

## KA&MELOCK MP 42

### Elastomer Bonding Agent

#### DESCRIPTION

**KA&MELOCK MP 42** is a specialty binder for bonding nitrile rubber (NBR) to metals and other rigid substrates.

It is used as a single-layer binder. The binding takes place during the vulcanization. Composite parts bonded with **KA&MELOCK MP 42** perform well resistance to water and many technical oils.

#### 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. The metal surface is basically prepared by two 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 preparing the metal surface chemically 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 MP 42 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 MP 42.

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|-------------------------|--|
| • Brushing/Roll Coating | Apply full strength.                           |
| • Dipping               | Undiluted or 20 % dilution with MIBK or MEK    |
| • Spraying              | Dilute primer with up to 40-60% of MIBK or MEK |

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

Apply for the recommended dry film thickness of 3 - 15  $\mu$  on sandblasted surfaces and approximately 5  $\mu$  on phosphated surfaces:

**Drying-** The bond coating can be dried at least 30 minutes at room temperatures. By using hot air drying up to 70 °C.; the time can be shortened. When dry, KA&MELOCK MP 42 forms a grey film on the metal part, providing excellent corrosion protection.

Metal parts properly primed with KA&MELOCK MP 42 can be stored for several weeks in a clean environment.

**Clean Up-** Use MIBK or MEK for clean-up.

#### TECHNICAL DATA\*

Colour	Grey Liquid
Viscosity 4 mm DIN-Cup	16—22 s
Viscosity,cps@25°C(77°F) Brookfield SNB1 Spindle 2, 30 rpm	50-300 mPas
Specific Gravity	0,90 – 0,94 g/cm <sup>3</sup>
Solid Content	23 - 26 % by weight
Solvents	Methyl Isobutyl Ketone (MIBK), MEK

\*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 9 months 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](mailto: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.