



PROCEDURE FOR BONDING NATURAL RUBBER TO STEEL SUBSTRATE

PRODUCT SPECIFICATIONS

Product Name:

SOLUFIX 30A/B	Two Component Etcher
SOLUFIX 14T/B	Two Component Adhesive
MP2100	Single Component Metal Primer

INSTRUCTIONS FOR USE

Surface Preparation:

Abrasive blast clean to AS 1627.4 Class 2½, using clean abrasive grit to provide a profile of 40-60µm.

Apply 1 coat of MP2100 to all metal surfaces, allow to dry.

If rubber doesn't have a pre cured bonding layer it must be abraded with a 24 grit sanding disc, to create a profile for the adhesive to bond to. Clean surface of buffed rubber until no further trace of dirt or grit is evident. Each wipe should be used once only and in a single pass so that surface contaminants are not returned to cleaned surface.

Application:

Thoroughly mix and stir Solufix 14A and 14B hardener in a ratio of **10:1** by weight (eg 100gm 14A to 10gm 14B) Apply an even first coat to both surfaces with a brush and allow to dry completely (approximately 30 minutes to one hour). Apply a thin second coat and allow to dry until slightly tacky.

Bonding:

Carefully line up both surfaces and then place together starting at the middle first and working outwards. As the adhesive will form a strong bond on contact, extreme care must be taken to ensure proper alignment. Use a stitcher or roller to apply pressure to the joint, again working from the middle outward to remove possible air bubbles. Lightly clamp surfaces together and constrain to prevent any slippage during curing.