

FORSCH POLYMER CORP.

TECHNICAL DATA BULLETIN

ADH 1020

ONE PART PRIMER-ADHESIVE FOR BONDING URETHANE TO RUBBER

DESCRIPTION

ADH 1020 is a single-coat primer and adhesive for bonding elastomers to cured urethane or vulcanized rubber. Bonds are resistant to water, salt spray, many solvents and other environmental conditions.

TYPICAL PROPERTIES

Composition	: A mixture of organic polymers dissolved in an organic solvent system
Color	: Brownish tone, off yellow liquid
Viscosity (77 Deg F)	: 200 - 400 cps
Volatile Content Weight	: 60 - 70%
Coverage	: 320 sq. ft./gallon
Density	: 6.8 - 7.0#/gallon
Flash Point (Pensky-Martens Closed Cup)	: -25 Deg F
Shelf Life from date of shipment, unopened container, 70 - 80 Deg F	: 6 Months
Storage	: Do not store or use near heat or open flame
Thinning Procedures	: Thin with Methyl Ethyl Ketone

SURFACE PREPARATION

Roughen urethane or rubber surfaces with sand paper or a wire wheel. Wash with MEK or Trichloroethane prior to applying. Application Temperature: 50 to 100 Deg F

APPLICATION

Slight agitation is required prior to use. May be applied to the cleaned substrate by brushing, dipping, spraying roller coating, or other method that gives a uniform coating and avoids excessive runs or streaks. Actual film should not exceed approximately 5 mils. After adhesive dries to a non-tacky film in a short amount of time, approximately 5 minutes at 77 Deg F, a second coat should be applied and allowed to dry to a slightly tacky surface, approximately 2 minutes. At this point the liquid or putty type urethane should be applied then allowed to complete the cure cycle for the particular product being used.

HANDLING AND PROCESSING

The bonding operation should take place as soon as the adhesive has tacked to avoid surface contamination.

STORAGE

Systems should be stored unopened in air tight containers at 60 - 90 degrees F.

CAUTION: Flammable liquid, store away from all heat or open flames!!!

HANDLING PRECAUTIONS

For complete and updated health and safety information, read the MATERIAL SAFETY DATA SHEETS. Do not handle or use until the MATERIAL SAFETY DATA SHEET has been read and understood.

REL 99

NON FLAMMABLE SILICON BASED LIQUID RELEASE

DESCRIPTION

REL 99 is a single component package, non-flammable silicon based liquid release agent designed to be applied directly to mold surfaces in single or multiple coat applications allowing quick and easy release of molded articles with maximum mold protection. **REL 99** is also recommended for in-mold applications where in-mold coatings are applied for color stability and high temperature exotherm protection.

FEATURES

Single Component
Non Flammable
Excellent Spraying Characteristics
Uniform Film Formation
Quick Drying
Outstanding Release Qualities

TECHNICAL SPECIFICATION

Solids by Weight	12%
Theoretical Coverage	100 mil sq. ft./gallon
Recommended Thickness	.25 - .50 mils
Number of Coats	1 or 2
Shelf Life	6 Months at 75 Deg F in Sealed Container
Flash Point	NF

APPLICATION

Thoroughly clean mold surface to prevent release build up and part contamination. Mold surface and ambient temperature should be 60 - 150 Deg F for proper application and uniform film formation.

Method: Brush spray apply with conventional pressure pot, airless or cap gun.

Dry Time @ 77 Deg. F: Approximately 5 minutes

Cleanup: MEK or other chlorinated base type solvent.

STORAGE

Systems should be stored unopened in air tight containers at 60 - 90 degrees F. Partially emptied containers should be swept free of atmospheric moisture with dry nitrogen before sealing.

HANDLING PRECAUTIONS

For complete and updated health and safety information, read the MATERIAL SAFETY DATA SHEETS. Do not handle or use until the MATERIAL SAFETY DATA SHEET has been read and understood.

This product is warranted to be of uniform quality within manufacturing tolerances. Since no control is exercised over its use, no warranty, expressed or implied, is made as to the effects of such use. The obligation herein shall be limited to refunding the purchase price of that portion of the material proven to be defective.