

# ENDURABOND™ RC ADHESIVE

## DESCRIPTION

Endurabond® RC Adhesive is a 100% solids, two component cold bond system used to bond vulcanized rubber to vulcanized rubber or vulcanized rubber to metal. It is specifically designed to bond natural and synthetic elastomers, such as chlorobutyl, bromobutyl, and Neoprene®. This adhesive has an open working time of 45 minutes. Cured adhesive forms a strong bond that can withstand harsh environmental conditions that include, but are not limited to, strong acids, bleach, and brine.

## FEATURES AND BENEFITS

**Environmentally compliant** - 100% reactive adhesive formulated with no VOC's.

**Room temperature cure** - Cures at room temperature without additional heat or steam; develops handling strength in 2 hours, achieving full cure in 24 hours.

**Environmentally Resistant** - demonstrates a strong resistance to harsh chemicals, high humidity and high temperature environments. Survives temperature cycling from -40°F to 230°F (-40°C to 110°C)

**High Temperature Resistance** - Can be used in elevated temperatures up to 230°F (110°C).

**Non-Sag** - remains in position when applied to vertical and overhead surfaces.

**Easy to Apply** - easily dispensed through cartridge and static mixer. Can be dispensed on either rubber or grit blasted metal surface and spreads well by brushing or troweling

**Durable** - Strong adhesion between metal and rubber produces deep rubber tear bonds on various elastomers of different moduli and thicknesses.

## TYPICAL PHYSICAL PROPERTIES

|                     |  |
|---------------------|--|
| Color               | Cream  |
| Consistency         | Paste  |
| Viscosity           | 100-300 cps  |
| Specific Gravity    | 1.04   |
| Coverage            | 150-170 sq.ft./gallon (18 sq.ft./cartridge)                                    |
| Pot Life            | < 60 minutes   |
| Thinner             | None - 100% solids   |
| Flash Point         | Part A - 124°F (51°C)<br>Part B - 141°F (61°C)                                 |
| Working Temperature | 40°F to 200°F (4°C to 93°C)  |
| Shelf Life          | 180 days in unopened containers  |
| Storage             | Store at cool temperatures, out of sunlight, away from heat, sparks and flame. |
| Packaging           | 400 ml cartridge   |

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## DIRECTIONS FOR USE

### PREPARATION

Grit blast the metal surface to conform to SSPC-SP5 (or NACE 1) specifications for a white metal blast with a minimum surface profile of 2 mils. Primer is not necessary but Endurabond™ Primer 1 may be used if oxidation is probable.

Rubber surface should be solvent wiped or roughened with a buffing wheel. A freshly buffed surface does not require solvent wiping.

### SOLVENT

Isopropyl alcohol (rubbing alcohol)

### TOOLS

- \* Mixing nozzle (2 provided per cartridge)
- \* 400ml, dual cartridge, 10:1 applicator (available from industrial supply houses)
- \* Brush or fine notched trowel 1/16" x 1/16" x 1/32"

### MIXING

The adhesive system has a 10:1 mix ratio, by volume. Dispensing through the cartridge and static mixer is required to ensure correct component ratio and a proper mix.

Prolonged breathing of vapors is harmful. Use only with adequate ventilation and an approved respirator. See SDS for further instructions.

### APPLICATION

Adhesive should be dispensed directly onto prepared surface. Do not dispense adhesive into a separate container before applying to substrate.

1. Remove cap from adhesive cartridge, level the two pistons by triggering the the dispensing gun without the static mixer attached. Once both components are dispensed evenly, attach the static mixer.
2. Discard the first full trigger of adhesive. When both components mix with a consistent color, the adhesive is ready to use.
3. Dispense adhesive onto either rubber or metal surface in long parallelbeads, (about 1/8" (3mm) in diameter), across the surface. The adhesive beads should be roughly 1/2" (13mm) apart.

4. Spread with a brush or notched trowel until the entire surface is evenly covered. Adhesive must be spread within 10 minutes of application - ideally 10-30 mils thick.
5. Let stand for 10-15 minutes, depending upon thickness of sheet, until tack develops
6. When tacky, apply rubber sheet to substrate being careful not to trap air. Open time is 45 minutes at 77°F (25°C) which allows for positioning and alignment.
7. Once aligned, roll the sheet down firmly ensuring intimate metal contact while pushing out any trapped air.
8. Tools should be cleaned with isopropyl alcohol while adhesive is still wet.

### CURING

Adhesive cures at ambient temperature, 50-104°F (10-40°C), developing handling strength in 2 hours and full strength in 24 hours.

### SHELF LIFE/STORAGE

Shelf life is 6 months from date of manufacture when stored in original, unopened container at a temperature between 40-50°F (4-10°C). Exposing adhesive cartridges to heat will reduce shelf life.

### CAUTION

Before using this product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

For industrial/commercial use only. Not to be used in household applications. Not for consumer use.