

## 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.