

BONDTITE HEATBOND SR is solvent-borne rubber-based contact adhesive designed with a special feature of excellent heat resistance up to 180 °C. It possesses quick grab property and strong bonding efficiency.

FEATURES & BENEFITS

- Excellent bond strength and fast setting
- High heat resistance up to 180 °C
- Ease of application with good coverage
- Mild smell
- Benzene free

AREAS OF APPLICATIONS

Suitable for manufacturing and repair purposes in many different industries as below.

- Any Vertical lamination
- Wood to laminate bonding
- PVC Edge binding
- Bus body interiors

HOW TO USE

- Ensure that substrates to be bonded are clean, dry and free from oil, grease and foreign particles such as dust and rust.
- Stir adhesive well and make it homogeneous prior to use.
- Apply adhesive uniformly in thin layer on both the substrates to be bonded with spreader, spatula or any suitable tool.
- Allow evaporation of solvents from adhesive layer to develop tack. The evaporation of solvent may take up to 5 minutes or more which depends upon surrounding temperature and humidity.
- Bring both the surfaces together and align properly from end to end. Apply uniform pressure to eliminate possible air entrapment and achieve close contact without air pockets for long lasting bonding.
- The optimum bond strength is achieved after 24 hours.

STORAGE

Product should be stored in a dry place in their original, properly closed cartridge at temperatures between 2°C to 40°C. Partially used container should be closed immediately

TECHNICAL DETAILS

PROPERTIES	TESTING STANDARD	RESULTS	UNIT
Color	-	Light yellow viscous liquid	-
Specific gravity @ 25 °C	ASTM D 1475	0.86-0.92	-
Viscosity @ 25 °C	ASTM D2196-05	2500-3500	cPs
Drying time, 60μ film @ 25°C	STP_042	30-50	sec
Tack retention time*	STP_065	8-16	Min
Lap Shear strength, 24 hrs.	ASTM D 1002	18-24	kg/cm ²

* (Tack retention time (open time) is generally measured after evaporation of solvent once adhesive applied in thin film. It may vary depending upon ambient temperature and humid conditions.)

SHELF LIFE

18 months in unopened packaging in a dry and cool storage place, at temperatures between 5°C to 25°C.

HANDLING PRECAUTIONS

Product should be stored in cool and dry place away from moisture, heat and direct sunlight. It contains highly volatile solvents, which will be released during application, processing and use. These volatile solvents are highly flammable; hence adhesive must not come in contact with heat, spark and necked flame. Please refer to the Safety Data Sheet (SDS) for detailed instructions on storage and handling.

PACKING

100 mL, 200mL, 500mL, 1L, 5L

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