

250

COLD BONDING ADHESIVE

Technical Data Sheet

ISSUED: December 2019

DESCRIPTION

TAC ADHESIVES - 250 CONTACT ADHESIVE is a 2 - component adhesive (together with **IRODUR E462 CURING AGENT**) developed for use in rubber bonding applications. It offers HIGH INITIAL GRAB , HEAT RESISTANCE, and GOOD OPEN TIME.

FIELDS OF APPLICATION

Bonding rubber to rubber and rubber to metal in mining applications.

SURFACE PREPARATION

Surfaces should be clean and free from oil, dust and other foreign materials.

Metal : sandblast surface to remove any rust then clean with **TAC ADHESIVES - 101 CONTACT CLEANER THINNER**. Prime metal surface using Chemlok 205 Metal Primer allowing primer coat to completely dry before applying adhesive coat.

Rubber : Buff then clean the rubber surface with a quick drying petroleum based solvent. Natural Rubber surfaces may need Chlorination for maximum adhesion.

APPLICATION

Best results are obtained under the following conditions:

Workshop, material and glue temperature: 20°C

Relative humidity: 60 - 70%

Thoroughly mix approximately 4 - 7% by weight of IRODUR E462 Curing Agent into required quantity of 250 Adhesive. Use within 2 - 3 hours.

Apply 2 coats of adhesive to bonding surfaces with a brush, allowing ~ 1 hour between coats.

Coverage Rate: ~ 4 m²/Litre per coat.

After the second coat allow adhesive to evaporate until it is no longer tacky to touch.

Join surfaces before end of open time.

Apply as much pressure as possible to obtain optimum bond strength.

Full cure occurs after ~ 7 days but may take longer due to substrates causing solvent entrapment

CLEAN UP

Clean brushes and rollers in **TAC ADHESIVES - 101 CONTACT CLEANER THINNER**.

TECHNICAL DATA

Base: Polychloroprene Rubber

Colour: Clear or Pink

Viscosity: Brushable liquid

Pack Sizes: 20 and 200 Litre

Best Before: 12 months

SAFETY DIRECTIONS

Avoid contact with skin and eyes and avoid breathing the vapour or spray mist. Store under cover, out of direct sunlight and in a well ventilated area. Keep away from all sources of ignition - No Smoking.

FIRST AID

If poisoning occurs contact a doctor or Poisons Information Centre. If swallowed, DO NOT induce vomiting. Give a glass of water. If in eyes, hold eyes open, flood with water for at least 15 minutes and see a doctor. Refer to Safety Data Sheet for further information.

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The information contained in this technical data sheet is based on our present knowledge and experience. They may be considered only as guidelines as many factors can affect processing and application. Users should determine the suitability of the product by means of their own tests for its intended application.