KA&MELOCK KM 36W

One-Coat Bonding Agent

DESCRIPTION

This product is a one-coat Bonding Agent for bonding Acrylic Rubber (ACM), Ethylene Acrylic Rubber (AEM "VAMAC"), Epichlorohydrin Rubber (ECO), Hydrogenated Nitrile Rubber (HNBR) and Nitrile Rubber (NBR) to Metal.

The bonding between metal and rubber occurs during the vulcanization process. The metal parts will be treaded chemically or mechanically. After coated with KA&MELOCK KM 36 W and drying the film, the bonding between rubber compounds and coated parts developed in the press during the vulcanization.

KA&MELOCK KM 36 W used for production of sealing parts.

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.

APPLICATION

Mixing – KA&MELOCK KM 36W 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 36W

• Brushing/Roll Coating	Apply full strength.
• Dipping	Undiluted or 20 % dilution with MEK
• Spraying	40-60% dilution with MEK

For the recommended coating thickness of approximately 15 µm.

Drying- Vulcanizing temperatures of 140 °C – 200 °C are preferable.For post-curing of parts, temperatures up to 220° C are acceptable, without any negative effect on bonding properties. The bond offers excellent temperature resistance.
When dry, KA&MELOCK KM 36 bonding agent forms a solid, dry, brown film. Coated components can be stored for up to 3 months before bonding without adversely affecting the bond performance. Coated components should be protected from dust, moisture during storage.

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

TECHNICAL DATA*

Colour	**Brown Liquid**
Viscosity 4 mm DIN-Cup	**9 – 13 s**
Viscosity,cps@25°C(77°F) Brookfield SNB1 Spindle 2, 30 rpm	50 - 120 mPas
Density	**0,96 – 0,98 g/cm³**
Solid Content	**20 - 26 % by weight**
Solvents	**Methyl Ethyl Ketone (MEK), Ethanol**

*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 25ºC. Shelf life is one year from date of manufacture when stored below 25 °C, unopened container. Remove only as much KA&MELOCK KM 36 W from the original drum as will be consumed during the next shift. Under no circumstances must unused material be returned to the original container!!! Generally, vulcanizing conditions (temperature, pressure, duration) recommended by the rubber supplier should be adhered to.

ADDITIONAL INFORMATION

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