



H.B. Fuller



ROYAL
ADHESIVES & SEALANTS

Silaprene

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TECHNICAL SALES BULLETIN

SILAPRENE

M6306 ADHESIVE

M6306 is a premium grade yellow colored Polychloroprene contact bond adhesive. This adhesive is highly versatile and will bond many kinds of materials together for high performance.

DESIGNED TO BOND:

1. Vinyl coated fabrics (fabric side only) like Naugahyde®.
2. Metal, wood, fiberglass, leather and fabrics.
3. Most expanded rubber, synthetic and latex foams.
4. Thermoplastics, such as ABS, styrene and polyolefins.
5. Thermoset plastics like phenolic, polyurethane, polyesters and epoxies.
6. Not recommended for vinyl films or foams.

PHYSICAL CHARACTERISTICS:

1. Suitable for brush, spray or roll coat application.
2. Very fast dry bonds can be made in as little as one minute with excellent early strength.
3. High strength bonds to most materials.
4. Open time for bonding longer than 30 minutes.
5. Non-staining for light colored vinyl coated fabrics.
6. Excellent for bonding trim and decorative laminates.
7. Shelf life, 1 year at temperature not to exceed 80°F in unopened containers.

TYPICAL PROPERTIES:

(Specification values available upon request)

Base:	Polychloroprene rubber
Color:	Yellow
Solids:	22%
Solvents:	Acetone, Textile Spirits, Toluene
Viscosity:	400 cps-RVF Brookfield, #2 spindle @ 10 RPM
Weight/Gallon:	6.9 pounds
Specific Gravity:	.82
Temperature Range:	-50°F to 250°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 another 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 1 to 3 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.

Spray application can be accomplished with a DeVilbiss JGA gun or a Binks #62 or similar equipment with suitable nozzles and air caps. Air pressures of 25-50 pounds and fluid pressures of 15-30 pounds are usually suitable. Thin with solvent to improve spray characteristics.

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 sources of heat or flame. Turn off or deactivate any electrical equipment or sources of ignition. Adequate ventilation is required to keep vapor concentration below the Threshold Limit Value.

- For professional or industrial use only.
- Read the container label and the Material 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.