



ENDURABOND XWNI Tack Cement

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FUNCTION: Endurabond XWNI is a solvent based nitrile tack cement for bonding nitrile rubber compounds.

Endurabond XWNI is suitable for pressure and open steam curing.

TYPICAL PHYSICAL PROPERTIES:	Color.....	White
	Wt./Gal.....	7.38 lbs.
	Specific Gravity, Solids.....	1.38
	Viscosity - #3 Zahn Cup.....	90-120 sec.
	Non-Volatile Solids.....	24-34%
	Shelf Life @ 75° F.....	3 mo. from DOS
	Bond Temperature Range.....	180-350° F
Coverage-Sq.Ft./Gal./Coat.....	Approx..150-200	

DIRECTIONS FOR USE: May be applied by brush or suitable roller Endurabond XWNI should be agitated thoroughly before use. If tack cement becomes too viscous, it is recommended the adhesive be thinned with 10-15% MIBK and mixed thoroughly before using.

Prior to use, the Cure Pack provided should be thoroughly mixed with the cement at the rate of 1 pkt (2.5 g)/ qt. of cement. More complete mixing is ensured if the cure pack is first slurried in approx. 20 ml of MEK and then stirred into the cement. The resulting mixture will have a shelf life at R.T. of about two weeks.

Endurabond XWNI tack cement should only be applied to non-contaminated surfaces and properly prepared substrates.

To increase the tack of the adhesive blend 20% by volume of 202 Tack to the XWNI Tack. For example add 1 gallon of 202 Tack to every 4 gallons of XWNI Tack.

Based on normal humidity and room temperature conditions, Endurabond XWNI should dry 15-30 minutes before rubber application.

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.



Section 5: ENDURABOND Cement Specification

Date: February 26, 2006