

C5004 – Technical Data Sheet



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Description

C5004 is a two-component, solvent-based adhesive formulated on polychloroprene rubber. It is used as a two-component, high-performance adhesive system for a wide range of industrial applications.

C5004 will bond natural, polychloroprene, butyl, nitrile and polyurethane rubber materials and also rigid PVC, wood and leather. It is particularly suitable for the fabrication of inflatable products such as boats, wet/dry suits, marine fenders and is also ideal for use in bonding rubber linings in storage tanks.

C5004 is not suitable for PVC.

C5004 offers many benefits:

- Exhibits high-strength bonds between a wide range of materials, including all types of rubbers.
- Excellent resistance to heat, saltwater and humidity.
- Easy to mix, two-component system - supplied in kit-form with the requisite amount of curing agent.
- Easy to apply by brush, roller or serrated trowel.
- Contact bonds can be made within 10-15 minutes (full cure).
- Mixed adhesive has a pot life of 4-6 hours.

Physical Properties – Component A

Base	Polychloroprene
Appearance	Off-white
Solids content	19-23% approx.
Viscosity	1700-2300 cps (20°C)

Physical Properties – Component B

Base	Isocyanate solution (MDI)
Appearance	Brown (translucent)
Solids content	18-22% approx.
Viscosity	Low (20°C)

Physical Properties – Mixed Adhesive

Cleaner	C1013
Shelf-Life	6 months (25°C)
Temperature Resistance	-40°C to +110°C

Directions for Use

1. Ensure that the surfaces to be bonded are clean and grease-free by abrading them with clean emery cloth, or by using **C1020** to remove surface contamination.
2. Mix together thoroughly, for approximately 5 minutes, **C5004** Component A, preferably in the proportions as supplied, or by taking (by weight) 100:6 ratio (A:B).
3. Apply an even coat of the mixed adhesive to both mating surfaces, either by brush or serrated trowel.
4. Allow the adhesive coats to dry for 5-15 minutes or until they can just be touched with the knuckles without any adhesive being transferred. Note: Two thin coats are preferable for maximum adhesion. The first coat should be allowed to dry for approximately 20-30 minutes before applying the final coat and allowing this to dry for 5-15 minutes.
5. Join the surfaces, taking care not to trap any air, using as much pressure as possible. Components may be handled within minutes of being bonded.

Coverage:

Approximately 4m² per litre but can vary with material being bonded (2m² bonded area).

Cure-time:

48 hours under normal ambient temperature conditions but the strength of the adhesive bond continues to increase, reaching its maximum within 6 days. Cure-rate may be accelerated by heating, e.g. 2 hours at approximately 70°C.

NB: The product should be stored unopened in a dry condition at a temperature of 5-25°C. This will ensure the stated shelf-life. The adhesive will have a limited life once the container is opened.

Please consult the C5004 Health & Safety Data Sheet for statutory regulation information.

Information relating to the products of Bondrite Adhesive Limited is based on tests carried out under laboratory conditions. If any of our products are not used in accordance with our instructions or are used under conditions which vary from our laboratory, they may not perform in accordance with any information provided and Bondrite shall not have any liability in this case. Bondrite will accordingly provide samples of our products, on request and free of charge, for Customers to carry out their own tests as to suitability of our product for their purposes and as used in their intended environment.

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