterFAB Hardener is very susceptible to moisture. We recommend that it be kept in a sealed container. A desiccant or nitrogen blanket is recommended.