

# Ratio-Pak Cartridge Systems

Snap-together cartridges for two-component (2K) materials



Ratio-Pak cartridges snap together in package volumes from 60mL to 1500mL



Ratio-Pak cartridge with separated bores



Ratio-Pak cartridge with joined bores



Select ratios from 1:1 up to 25:1

Ratio-Pak® cartridge systems offer a versatile solution to package a variety of two-part materials, including foams, coatings, potting compounds, and other adhesives and sealants.

The Ratio-Pak line uses individual cartridges that snap together with Ratio-Pak cartridges of any other size. This unique, patented design gives users the flexibility to combine multiple ratios, from 1:1 up to 25:1, to achieve proper mixing results.

Cartridge configurations are available with a variety of capping solutions, assorted thread forms, and self-venting seals for easy filling.

## Features

- Snap-together design for easily changeable configurations
- May be filled through the nozzle or back side of the cartridge
- Fit industry-standard dispense guns
- Many mixer options available

## Benefits






- Versatile design allows different mix ratios and volumes
- Snap-together cartridges help reduce inventory; join side 1 with different sizes of side 2
- Match different resins for chemical compatibility; for example, mate PP side 1 with nylon side 2
- Easy filling and handling, with quick clean-up



more info



## Ratio-Pak Cartridges

| RATIO-PAK SNAP-TOGETHER CARTRIDGES  |         |                                    |  |          |         |
|---|---------|------------------------------------|--|----------|---------|
| 75mL Ratio-Pak Cartridges   |         |                                    |  |          |         |
|   | Part #  | Usable Volume                      | Description  | Material | Color   |
|    | 7661540 | 75mL                               | Ratio-Pak cartridge, 7/8 - 9 outlet thread, A-side | PP       | Natural |
|   | 7661411 | 75mL                               | Ratio-Pak cartridge, 7/8 - 14 outlet thread        | PP       | Natural |
|   | 7661440 | 75mL                               | Ratio-Pak cartridge, 7/8 - 14 outlet thread        | Nylon    | Natural |
|   | 7660545 | –                                  | 75mL piston rear seal, non-vented                  | MDPE     | Black   |
|   | 7660873 | –                                  | 75mL piston rear seal, self-vented                 | MDPE     | Black   |
| 100mL Ratio-Pak Cartridges  |         |                                    |  |          |         |
|   | Part #  | Usable Volume                      | Description  | Material | Color   |
|    | 7660569 | 100mL                              | Ratio-Pak cartridge, 7/8 - 14 outlet thread        | PP       | Natural |
|   | 7660589 | –                                  | 100mL piston rear seal, non-vented                 | MDPE     | Black   |
| 150mL Ratio-Pak Cartridges  |         |                                    |  |          |         |
|   | Part #  | Usable Volume                      | Description  | Material | Color   |
|    | 7364433 | 150mL                              | Ratio-Pak cartridge, 7/8 - 9 outlet thread, B-side | PP       | Natural |
|   | 7660598 | 150mL                              | Ratio-Pak cartridge, 7/8 - 14 outlet thread        | PP       | Natural |
|   | 7660604 | 150mL                              | Ratio-Pak cartridge, 7/8 - 14 outlet thread        | PE       | Natural |
|   | 7660609 | –                                  | 150mL piston rear seal, non-vented                 | MDPE     | Black   |
|   | 7660878 | –                                  | 150mL piston rear seal, self-vented                | MDPE     | Black   |
| 7660610   | –       | 150mL piston rear seal, non-vented | HDPE   | Black    |         |
| 200mL Ratio-Pak Cartridges  |         |                                    |  |          |         |
|   | Part #  | Usable Volume                      | Description  | Material | Color   |
|   | 7661405 | 200mL                              | Ratio-Pak cartridge, 7/8 - 14 outlet thread        | PP       | Natural |
|   | 7661403 | –                                  | 200mL piston rear seal, non-vented                 | MDPE     | Black   |
|   | 7661404 | –                                  | 200mL piston rear seal, self-vented                | MDPE     | Black   |
| 250mL Ratio-Pak Cartridges  |         |                                    |  |          |         |
|   | Part #  | Usable Volume                      | Description  | Material | Color   |
|  | 7661408 | 250mL                              | Ratio-Pak cartridge, 7/8 - 9 outlet thread, A-side | PP       | Natural |
|   | 7661409 | 250mL                              | Ratio-Pak cartridge, 7/8 - 14 outlet thread        | PP       | Natural |
|   | 7661406 | –                                  | 250mL piston rear seal, non-vented                 | MDPE     | Black   |
|   | 7661407 | –                                  | 250mL piston rear seal, self-vented                | MDPE     | Black   |




Order both side 1 and side 2 based on ratio requirement and volume.

Part numbers noted as A-side or B-side must be sold in matching pairs. A-side cartridges are only compatible with B-side cartridges.

*Continued on next page*

# Ratio-Pak Cartridges

Continued from previous page

| RATIO-PAK SNAP-TOGETHER CARTRIDGES   |         |               |  |          |         |
|--|---------|---------------|--|----------|---------|
| 300mL Ratio-Pak Cartridges   |         |               |  |          |         |
|  | Part #  | Usable Volume | Description  | Material | Color   |
|   | 7660650 | 300mL         | Ratio-Pak cartridge, 7/8 - 9 outlet thread, B-side             | PP       | Natural |
|  | 7660625 | 300mL         | Ratio-Pak cartridge, 7/8 - 14 outlet thread                    | PP       | Natural |
|  | 7660630 | 300mL         | Ratio-Pak cartridge, 7/8 - 14 outlet thread                    | PE       | Natural |
|  | 7660626 | 300mL         | Ratio-Pak cartridge, 7/8 - 14 outlet thread                    | Nylon    | Natural |
|  | 7660653 | –             | 300mL piston rear seal, non-vented                             | MDPE     | Black   |
|  | 7660884 | –             | 300mL piston rear seal, self-vented                            | MDPE     | Black   |
|  | 7660656 | –             | 300mL piston rear seal, non-vented                             | HDPE     | Black   |
| 600mL Ratio-Pak Cartridges   |         |               |  |          |         |
|  | Part #  | Usable Volume | Description  | Material | Color   |
|   | 7660665 | 600mL         | Ratio-Pak cartridge, 7/8 - 9 outlet thread, A-side             | PP       | Natural |
|  | 7660663 | 600mL         | Ratio-Pak cartridge, 7/8 - 14 outlet thread                    | PP       | Natural |
|  | 7660666 | –             | 600mL piston rear seal, non-vented                             | MDPE     | Black   |
|  | 7661708 | –             | 600mL piston rear seal, self-vented                            | MDPE     | Black   |
| 750mL Ratio-Pak Cartridges   |         |               |  |          |         |
|  | Part #  | Usable Volume | Description  | Material | Color   |
|  | 7661410 | 750mL         | Ratio-Pak cartridge, 7/8 - 9 outlet thread, B-side             | PP       | Natural |
|  | 7660667 | 750mL         | Ratio-Pak cartridge, 7/8 - 14 outlet thread                    | PP       | Natural |
|  | 7660683 | –             | 750mL piston rear seal, non-vented, vented, for PP cartridges  | MDPE     | Black   |
|  | 7660887 | –             | 750mL piston rear seal, self-vented, vented, for PP cartridges | MDPE     | Black   |
|  | 7660668 | 750mL         | Ratio-Pak cartridge, 7/8 - 14 outlet thread                    | Nylon    | Natural |
|  | 7660686 | –             | 750mL piston rear seal, non-vented, for nylon cartridges       | HDPE     | Natural |
|  | 7660687 | –             | 750mL piston rear seal, self-vented, for nylon cartridges      | HDPE     | Natural |

Order both side 1 and side 2 based on ratio requirement and volume.

Part numbers noted as A-side or B-side must be sold in matching pairs. A-side cartridges are only compatible with B-side cartridges.

Material:

PP (polypropylene)      LDPE (low-density polyethylene)  
 PE (polyethylene)      MDPE (medium-density polyethylene)  
    HDPE (high-density polyethylene)

| RATIO-PAK ACCESSORIES |  |   |
|-----------------------|--|---|
| Part #                | Description  | Notes   |
| 7660792               | Disc, 1.9 x 1.6 mm (0.75 x 0.062"), PE, white              | When installed between a capped barrel and nut, keeps the nose plug stable.                                       |
| 7660794               | Gasket tape, 1.9 x 1.9 mm (0.75 x 0.75"), two-sided, white | Place gasket tape on the flat side of the cartridge neck to prevent material from flowing between the cartridges. |
| 7660945               | Vent strip, PE, white                                      | Reusable vent strip for non-vented rear seals.  |
| 7660731               | Retaining nut, 7/8 - 9 cartridges                          | Retaining nuts secure the mixer to the cartridge.   |
| 7660818               | Retaining nut, 7/8 - 14 cartridges                         | Retaining nuts secure the mixer to the cartridge.   |



## Flow Restrictors

EFD's low-cost, plastic flow restrictors eliminate problems caused by low-viscosity fluids by slowing the thinner component's flow.



## Cartridge Caps

Each Ratio-Pak cartridge set requires a one-piece or two-piece sealing cap. Two one-piece caps (called D-plugs) are required per cartridge set. Only one two-piece cap is required per cartridge set.

| RATIO-PAK FLOW RESTRICTORS |        |                               |          |       |
|----------------------------|--------|-------------------------------|----------|-------|
| Part #                     | Type   | Orifice Size (mm / in)        | Material | Color |
| 7660764                    | Flat   | 1.6 x 1.6 mm (0.063 x 0.063") | LDPE     | Black |
| 7660766                    | Flat   | Dual Slit                     | LDPE     | Black |
| 7660768                    | Flat   | Slit x 4.8 mm (Slit x 0.188") | LDPE     | Black |
| 7661231                    | Tabbed | 2.4 x 2.4 mm (0.094 x 0.094") | LDPE     | White |
| 7661232                    | Tabbed | Dual Slit                     | LDPE     | Blue  |
| 7661325                    | Tabbed | 2.4 x 4.8 mm (0.094 x 0.188") | LDPE     | Red   |

| RATIO-PAK CARTRIDGE CAPS |                       |             |         |                 |
|--------------------------|-----------------------|-------------|---------|-----------------|
| Part #                   | Description           | Material    | Color   | # per Cartridge |
| 7660214                  | D-plug                | PE          | Black   | 2               |
| 7660215                  | D-plug                | PE          | Natural | 2               |
| 7660216                  | D-plug                | PE          | White   | 2               |
| 7660218                  | D-plug                | Santoprene* | Black   | 2               |
| 7660217                  | D-plug                | Santoprene  | Natural | 2               |
| 7660220                  | Cartridge cap, flat   | PE          | White   | 1               |
| 7661196                  | Cartridge cap, tabbed | PE          | White   | 1               |

\*For difficult-to-seal materials.

## Recommended 2K Mixers

Nordson EFD offers a variety of static mixers for Ratio-Pak cartridges, including OptiMixers™ and other square and spiral mixers. To request samples for your application, go to [www.nordsonefd.com/2Ksamples](http://www.nordsonefd.com/2Ksamples).

| DISPOSABLE MIXERS |                        |        |
|-------------------|------------------------|--------|
| Series            | Type                   | Style  |
| Series 480        | OptiMixer              | Square |
| Series 280        | Turbo Integral Nut     | Square |
| Series 160        | Bell Inlet             | Spiral |
| Series 161N       | High-Flow Integral Nut | Spiral |
| Series 260        | Bell & Integral Nut    | Spiral |



Series 480 OptiMixers



Series 280N



Series 160



Series 260

## 2K Dispense Guns

Nordson EFD's 2K dispense guns are compatible for use with our Film-Pak®, Side x Side, Ratio-Pak, and coaxial cartridge systems. Lightweight and durable, 2K dispense guns make applying two-component adhesives quicker and easier. Available in three models.



Manual dispense gun



Pneumatic dispense gun



Cordless dispense gun



For Nordson EFD sales and service in over 40 countries, contact Nordson EFD or go to [www.nordsonefd.com](http://www.nordsonefd.com).

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