

PD-2128D**Product Description**

PD-2128D is a fast-tack, high solids, acrylic, water-based pressure sensitive (PSA) adhesive developed for rapid assembly of fiberglass insulation, nonwovens, and light-weight materials. PD-2128D bonds while still wet and resists heat, humidity, moisture and freezing temperatures.

Product Features

- Instant, aggressive, permanent tack for fast assembly
- High solids / High coverage rates
- Spray, roll coat, or brush application
- One component
- Low viscosity
- Meets the safety challenge: no solvent, no caustic, low odor, non-flammable in wet state
- Zero VOC
- UL Certified
- Higher mileage than conventional high viscosity waterbase products
- Easy clean up

Performance Standards / Certifications

- Certified Underwriters Laboratories. Listing MAGW2 (Adhesives, Insulation Component)
HBF File Number MH-7871

Underwriter's Laboratories, Inc. Tunnel Test – ASTM E-84		
Measurement	UL Requirement	PD-2128D Test Results
Flame Spread	<25	1.38
Smoke Development	<50	0.1

Typical Physical Properties

Property	Value
COLOR	WHITE
DENSITY	8.6 lb-mass/gal
PH	3.5 - 4.5
SHELF LIFE	1 year
SOLID CONTENT (NON-VOLATILES)	54 - 58 percent
VISCOSITY	200 - 1,100 cP

Application Methods

- Spray
- Roll Coat
- Brush

This adhesive is designed to be applied by spray, roll coat or brush methods. Contact your H.B. Fuller representative to help you select the right system for your operation. H.B. Fuller has trained technicians who can help set up and train personnel in the operation of most application equipment.

Application Guidelines

Surface Preparation: Surfaces must be free of dust, dirt, oil, grease and moisture to assure proper adhesion.

Application: PD2128D can be applied by spray, roll coat, or brush application.

Coverage: Coverage rates depend on the porosity of the substrates and method of application.

Fiberglass Insulation:

- Spray the adhesive on one side of fiberglass insulation at a coverage of 3 – 6 grams wet/ft²
- Allow up to 30 to 60 seconds depending on temperature and humidity
- Attach to steel or aluminum surface using hand pressure only

Mineral Wool to itself:

- Spray the adhesive to both surfaces
- Allow up to 30 to 60 seconds depending on temperature and humidity
- Combine with hand pressure
- Mineral Wool failure should occur once the water has completely dissipated (depends on temperature and humidity)

Fiberglass Facing Material to Mineral Wool and Fiberglass insulation:

- Spray or roll coat the adhesive onto the facing material
- Within 30 – 60 seconds combine facing to mineral wool or fiberglass insulation using light pressure.

Spray / Pump Equipment Recommendations

- Graco, Binks, and DeVilbiss HVLP hand guns
- Pressure Feed Systems are recommended for best control to achieve desired delivery rate and spray pattern. The adhesive can be dispensed into the spray guns in several ways: Pressure Pot: Stainless Steel; or plastic liner; intake tube must be stainless steel
- Pumping Equipment: Double Action diaphragm pump, Graco Husky 1040.
- Gravity Feed: Feed from 300 gallon tote bin positioned on elevated tower.

HVLP Starting Recommendations				
Type	Fluid Nozzle	Air Cap	Fluid Pressure	Atomization Pressure
Graco 239542	239592	192315	5-10 psi	30-50 psi
Binks BBR	20	905P	5-10 psi	30-50 psi
DeVilbiss JGA 510	FX	98	5-10 psi	30-50 psi

Cleanup Procedures

- When still wet, use warm soapy water

For dry adhesive removal: MEK, isopropyl alcohol, or “environmentally safe” solvents such as Citrex (Inland Technology)

Storage and Handling

- Protect from freezing
- Storage temperatures between 60-85° F (15-30°C) are recommended.

No special handling instructions due to toxicity. This product contains limited amounts of residual monomer. Under normal handling and use conditions the residual monomer should not present a hazard. In storage, the monomer will migrate from the emulsion and establish an equilibrium between the headspace in the storage container and the liquid emulsion. Levels in excess of acceptable exposures can accumulate in non-vented headspaces above the emulsion. All procedures appropriate for a confined space entry should be completed prior to performing any work in a bulk storage tank.

Shelf Life

12 months from date of manufacture when stored in original, unopened container at recommended temperature conditions.

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North America
+888-HBFULLER
+888-423-8553

inquiry@hbfuller.com
www.hbfuller.com



H.B. Fuller