



H.B. Fuller



ROYAL
ADHESIVES & SEALANTS

Silaprene®

TECHNICAL SALES BULLETIN

SILAPRENE® DC 13233

NATURAL RUBBER PSA ADHESIVE

SILAPRENE DC 13233 is an off white colored, solvent-based, pressure sensitive adhesive for paper, card stock, foils, rigid plastics, and polyolefin foams and films.

DESIGNED TO BOND:

1. Polyethylene and polypropylene foam and plastic.
2. Most plastic substrates, including polyurethane foam.
3. Paper, cardboard, chipboard, and metal foils.
4. Glass and ceramic materials.
5. Most elastomers, including EPDM, natural and TPR.
6. Painted and bare metal.
7. Not recommended for highly plasticized vinyls.

PHYSICAL CHARACTERISTICS:

1. Brush or roll coat viscosity.
2. Medium tack strength to most substrates.
3. Good peel adhesion.
4. Good resistance to creep and cold flow.
5. Resists heat, water and cold.
6. Retains tack at temperatures as low as 40°F.
7. High shear strength.
8. Shelf life: 1 year at temperatures not to exceed 80°F.

TYPICAL PROPERTIES:

(Specification ranges available on request)

Base: Natural Rubber
 Color: Off White
 Solvent: Hexane/Toluene
 Solids: 32%
 Viscosity: 18000 cps, RVF Brookfield,
 #4 spindle, @ 20 rpm.
 Weight/gallon: 6.8 pounds
 Specific Gravity: .82
 Temperature range: 40°F to 240°F

PREPARATION OF SUBSTRATES:

Surfaces to be bonded should be cleaned of all dust, oils or other contaminants. A solvent wipe is often adequate. Bonds to rigid surfaces are usually improved by a solvent wipe followed with light abrasion (180 grit), and solvent wiping to remove abrasive residue. Dry surfaces thoroughly before applying adhesive.

CLEANER AND THINNER:

Toluene

METHOD OF APPLICATION:

Apply one coat of adhesive by brush to one of the surfaces to be bonded. Join the surfaces when the adhesive is tacky to the touch but does not transfer to the finger. Use sufficient pressure to ensure good contact. Bonds can be made in 1 to 5 minutes, depending on ambient conditions and coating weight.

The adhesive can be applied by knife coating, roll coating, and by reverse roll coating. For better adhesion and surface wet-out, the adhesive can be applied directly to the surface to be bonded. However, for better control of adhesive film thickness, coating onto release paper is recommended. Dry film thickness can vary from 1 to 10 mils, depending on the surface conditions of the substrate.

After drying the adhesive on the release paper, the substrate should be laminated to the adhesive film and pressed or rolled between nip rollers to effect a transfer from the release paper to the substrate. Combined surfaces should be dried an additional 24 hours at room temperature prior to cutting or other operations. This will allow any remaining solvent to diffuse out and reduce flowing and gumming of cutting knives

PRECAUTIONARY DATA:

This product is extremely flammable. Vapors may form an explosive mixture with air. Precautions should be taken to keep product away from fire, sparks, motors and other sources of heat or flame. Turn off or deactivate any electrical equipment or sources of ignition. Adequate ventilation is required to keep vapor concentrations below the Threshold Limit Value.

- For professional or industrial use only.
- Read the container label and the Safety Data Sheet carefully before use.
- Keep away from children.
- Keep container closed when not in use.
- Store closed container under 80°F.
- This product contains toxic chemicals subject to the reporting requirements of Section 313 of the Emergency Planning and Community Right-to-Know act of 1986 and 40CFR 372.

DISPOSAL INFORMATION:

When discarded, this material is hazardous waste. Do not reuse container or remove label. Safely dispose of container and contents in accordance with applicable Federal, State and local regulations.

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ISO 9001:2008

For Reference Only

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This product is warranted to the original purchaser to meet published specifications, if any, and, in the absence of published specifications, to be merchantable quality. Such warranty may not be assigned or otherwise transferred by purchaser. No other warranty, expressed or implied, of fitness for a particular purpose or any other thing is made. Purchaser's exclusive remedy for breach of this warranty shall be a refund of the price paid for the products by the purchaser. Except as stated above, Royal Adhesives & Sealants, LLC, shall not be liable for any defect in, or breach of obligation relating to the defects in these products, regardless of the theory that may be asserted, including, without limitation, negligence, contract, absolute liability in tort or misrepresentation. If the purchaser does not accept goods on these terms, they are to be returned at once, unopened.