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RC13101 HypaBond 2-Part Adhesive Datasheet

Product Code: RC13101

Description

HypaBond is a quality, high performance polychloroprene adhesive. It can be used as either a single or two-part adhesive depending on the materials to be bonded and the bond strengths required. It was developed primarily for use with the curing agent to bond a range of rubbers and rubber coated fabrics (e.g. neoprene, hypalon, natural rubber, etc.) in inflatable constructions such as life rafts, dinghies, high-speed inflatable RIBs, etc. It may also be used in the manufacture of dry and wet suits for the bonding of rubber or nylon coated fabrics to themselves.

HypaBond may also be used as a single component adhesive in many general purpose applications for bonding materials such as Formica, Melamine and laminates to wood, metal, etc.

Not suitable for bonding plasticised PVC (unless the substrate is first primed with PVC) or expanded polystyrene.

Application

Surface Preparations

All substrates to be bonded should be thoroughly cleaned before bonding. Abrade surfaces using sandpaper or wire brushing followed by cleaning with solvent or similar to remove any grease and other contaminants liable to impair adhesion.

Application - Mixing ratio

HypaBond - 100 parts by weight / volume
Curing Agent - 6% by weight / 3.4% by volume

Materials should be mixed thoroughly; this usually takes 3-4 minutes mixing by hand. Mixed adhesive should not be used after 4 hours.

Apply a thin, even coat of the mixed adhesive to both substrates and allow to dry thoroughly. When dry, apply a further thin coat to both substrates and allow to tack off (15 - 30) minutes depending on drying conditions. Bring surfaces together and press firmly, finishing with a hand roller to ensure an even pressure.

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PVC bumpers and other fittings should be primed with PVC to stop plasticiser migration.

Cross-linking may take up to 7 days to provide full strength and durability.

For single-part, general use, apply an even coat of adhesive to both surfaces to be bonded and allow to dry for 10-20 minutes, until the solvent has evaporated but the adhesive remains tacky. Bring both surfaces together and consolidate the bond by use of roller or press.

Precautions

This type of product has been used quite safely for many years, but it is essential that the following are noted and observed.

- Keep the solution covered as much as possible; only have sufficient amount on the bench for immediate use.
- Contact between skin and eyes should be avoided – Wear gloves and goggles.
- In case of skin or eye contact irrigate affected area with plenty of clean water.
- Ensure good extraction or ventilation at point of application.
- Solvent base gives off a highly inflammable vapour; No smoking or pilot lights in the vicinity.
- Used wiping cloths should be washed in an excess of water before disposal.

Storage

Store in accordance with the requirements of The Petroleum Regulations in a flameproof area between 5°C and 25°C.

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Technical Specification

Property	HypaBond	Curing Agent
Physical Form	Liquid	Liquid
Colour	Off-white	Pale brown
Chemical Type	Polychloroprene rubber, synthetic resin blend	Polyisocyanate
Solvent	Mixture of hydrocarbons, toluene, and ketones	Dichlormethane
Viscosity (Brookfield RVT, 10rpm at 20°C)	2400 mPa (approx.)	-
Solids Content	22% (approx.)	27% (approx.)
Specific Gravity	0.85 (approx.)	1.3 (approx.)
Flammability	Highly flammable	Highly flammable
Open Time	10 to 30 minutes, subject to substrate conditions and length of time after addition of Curing Agent	
Pot Life (2 component mix)	4 hours (approx.)	
Packaging	4.275L	170ml
	932ml	37ml
	240ml	10ml

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