



## H.B. Fuller FH3530

FH3530 is a two component, liquid, castable, polyurethane, elastomer that contains no MDA, TDI, or MOCA. The material has a low mixed viscosity and cures to a dark amber, medium hardness elastomer at room temperature. FH3530 has very low shrinkage and excellent weather resistance. Applications include potting of sonobuoy's, electronics potting, and structural adhesive sealant applications.

<b>Technology / Base</b>	Polyurethane
<b>Type of Product</b>	Structural Adhesive
<b>Components</b>	Two Component
<b>Curing</b>	Room Temperature (secondary thermal cure)
<b>Appearance / Color</b>	Amber
<b>Consistency</b>	Liquid

### Features and Benefits

- Fungus resistant - does not support fungus growth
- Low shrinkage
- Fast curing
- Self leveling
- Does not stress stress crack PC or PE
- Non corrosive to metals
- No MDA
- Insensitive to Typical Environmental Moisture
- Low Viscosity
- Excellent salt water resistance

### General Instructions

Surfaces to be bonded must be clean, dry and free from grease, oil, wax, weak oxide films and other contaminants. Bring both components to room temperature prior to mixing. Measure out specified amounts of parts A and B and mix, without introducing bubbles, until homogenous. Meter-mix equipment equipped with an automatic purge is recommended for higher volume applications. Contact your H.B. Fuller representative for suggested application equipment to suit your specific needs. We recommend that containers be purged with nitrogen after they are opened to the air and not all the material is used.

### Handling and Clean-Up

See SDS for handling and clean-up information.

### Specifications and Approvals

#### Storage

Product should be stored in a cool dry place out of direct sunlight. The shelf life is from date of manufacture. Shelf life is based on the products being stored properly at temperatures between 18°C and 26°C. Exposure to temperatures above 26°C will reduce the shelf life. This product should not be frozen. Purge opened containers with dry nitrogen inert blanketing gas before resealing.

### Safety and Disposal

See SDS for safety and disposal information.



Technical Data

Rheology	Value	Condition/Method
Viscosity - Part A	5,500 cPs	at 25°C
Viscosity - Part B	50 cPs	at 25°C
Viscosity - Mixed	3,500 cPs	at 25°C
Density		
Specific Gravity	1.03	
Uncured Material Characteristics		
Volume Mix Ratio	100 to 44	at 23°C at 23°C
Weight Mix Ratio	100 to 40	
Pot Life	15 min	
Gel Time	21 min	
Handling Time	4 to 6 hours	
Full Cure @ 23°C	3 to 5 days	
Full Cure @ 70°C	2 hours	
Shelf Life	12 months unopened	
Cured Mechanical Properties		
Hardness	80 Shore A	ASTM D2240
Tensile Strength	14.0 MPa (2,030 psi)	ASTM D638, 25°C 50% RH
Elongation at Break	560%	ASTM D638, 25°C 50% RH
Overlap Shear Strength		
Aluminum, Acid Etched		

Note

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Date Modified: 11 October 2018

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