

# CHEMITAC A400+H400

## DESCRIPTION

Chemitac A400 + Chemitac H400 is a cold-curing adhesive system designed for bonding rubber to rubber, rubber to fabric, rubber to rigid substrates such as steel, concrete, fiberglass and wood and fabric to fabric.

It can be used in lining installations, conveyor belt splicing and repair, playground surfacing, carpet and artificial grass bonding and to fix rubber lined vessels and tanks.

Chemitac A400 + Chemitac H400 system is a lead-free product.

## TYPICAL PROPERTIES

<b>Appearance</b>	Black
<b>Solvent</b>	Ethyl Acetate
<b>Application Temperature</b>	10-45°C
<b>Shelf life</b>	2 years (unopened container below 25°C)

## CHEMICAL COMPOSITION

Polymers and catalysts in solvents.

## MIXING INSTRUCTION

Chemitac A400+H400 system is comprised of a cement and a hardener in the ratio of 700 grams of Chemitac A400 (cement) to 30 grams of Chemitac H400 (hardener). These two components must be thoroughly stirred and used within 2-3 hours.

## SUBSTRATE PREPARATION

For best bonding results, the substrate temperature must be 10-45°C and 5 degrees higher than the dew point. The relative air humidity must be up to 80%.

**Steel** – Use solvent degreasing methods to remove oils, greases and dirt. Grit blast the surface to a roughness (Rz) greater than 25 microns. Blasting residues should be removed before the application of the adhesive. Apply Chemitac 11 primer to the surface and allow it to dry completely.

**Fiberglass** – The surface should be cleaned and abrasive blasted. All blasting residues should be removed and if a solvent is used, allow it to dry completely before the adhesive application.

**Rubber** – The surface should be cleaned with a solvent to remove all mold releases and rubber dust.

**Concrete and Wood** – We recommend abrasive blasting the surface for best adhesion results. Concrete surface may be acid etched whenever blasting is not an option.

**Fabric** – The fiber should be clean and dry before the adhesive application.

## ADHESIVE APPLICATION AND BONDING

A two-coat adhesive layer should be applied to both surfaces. Make sure to apply the adhesive uniformly and fill in all surface voids using a cement brush. The first coat should dry completely for at least one hour. The second coat or “tack coat” should be applied simultaneously to both surfaces and dry to a tack. Tack coat should be reapplied if the surface becomes too dry. Bond the surfaces together applying pressure and making sure to eliminate all air.

## 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:

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