



ENDURABOND Tack #3

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FUNCTION: Endurabond Tack #3 is a black tacky tie cement to be used over Endurabond Primer #1 and Intermediate #2 when bonding natural rubber to a substrate. Tack #3 provides a tenacious green strength and is particularly good in sharp radius areas such as flanges. Its low temperature activation makes it suitable for use with autoclave, open steam and chemical cure systems.

TYPICAL PHYSICAL PROPERTIES:	Color.....	Black
	Wt./Gal.....	7.4 lbs.
	Specific Gravity.....	0.87
	Viscosity (#4 Zahn Cup).....	55 sec.
	Non-Volatile Solids.....	14%
	Shelf Life at 75° F(unopened can).....	3 m. from DOS
	Flash Point.....	40° F
	Bond Temperature Range.....	180-330° F
Coverage-Sq.Ft./Gal./Coat.....	Approx. 200-250	

DIRECTIONS FOR USE: May be applied by brushing or rolling. Long nap rollers should be avoided. Dry film thickness should be approximately 0.5 mil. Tack #3 should be applied just prior to lay-up. The adhesive should be dry to the touch.

Do Not leave exposed to direct sunlight. Primer should be agitated thoroughly before use. Toluene may be used for reducing viscosity, if necessary. Layover time is approximately 3 days.

TOXICITY: Prolonged breathing of vapors is harmful. Use only with adequate ventilation and an approved respirator. See MSDS for further instructions.

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