

One-coat Adhesive

Product Explanation

· General

-VULCAN 44 is a high performance one- coat bonding agent.
 -VULCAN 44 is suitable for bonding of CR, HNBR, NBR, NR, EPDM etc. to metals and plastics.

· Environment-friendliness

- Non-detection of 6 hazardous substances (Pb, Cd, Hg, Cr (VI) PBB, PBDE).

· Usability

- VULCAN 44 makes less deposition.
 -> shorter string time
 - Easily applied in spray, dipping and brush work

Properties Information

Appearance	Deep yellow liquid
Structure	Polymer and filler dispersion in Xylene, MIBK
Viscosity	20-28s (Zahn Cup No. 3 @25°C) 250-350 CPS(Brookfield LV, spindle 2, 30RPM @25°C)
Specific gravity	0.91 - 0.95
Flashing point	18°C
Solid content	17 - 19%
Dilution solvent	Toluene, Xylene, MEK, MIBK
Storage period	12 months from the production date (20~28°C)

Application

- VULCAN 44 can be applied by spraying, dipping and brushing.
- The recommended application thickness is of about 15~20 μ m, when necessary in severe environmental resistance, thicker application may be required.
- Apply enough VULCAN 44 to metal surface to make concealed surface.

Recommended Dilution Ratio

Brush	Not diluted
Dipping	20% by weight
Spraying	40 - 70 % by weight

* This recommendation was made by our test machine. So you can fit this based on your own way. Enough test is necessary before use.

VULCAN[®] 44

TECHNICAL DATA SHEET

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

Important Details

- ① VULCAN 44 requires enough churning 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 and the recommended metal surface temperature is under 50°C.
- ④ It is recommended to dry at room temperature(10~30°C) until the solvent is completely evaporated(around 30 minutes) when applying the adhesive. . Please dry at less than 80°C for 10 minutes when drying by heat.
- ⑤ The dried VULCAN 44 after applying on metals is dark yellow 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 165°C~180°C.

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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