



## TECHNICAL DATA SHEET

### CHEMITAC 25

#### DESCRIPTION:

Chemitac 25 is a termorreactive adhesive used with a primer Chemitac 9 or Chemitac 11, for bonding elastomers as NR, SBR, BR, CR, NBR, HNBR, IIR, CIIR, BIIR, CSM and EPDM with steel, aluminum, aramid, textile fibers and glass by vulcanization process.

In bonding applications for textile fibers with pretreatment RFL (Resorcinol, Formaldehyde and Latex), Chemitac 25 is applied without primer.

The textile fibers can be:

- Cotton, cellulose, polyamide, polyester and aramid.

Chemitac 25 is a heavy metals free product.

#### TYPICAL PHYSICAL CHARACTERISTICS:

Appearance	:	Bright black liquid.
Non-volatile solides (1h @ 135°C)	:	27,00%
Specific gravity at 25°C	:	1,009 g/cm <sup>3</sup>
Viscosity Brookfield at 25°C	:	300 cps - #2 spindle @ 30 rpm.
Viscosity Ford Cup # 4 at 25°C	:	210 s.
Diluents	:	Xylene / Toluene
Bonding Temperature Range	:	130 to 200°C
Shelf life	:	1 year (closed can below 25°C).

#### CHEMICAL COMPOSITION:

Polymers and fillers stabilized in aromatic solvents.

#### HOW TO PREPARE THE SURFACE:

##### METALS AND RIGID SUBSTRATES:

Prepare the metal surface properly by removing completely oil, grease and dirt.

Blasting the surface with grit blasting steel so that the surface roughness is greater than 15 µm.

For aluminum surfaces we recommend the use of aluminum oxide as abrasive.

Clean again the substrate to remove dust from blasting residues.

If specified, the metal part can be phosphatized, galvanized, chromate conversion treated or KTL, before applying adhesive.



## TEXTILE FIBERS

In application with textile fibers treated with RFL, Chemitac 25 is applied directly to the fiber.

When the natural fibers are without treatment with RFL, the application of Chemitac 50 or Chemitac 94 is recommended before Chemitac 25.

## HOW TO APPLY CHEMITAC:

**Agitation:** We recommend stir Chemitac 25 before the application to avoid settle down.

**Dilution:** Dilution of the product depends on the applications methods.  
We recommend that dilution is always made with Xylene or Toluene.

**Dipping:** For this application we recommend diluting between 20 e 50% v/v.

**Brushing:** For this application we recommend diluting between 20 e 50% v/v.

**Spray:** For this application we recommend diluting between 50 and 100% v/v.

**Application Layer:** In applications with rigid substrate apply primer Chemitac 9 or Chemitac 11 prior to the Chemitac 25 adhesive.

The primer layer thickness of the must be between 3 and 8  $\mu\text{m}$ .

After drying the primer, apply Chemitac 25 where its layer thickness must be between 15 and 25  $\mu\text{m}$ .

In applications where Chemitac 25 will be used as mono component, the layer thickness must be between 20 and 25  $\mu\text{m}$ .

Parts with Chemitac 25 already applied can be stored for 60 days before vulcanization if stored in a dust and moisture free condition.

**Drying:** Dry film between 10 and 30 minutes at room temperature. If it is necessary to reduce drying time, we recommend to use forced air for 2 minutes at 65°C maximum. Do not use in this stage of process temperatures above 82°C to avoid adhesive pre-cure.

After this process, follow to vulcanization.

## TOXICITY:

Breathing vapors for a prolonged period of time is harmful to health.

Use Chemitac 25 only with facial breathing mask, gloves, protection glass and appropriate ventilation.

Continuous contact with the skin may cause irritation.

Adhesive Chemitac 25 may be fatal if swallowed.

If swallowed, do not induce vomiting, but call a physician.



## STORAGE:

Keep container tightly closed during storage and always keep away from heat sources. Store in an environment below 10°C increases the shelf life of the adhesive.

## PACKING AND STACKING CONDITIONS:

Packing types as well as the recommended maximum amounts for stacking depends on the production place of the product like below:

Place	Can/sample	Can 5.0 L	Bucket 10.0 L	Bucket 30.0 L	Drum 200.0 L
Europe	0,40 Kg / 6 units	4 Kg / 6 units	8 Kg / 6 units	27 Kg / 3 units	190 Kg / 3 units

Place	Can	Gallon	Bucket 25 L.	Drum 200 L
Brasil	-.-	-.-	-.-	-.-

## SAFETY INFORMATIONS:

Consult the product MSDS for safety information.

## ADDITIONAL INFORMATION:

For more information on this and other products, please visit our Website:

[www.chemitac.com](http://www.chemitac.com)