

## APPLICATION CONDITIONS

All surfaces are protected from direct sunlight, completely dry and free from contamination. Ambient and surface temperature should be similar and between 7°C and 45°C (45°F to 113°F). Warming surfaces and surrounding air is a good option when working in colder temperatures. Relative humidity should be below 80% and dew point is maintained 3°C (5°F) above substrate temperature for the duration of the application.

# NA-900 SERIES COLD BOND CEMENT

## RUBBER TO METAL APPLICATION

- 1. Metal** - Remove all weld splatter, weld seams, sharp edges, and irregularities by surface grinding. Grit blast using SSPC-SPI10 specifications near white including a minimum anchor depth profile of 50 microns (.002"). Be aware using other forms of surface preparations will reduce adhesion strength.
2. Use dry clean compressed air, broom, or a vacuum to remove any dust or debris from the grit-blasting process. Use NR-TR or a non oil-based solvent to remove dirt and oil contamination that may occur.
3. Immediately after cleaning, apply one even coat of NP-5001 metal primer to the prepared surface to ensure bond strength while protecting the surface from oxidation. Primed metal can be stored for up to 7 days if kept cool, dry, and away from UV exposure. Cover to maintain cleanliness.
- 4. Rubber** - If the rubber sheeting has a bonding layer you have the option to move directly to the cement application. If not, prepare the bonding side of the rubber by first wiping entirely to remove contaminants with NR-TR or a non-oil-based solvent, then roughen to remove all shiny spots using a slow speed grinder with 24 to 36 aluminum oxide sanding disk or stiff wire wheel (< 2000rpm). Avoid tools with high speed rotation as this will result in burning and charring the rubber, negatively affecting adhesion.
5. Use dry clean compressed air, broom, or a vacuum to remove any dust or debris from this process. Use NR-TR or a non oil-based solvent to remove dirt and oil contamination that may occur.
6. Mix by stirring ONLY (not shaking) the appropriate amount of 900 Cement and Hardener for one minute, then begin your 1st coat (dry coat) to both substrates with a cement brush using a scrubbing motion to ensure all areas are filled and covered evenly while avoiding runs and puddles. Allow this 1st coat to dry completely for a minimum of one hour (overnight is ideal) before moving to the 2nd coat (tack coat).
7. Apply the second coat (tack-coat) of 900 Cement to both surfaces at the same time to ensure drying times are equal. Apply evenly, similar to painting using a brush or roller WITHOUT using a scrubbing motion. At the optimum joining time, the cement feels tacky to the touch but does not transfer to the back of the hand when testing. If the tack coat becomes too dry, re-cement both surfaces and wait for the tack stage.
8. Once the materials are placed together and positioned, and depending on material thickness, stitch vigorously using a mall flat roller, rubber mallet, and or pneumatic hammer tool to apply pressure and ensure maximum surface contact. Make overlapping passes, working out towards the edges while removing any trapped air. Excess material can be trimmed using a sharp knife.
9. See our complete Cold Bond Cement application guide for more detailed information.



**Normac Adhesive Products Inc.**  
1350 Heine Court, Burlington ON  
Canada L7L 6M4  
Tel. 1.905.332.6455  
info@normacadhesives.com

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