



NP-8400 RUBBER PRIMER

NORMAC NP-8400 is a single-component polymer-based primer for bonding Polyurethane to Rubber. May also be used to bond Polyurethanes together. Expect excellent bond strength in under two hours for standard conveyor belt rubber.



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The directions for the use of our products are based upon tests believed to be reliable but no warranty is given. Since conditions for the use of this product are beyond the sellers control, all risks are assumed by the user. Please contact your local agent or call Normac Adhesive Products Inc. for further assistance.

COVERAGE:

Theoretical coverage: 8.54 sqm @ 25 micron/kg (41.66 sqft/lb @ .001")

Recommended DFT: 25 micron (.001")

Solids content: 25%

MIXING INSTRUCTIONS:

Single component

Shake well before use

Mixed Appearance: Amber clear

Dilution: Not required

APPLICATION CONDITIONS:

Ambient and surface temperature should be similar and between 7°C to 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 85% and dew point is maintained 3°C (37°F) above substrate temperature for the duration of the application. Always protect the area from contaminants and direct sunlight.

APPLICATION INSTRUCTIONS (23°C / 73°F):

Apply one liberal coat by brush, roller, or spray after proper elastomer surface preparation which includes cleaning and mechanical roughening. Prepare the rubber by first wiping entirely to remove with NR-TR buffer. Then roughen to remove all shiny spots using a slow speed grinder or wire wheel (under 2000 rpm). Avoid tools with high speed rotation as this will result in burning and charring the rubber, negatively affecting adhesion.

Working Time: Continuous, keep can covered.

Dry Times: 10 - 20 min

DFT: 25 micron (.001")

Recoat Time: 30 min

Clean up: Non oil based solvent such as Ethyl Acetate

TECHNICAL DATA:

Transportation: DGR

Storage: Under 27°C (80°F) away from heat, sparks, and open flame.

Shelf life: 2 years, unopened

Viscosity: 35 cps

Flash Point: -4°C (24.8°F)

VOC content: 714 g/l

AVAILABLE KIT SIZES:

115 g, 230 g, 450 g. Others on request.

SAFETY:

Flammable liquid. See the NORMAC NP-8400 product SDS. Strict adherence to regional safety regulations must be practiced.