



H.B. Fuller



ROYAL
ADHESIVES & SEALANTS

Silaprene®

ISO 9001:2000 2/14/05

TECHNICAL SALES BULLETIN

SILAPRENE DC-11691/M6127 is a black, brushable, premium grade contact adhesive suitable for use as a general purpose bonding agent. This adhesive provides tough durable bonds to many surfaces.

DESIGNED TO BOND:

1. Rubber to metal, glass and masonry.
2. Nonstructural metal-to-metal.
3. Natural and synthetic rubber and expanded products.
4. Most kinds of plastic, including ABS, styrene, epoxies.
5. Wood, fiberglass, ceramic and leather.
6. Not recommended for vinyl plasticized films or foams.

PHYSICAL CHARACTERISTICS:

1. Suitable for brush or roll coat application.
2. Excellent early strength, with 20 minutes open time.
3. High shear strength to most substrates.
4. Oil and gasoline resistant.
5. Excellent resistance to water and moisture.
6. Good building tack properties.
7. Superior heat resistance.
8. Shelf life: 1 year, when stored below 80° F in unopened container.

TYPICAL PROPERTIES: (Specification ranges available on request)

Base:	Polychloroprene rubber
Color:	Black
Solvent:	MEK, Toluene
Solids:	34%
Viscosity:	1300 cps, RVF Brookfield, #3 spindle, 20 rpm
Weight/Gal:	7.2 pounds
Spec. Gravity:	.915
Temp. Range:	-40°F to 275°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.

METHOD OF APPLICATION:

Stir thoroughly until product is a consistent color before using. Apply one coat of adhesive by brush or roll coat onto each surface to be bonded. Porous materials, such as fabric, foam or wood may require two coats of adhesive. 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 3 to 5 minutes, depending on ambient conditions and substrate coating weight. If the adhesive becomes too dry, it may be reactivated with a cloth dampened with Toluene or MEK. Join surfaces immediately after reactivation.

CLEANER AND THINNER:

Toluene.

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 source 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.
- 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 40 CFR 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.