



Armor-Bond Flex

AP-1230 A/B

70 SHORE A POLYURETHANE ADHESIVE



AP-1230 is a two-part, flexible polyurethane adhesive with a 3-4 minute work time. Designed to bond together many of BJB's flexible polyurethane cast products, this adhesive exhibits excellent bond strength and shock absorption. AP-1230 can also be used to bond BJB flexible polyurethane foams and other flexible substrates. Great for Medical Simulation Models, Fabrics, Cosplay Foam Armor & Props, Movie Special Effects, and much more. AP-1230 is available in 50ml cartridges. 50ml dispensing guns are sold separately.

- RoHS/REACH Compliant
- Excellent Adhesion
- Thixotropic Bead
- Quick Setting
- Convenient 1:1 (pbv) mix ratio
- Remains Flexible

| PHYSICAL PROPERTIES | TEST METHOD | ELEVATED TEMPERATURE CURE |
|----------------------------|-----------------|---------------------------|
| Hardness, Shore A | ASTM D2240-04e1 | 70 ± 5 |
| Density (g/cc) | ASTM D792-00 | 1.081 |
| Cubic Inches per Pound | N/A | 25.58 |
| Color/Appearance | Visual | Translucent Pale Yellow |
| Dielectric Constant, 1 MHz | ASTM D150-87 | 3.695 |
| Dissipation Factor, 1 MHz | ASTM D150-87 | 0.0722 |

Note: Reported physical properties are based on test specimens cured for 24 hours at room temperature.

| HANDLING PROPERTIES | Part A | Part B |
|------------------------------------------------|---------------|-------------|
| Mix Ratio by weight | 100 | 91 |
| Mix Ratio by volume | 100 | 100 |
| Specific Gravity @ 77°F (25°C) | 1.121 | 1.018 |
| Color | Pale Yellow | Pale Yellow |
| Viscosity (cps) @ 77°F (25°C) Brookfield | 3,790 | 890 |
| Mixed Viscosity (cps) @ 77°F (25°C) Brookfield | Non-Flowable | |
| Work Time, 10 g mass @ 77°F (25°C) | 3 – 4 minutes | |
| Thin Film Set Time | 15 minutes | |

Properties above are typical and not for specifications.

SURFACE PREPARATION:

Abrade and clean surfaces before bonding. For best results, a chemical wipe of surfaces with a clean solvent (e.g. Acetone) works best to remove grease, dirt, or dust.

DIRECTIONS FOR CARTRIDGE USE:

- Place cartridge into the dispense gun. Before attaching the mix tip, dispense a small amount of adhesive to ensure proper flow on both sides. If there is a restriction, use a pointed object to clear any blockage. Once blockage is cleared, dispense a small amount to verify flow.
- Attach mix tip. Begin pumping the adhesive through the mix tip. It is advisable to dispense a small waste shot of material to ensure both A & B are mixed properly.
- When finished dispensing, leave the mix tip attached. Adhesive in the tip will cure, creating its own seal for storage should there be remaining adhesive in cartridge.
- Remove used mix tip when using cartridge again. Repeat steps above to dispense more adhesive.

COLOR VARIATIONS:

The color of the base material may vary slightly from batch to batch due to raw ingredients. Color variations will not affect the cured physical properties. Exposing the material to various conditions such as heat and UV light will alter the color of the cured system. Color stability is not guaranteed. This product can be pigmented, but you may see more color shift when using lighter pigments.

STORAGE:

Store at ambient temperatures, 65-80°F (18-27°C). Sealed packages will have a shelf life of 3 months from date of shipment when properly stored at recommended temperatures. Purge opened containers with dry nitrogen before re-sealing.

| PACKAGING | Part A | Part B |
|---------------------|---------------|---------------|
| 50ml Dual Cartridge | 1 oz. | 0.91 oz. |

SAFETY PRECAUTIONS:

Use in a well-ventilated area. Avoid contact with skin using protective gloves and protective clothing. Repeated or prolonged contact on the skin may cause an allergic reaction. Eye protection is extremely important. Always use approved safety glasses or goggles when handling this product.

IF CONTACT OCCURS:

Skin: Immediately wash with soap and water. Remove contaminated clothing and laundry before reuse. It is *not* recommended to remove resin from skin with solvents. Solvents only increase contact and dry skin. Seek qualified medical attention if allergic reactions occur.

Eyes: Immediately flush with water for at least 15 minutes. Call a physician.

Ingestion: If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel. Never give anything by mouth to an unconscious person.

⚠WARNING: This product can expose you to chemicals including Ethyl acrylate, which are known to the State of California to cause cancer and birth defects or other reproductive harm. For more information, go to www.P65Warnings.ca.gov.

NOTE:

Refer to the Safety Data Sheet before using this product. For processing tips and guides, please visit: learn.bjbmaterals.com to discover additional information.