Specialty Polymers

FilterFAB 2020 DEV

FilterFAB 2020 DEV is a two-component, fast-setting polyurethane assembly adhesive with excellent durability. This self-leveling, room temperature curing product bonds well to metals, PVC, vinyl, fiberglass and cellulosic materials. FilterFAB 2020 DEV is formulated for hydraulic fluid and lubrication oil filter fabrication, and is particularly effective in bonding filter end caps and side seams.

PHYSICAL PROPERTIES

FilterFAB 2020 DEV
Viscosity @ 77° F (cps): 11,000 - 41,000
Color: Off-white liquid
Weight per Gallon (lbs): 14.2
Recommended Mix Ratio: 4 parts by volume
Pot Life @ 77° F: 1 - 5 minutes
Mixed Weight per gallon: 13.4 lbs
Freeze/Thaw Stable: Yes

FilterFAB Hardener
Viscosity @ 77° F (cps): 150 - 250
Color: Brown Liquid
Weight per Gallon (lbs): 10.3
Recommended Mix Ratio: 1 part by volume

*The physical properties listed are target ranges and not final product specifications.

KEY PRODUCT FEATURES

- Fastest setting product in the FilterFAB 2000 series
- 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 five minutes; 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.

MIXING INSTRUCTIONS

FilterFAB 2020 DEV is mixed with FilterFAB Hardener at a ratio of four-parts 2020 to one-part Hardener by volume. Off-ratio mixes will result in slower setting rates and weaker ultimate bonds.

APPLICATION GUIDELINES

FilterFAB 2020 DEV 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 FilterFAB 2020 DEV 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: FilterFAB 2020 DEV will generally remain usable for about two to three minutes after being mixed. FilterFAB will cure more rapidly in a large volume than in a thin film.

Heat acceleration: FilterFAB 2020 DEV will cure faster with the application of heat. Temperatures of 150 degrees Fahrenheit or less are normally sufficient.

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Ultimate cure: FilterFAB 2020 DEV normally reaches handling strength in less than fifteen minutes. It will continue to become harder for the next 24 hours. A full cure is attained in about seven days.

Cleanup: FilterFAB 2020 DEV may be cleaned up with many common solvents including acetone, lacquer thinner or mineral spirits. Cured FilterFAB 2020 DEV can be removed mechanically.

PERFORMANCE PROPERTIES

Bond strength: FilterFAB 2020 DEV 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: FilterFAB 2020 DEV is used in air, water, and oil filters. Long term exposure to solvents and synthetic oils are not recommended.

Heat resistance: FilterFAB 2020 DEV is suitable for continuous use in temperatures up to 180 degrees Fahrenheit. Exposure to temperatures up to 220 degrees Fahrenheit for extended periods is possible as well.

Indirect food contact: FilterFAB 2020 DEV cured with Hardener complies with CFR 175.105 regulations for indirect food contact. Please note, FilterFAB 2020 DEV has not been submitted for approval by the NSF for use in water filters.

HANDLING AND STORAGE

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

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

Storage of opened containers: FilterFAB 2020 DEV 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.

For additional questions, Franklin's technical service team is available at 1.800.877.4583. **24/7** technical service is available online at www.franklinadhesivesandpolymers.com.

IMPORTANT NOTICE TO CUSTOMER: