



ENDURABOND Intermediate I-100

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FUNCTION: Endurabond Intermediate I-100 is a covercoat adhesive for bonding synthetic elastomers such as, EPDM, butyl, neoprene, nitrile and hypalon compounds to Endurabond Primer P-100 primed metal during vulcanization and functions as a splice cement for bonding cured and uncured rubber compounds to themselves and other elastomers.

TYPICAL PHYSICAL PROPERTIES:	Color.....	Black
	Wt./Gal.....	9.0 lbs.
	Specific Gravity.....	0.92
	Viscosity (#3 Zahn Cup)@ 25 C.....	30 sec.
	Viscosity-Brookfield, #1 10 rpm.....	450 CPS
	Non-Volatile Solids.....	25%
	Shelf Life at 75° F (unopened can).....	1 yr from DOS
	Flash Point.....	83° F
	Bond Temperature Range.....	150-232° F
Coverage-Sq. Ft./Gal./Coat.....	Approx. 225-275	

DIRECTIONS FOR USE: May be applied by brushing, rolling or spraying. Dry film thickness should be between .8 – 1.5 mil (12-25 microns.). Lay over time is one month if kept free of contamination.

Must be applied to Endurabond Primer P-100 primed metal. After applying adhesives, dry for 20-30 minutes at room temperature. Must be thoroughly agitated before use, preferably with a high speed, propeller-type agitator. Stir while adding solvents.

For spraying dilute with toluene to a viscosity of 23-36 seconds, using a # 2 Zahn cup. This dilution sprays well at 50 psi automation pressure and 10 psi pot pressure, using a DeVilbiss FX fluid tip and a DeVilbiss 777, 78 or 704 air cap, or equivalent. If webbing occurs, replace the toluene with xylene. Add diluent slowly while mixing or polymer base will precipitate out.

TOXICITY: Prolonged breathing of vapors is harmful. Use only with adequate ventilation. Repeated contact may cause irritation. See MSDS for further instructions.

SAFETY: Usual fire safety measures should be observed. Keep away from heat, sparks and open flames.

NOTE: Specification writers: Please contact Quality Control Manager, Blair Rubber Company, before writing specifications on above product.