

IsoBond HBN 5200

IsoBond™ HBN 5200 is a quick-setting two-component adhesive. It is highly suited for bonding wood to itself or to other porous substrates, such as fabric or cardboard and can provide adequate wood to plastic adhesion in many cases. Flexible substrates adhered to wood by IsoBond™ HBN 5200 will tend to break before the adhesive. It also contains 35 to 45 % naturally renewable material, giving it a “greener” profile than many adhesives. IsoBond™ HBN 5200 is packaged in cartridges and applied through a static mixer. The excellent initial bond of IsoBond™ HBN 5200 dramatically reduces downtime for a more efficient and productive manufacturing process.

APPLICATIONS

- Floor and wall systems
- Plywood
- Subfloor Adhesive
- Wood & Furniture
- Wood, Foam,Plastics, Other natural products

PRODUCT ADVANTAGES

- Excellent initial and final bond
- High strength bonds
- Solvent-free to meet stringent environmental regulations

*Values given are not intended to be used in specific preparation

Component Properties

Color - ISO	Amber
Color - POL	Amber
Specific Gravity - 74°F, ISO	1.16 - 1.18
Specific Gravity - 74°F, POL	.96 - 1
Viscosity - ASTM D-2196 - 74°F, ISO	3000 - 6000 cps
Viscosity - ASTM D-2196 - 74°F, POL	1400 - 1600 cps
% Solids	100 %

Reactivity Profile

Ratio by Volume - ISO:POL	1:1
Gel Time - 100 gram sample, 74°F	100 - 120 Seconds
Tack Free Time	1030 - 180 Seconds
Full Cure	24 Hours

Typical Physical Properties

Flexural Modulus - ASTM D790	2.5 - 3.3 %
Lap Shear ABS - ASTM D1002	130 psi
Lap Shear Acrylic - ASTM D1002	130 psi
Lap Shear Aluminum - ASTM D1002	200 psi
Lap Shear Maple - ASTM D1002	1380 psi
Hardness - ASTM D2240 - Shore D	58 Shore D
Tensile Strength - ASTM D412	2440 - 2680 psi

RECOMMENDED HANDLING INSTRUCTIONS

Isotec® International's Recommended Application and Handling Instructions

- Use only in well-ventilated areas.
- Wear chemically resistant rubber gloves, safety glasses, and an apron.
- Avoid prolonged or repeated contact with skin.
- In case of skin contact, wipe affected area with isopropyl alcohol, followed by soap and water.
- In case of eye contact, flush eyes with water for 15 minutes and consult a physician.
- If swallowed or comes into contact with eyes, seek medical attention immediately.

Care should be taken to insure the proper ratio of ISO to POL is achieved. Mixing material at a different ratio than 1:1 by volume could compromise the resulting physical properties of the cured elastomer. The two reactive components are designed for dispensation through a static mixer. Surfaces should be clean, dry, and free of oils or coatings that might prevent the adhesive from bonding to the surfaces. Metal surfaces can be cleaned with xylenes, mineral spirits, MEK, but should be dried before adhesive application. An isopropyl alcohol wipe is recommended for cleaning plastics that may have dirt or mold release on their surface. Isotec also has plastic primers available if required. Parts should be clamped

together for 20 minutes before handling and moving.

STORAGE

Protect ISO and POL side from moisture. If the ISO side material is exposed to moisture, including moisture from the air, it will release CO² gas. If placed in a sealed container, this gas can cause a dangerous build up of pressure potentially resulting in injury or death. If the POL side is exposed to excess moisture and then applied it may cause weak or foamed material to be applied.

SAFETY

-Refer to the product SDS for all relevant safety information.

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- THERE ARE NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING ANY WARRANTIES OR MECHANABILITY OR FOR ANY PARTICULAR PURPOSE. While all data presented in Seller's technical data sheet is based on the best information available to Seller and believed correct, such data is not to be construed as a warranty that the product will conform to such specifications. Such technical data sheets are subject to change without notice. Reported laboratory test results of fire redundancy in no way relates to the actual performance under fire conditions. Since all urethane systems are organic, they will burn.
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