

CHEMITAC 80DG

DESCRIPTION

Chemitac 80DG is a thermoreactive adhesive used with Chemitac 11 primer for bonding NR, SBR, BR, CR, NBR, HNBR, IIR, CIIR, BIIR, CSM and EPDM to rigid substrates. It can also be used as a one-coat adhesive for bonding KTL-treated substrates and textile fibers.

TYPICAL PROPERTIES

Appearance	Dark Gray liquid
Nonvolatile solids content (1h @ 105°C)	25-28%
Specific gravity @ 25°C	0.980-1.020 g/cm ³
Viscosity, Brookfield @ 25°C	200-300 cps - Spindle 2, 30 rpm
Viscosity, Ford Cup No.4 @ 25°C	40-100 s
Solvents	Xylene/Toluene
Bonding Temperature Range	130-200°C
Shelf life	1 year (unopened container below 25°C)
Dry film density	1.7 g/cm ³ (calculated)

CHEMICAL COMPOSITION

Polymers and fillers stabilized in aromatic solvents.

SUBSTRATE PREPARATION

Surface preparation comprises two steps:

1. **Cleaning** – Solvent degreasing or alkaline cleaning methods should be used to remove oils, greases and dirt. Cleaning solutions should be kept free from contamination and replaced when necessary.

2. **Surface treatment** – In order to achieve good adhesion results, the surface must be either mechanically or chemically treated before the application of the adhesive.
- Chemical treatment – Phosphatizing, anodizing and KTL coatings are the most commonly used methods.
 - Mechanical treatment – We recommend grit blasting the surface to a roughness (Rz) greater than 15 microns. Steel grit should be used for ferrous metals such as steel and iron; for other nonferrous metals, the use of aluminum oxide is recommended. Care should be taken to maintain grits clean. Blasting residues should be removed before the application of the adhesive. Layover time between blasting and adhesive application should be kept to a minimum in order to avoid oxidation.

ADHESIVE APPLICATION

Agitation – We recommend stirring Chemitac 80DG before the application to avoid settling.

Dilution – We recommend the dilution be always made with Xylene or Toluene. Dilution of the product depends upon the type of application.

- **Dip** – 20-50% v/v.
- **Brush/Roll** – 20-50% v/v.
- **Spray** – 50-100% v/v.

Application Layer – If Chemitac 80DG is being used as a one-coat adhesive, it is recommended a layer from 20 to 25 microns. If used as a covercoat adhesive, then the primer layer thickness should be 3-8 microns and the adhesive layer thickness should be 15- 25 microns.

Drying – Drying time is usually 30-45 minutes at room temperature. If it is necessary to reduce drying time, we recommend using circulating air at 70°C for 15 minutes maximum. These values are only an estimated guideline and can vary. Check the purity of drying air to avoid contamination. The adhesive film should be completely dry before the application of the covercoat adhesive and/or vulcanization.

The application layer and drying time values are to be used as reference. They may deviate based on processing conditions. For more details and guidance, please contact us at tech.support@chemitac.com.

Storage of coated parts – Coated parts can be stored for 30 days before vulcanization in a clean and moisture-free condition.

CAUTIONARY INFORMATION

Before using this product, please refer to the Safety Data Sheet for safe use and handling instructions.

STORAGE

Keep the container tightly closed and away from heat sources. Maximum temperature storage is 25°C.

ADDITIONAL INFORMATION

For more information on this and other products, please contact us:

tech.support@chemitac.com