

Adhesive

Product Explanation

- Vulcan 22 is a one-component adhesive capable of NBR bonding.
- Vulcan 22 can be used as a primer on all grades.
- VULCAN 22 adheres elastomer and metal strongly, is strong in water with its good resistance and protects the product from all types of corrosion and oxidation.
- **Environment-friendliness**
 - Non-detection of 6 hazardous substances (Pb, Cd, Hg, Cr (VI) PBB, PBDE).
- Products produced by the use of VULCAN 22 are strong against all types of Grease and Oil, are safe at high temperature and are very strong.

Properties Information

Appearance	Slight yellow liquid
Structure	Polymer and filler dispersion in MIBK and Xylene
Viscosity	8-12s (Zahn Cup No. 3 @25°C)
Specific gravity	0.88 - 0.92 g/cm ³
Flashing point	18°C
Solid content	18 - 20% of the weight(100°C 1hr)
Dilution solvent	MEK, MIBK
Storage period	12 months from the production date (20~28°C)

Application

- VULCAN 22 can be applied by spraying, dipping and brushing
- The recommended application thickness for NBR is of about 10~20µm. When using it as a primer, 7~10µm may be required.
- Apply enough VULCAN 81 to metal surface to make concealed surface

Recommended Dilution Ratio

VULCAN[®] 22

TECHNICAL DATA SHEET

Brush	Not diluted
Dipping	Not diluted or 10~20% MEK or MIBK
Spraying	20 - 40 % MEK or MIBK

* Suitable dilution proportion for each type of application can be obtained through experience.

* When bonding NBR, it is recommended to test from the undiluted solution even if it is dipping or spraying.

Important Details

- ① VULCAN 22 requires enough agitation before use.
 - ② When not stirred enough, the solvent and solid part get dispersed and defects can be caused. Please pay enough attention during dilution and stir properly.
 - ③ Please apply after removing completely oil, humidity, dust, etc. from the metal to be applied.
 - ④ It is recommended to dry at room temperature until the solvent is completely evaporated when applying the adhesive. Please dry at less than 80°C for 10~20 minutes when drying by heat.
 - ⑤ The dried VULCAN 22 after applying on metals is transparent and prevents from corrosion. Additionally, the applied metal can be stored for a few months without change in an environment not contaminated.
 - ⑥ The recommended molding temperature is of 120°C~190°C.
- ※ This product was produced to do not make the solid part sink, and the upper part of the product may have a yellow color that feels like jelly when opening the product. This is normal and it returns to its original form after stirring for the first time.

Precautions

- ① Please be careful with inflammables or ignition as it contains flammable agents, and avoid work in confined spaces.
- ② Wear suitable protection gear when handling the product as it contains organic solvents. Do not inhale mist, etc. dispersed in the air.
- ③ Be careful to do not throw or cause strong impact on the product during transportation and storage.
- ④ Please refer to the MSDS data for more detailed information.

All the property information was recorded by production lot, and the value specified on the TDS indicates the general average property values. Additionally, each proposal was based from experiments and does not guarantee results on the real site. Please utilize after testing in advance.

U-ONE R2M Co., Ltd. is not only working hard in adhesives for rubber and metals but it is also conducting researches for the development of all types of adhesives for different materials. Please contact us by telephone or e-mail for further inquiries and suggestions about the product.

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