

KA&MELOCK KM 25

Elastomer Bonding Agent

DESCRIPTION

KA&MELOCK KM 25 is an elastomer bonding agent suitable for top coat use. It should be used in combination with KA&MELOCK MP 05 primer when high temperature corrosion resistance and dynamic resistance are required for bonding various elastomers to metal and plastic surfaces during the vulcanization process. It is composed of a mixture of dispersed polymers, cross-linking agent and suspended solids in an organic solvent system.

KA&MELOCK KM 25, Natural rubber (NR), Polyisoprene (IR), Polybutadiene (BR), Styrene butadiene (SBR), Nitrile (NBR), Chloroprene (CR), Butyl (IIR), Polychloroprene (CR), Chlorosulfonated Polyethylene (CSM) and Ethylene Propylene (EPDM) based rubber compound adheres to a wide range of metals and plastics during vulcanization process.

PREPARATION STAGES OF METAL SURFACES BEFORE APPLICATION

The metal surface must be completely cleaned before applying the adhesive. A good preparation of the metal surface is required to obtain a good metal/rubber bond and to be resistant to water and corrosion. The oxide layers on the metal surface should be mechanically cleaned. Remove rust, scale or oxide coatings by suitable chemical or mechanical cleaning methods.

- Mechanical Cleaning:

Grit blasting is a recommended method of metal cleaning. Steel grit is used to blast clean steel, cast iron; for other nonferrous metals, the use of aluminum oxide is recommended. Layover time between blasting and adhesive application should be kept to a minimum in order to avoid oxidation.

- Chemical Cleaning:

The process of chemically preparing the metal surface requires a different application for each metal group. Phosphating is a widely used chemical process for steel. The process applied under the paint in the aluminum surface coating process is called chromate.

APPLICATION

Mixing – KA&MELOCK KM 25 should be stirred thoroughly before use and during using to keep dispersed solids uniformly suspended.

Applying - Brush, roller, dipping or spraying methods can be applied for KA&MELOCK KM 25.

Experience has shown the following thickness of Primer and Bonding Agent provide the best result:

Primer	approx. 8 µm - 10 µm
Bonding Agent	approx. 15 µm - 20 µm

Drying- The bond coating can be dried at least 30 minutes at room temperatures. By using hot air drying up to 90 °C.; the time can be shortened. Metal parts with the Primer or Bonding Agent can be stored for several days in a clean environment.

Clean Up- Use xylene or toluene for clean-up.

TECHNICAL DATA*

Colour	Black – Green Liquid
Viscosity 4 mm DIN-Cup	80 – 120 s
Viscosity,cps@25°C(77°F) Brookfield SNB1 Spindle 2, 30 rpm	200-800 mPas
Specific Gravity	0,98 – 1,02 g/cm ³
Solid Content	22 – 27 % by weight
Solvents	Xylene

*Data is typical and not to be used for specification purposes.

CAUTIONARY INFORMATION

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

SHELF LIFE / STORAGE

Keep the container tightly closed and away from heat sources. Maximum temperature storage is 25°C. Shelf life is one year from date of manufacture when stored below 25 °C, unopened container.

ADDITIONAL INFORMATION

For more information on this and other products, please contact us: info@wbkim.com.tr

The above information and recommendations contained are based on our knowledge and experience. Beyond our control due to different materials and conditions of application for our products, processes and applications will be used when appropriate in order to make sure that we strongly advise that adequate testing is performed.