UNISEAL 2320
Induction heat responsive structural adhesive

TECHNICAL DATA SHEET

DESCRIPTION:
UNISEAL 2320 is a black, induction heat responsive structural adhesive. It is a sag resistant, pumpable, one-component, epoxy-based adhesive system. UNISEAL 2320 requires an oven cure cycle to achieve cured adhesive strengths.

SUGGESTED USES:
UNISEAL 2320 is primarily used as a hem flange structural adhesive to bond metal automotive components such as decklids, hoods and doors. The induction heat response of UNISEAL 2320 makes it well suited for bonding processes that require some initial handling strength without the expense of a two-part system. It can be used wherever "oily" and poorly prepared substrates, such as hot dipped and electro-galvanized steel, are used.

APPROVAL:
Ford Material Specification WSS-M2G300-A2

PROPERTIES INCLUDE:
• Adhesive adheres to poorly prepared substrates
• Induction heat responsive
• Easy to pump
• Sag resistant
• Excellent adhesion through various draw lubricants and oils
• Non-toxic and non-corrosive

APPLICATION/DIRECTION FOR USE:
UNISEAL 2320 is applied by typical industrial pumping systems.
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PRODUCT CHARACTERISTICS:

As Received

DESCRIPTION: High-viscosity material

VISCOSITY: 10-30 seconds, 550 kPa through a 2.64 mm orifice

DENSITY: 1.39 ± 0.02 kg/l

PERCENT SOLIDS (ASTM D 2834): 99% minimum

ASH (S) 3491 (METHOD A): 23.9%

WASH RESISTANCE (FLTM BV 116-01, METHOD A): No displacement or wash-off

E-COAT COMPATIBILITY (FLTM BV 119-01): No film irregularities or E-coat contamination

SAG RESISTANCE (FLT BV 118-01): 150 mm x 25 mm x 6 mm ribbon
Horizontal: 3 mm maximum
Vertical: 3 mm maximum
Inverted: no loss of material

SHELF LIFE: 90 days when stored below 40°C

PACKAGING: 55 gallon open-head drums and 5 gallon open-head pails

MECHANICAL PROPERTIES:

BAKE CYCLE: 171°C ± 2°C/20 minutes minimum
205°C ± 2°C/40 minutes maximum

LAP SHEAR STRENGTH INDUCTION CURE: 1.4 MPa minimum (SAE J 1523)
(1” x 0.5”, 0.01” bondline)

LAP SHEAR STRENGTH OVEN CURE: 6.9 MPa minimum (SAE J 1523)
(1” x 0.5”, 0.01” bondline)