

Silaprene®

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TECHNICAL SALES BULLETIN

SILAPRENE® M6230 ADHESIVE

SILAPRENE® M6230 is a dark brown, solvent-based, general purpose adhesive that forms a tough, flexible bond to many substrates. This product exhibits improved strength and high temperature properties when heated to cure it.

DESIGNED TO BOND:

1. PVC film, sheet and foam.
2. Acrylic, polyurethane, ABS and other thermoplastics.
3. Most thermoset plastics, such as DAR epoxy, and phenolics.
4. Metal, wood, ceramic, leather and concrete.
5. Nitrile, Neoprene and other elastomers.

PHYSICAL CHARACTERISTICS:

1. Brush or roll coat viscosity.
2. Highly resistant to oils, fuels and water.
3. Resistant to plasticizer migration from vinyl films.
4. Good early strength with high ultimate strength.
5. Excellent heat resistance and high temperature strength when cured at 300°F for 10 minutes.
6. Retains flexibility at low temperatures.
7. Pre-coated parts can be solvent reactivated.
8. Shelf life. 6 months at temperatures not to exceed 80°F

TYPICAL PROPERTIES:

(Specification ranges available on request.)

Base:	Nitrile rubber
Color:	Dark brown
Solvent:	Acetone
Solids:	30%
Viscosity:	1000 cps, RVF Brookfield, #2 spindle @ 10 rpm
Weight/Gallon:	7.2 pounds
Specific Gravity:	.86
Temperature:	-35°F to 350°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 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 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 acetone or MEK. Join surfaces immediately after reactivation.

Parts may be coated with adhesive well in advance of assembly operations. Fully dried coated parts will not bond to each other until reactivated by heat or solvent.

CLEANER AND THINNER:

Acetone or MEK.

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 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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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.