



MEGUM™ W-7025

Description MEGUM™ W-7025 is a waterborne-based seal adhesive for bonding NBR, HNBR, and XNBR compounds.

Benefits & Features There is no chlorinated polymers in the make up of this bonding system giving the optimum corrosion resistance.

Uncured Properties	Nominal Value	Unit	Test Method
Color	Grey		
Solids Content			
-- 1	21	%	
-- 2	26 to 30	%	ASTM D2369
Density	1.05 to 1.10	g/cm ³	ASTM D1475
Dry Film Density	0.98	g/cm ³	
VOC Content	2.20	lb/gal	
Viscosity ³ (25°C, Brookfield RVT)	0.050 to 0.35	Pa-s	ASTM D1084
Viscosity (25°C)	20 to 72	sec	Zahn Cup 2
Theoretical Coverage ⁴	18.6	m ² /l	
Recommended Film Thickness	5.1	µm	
Recommended Film Thickness Range	2.5 to 15	µm	
Shelf Life ⁵ (25°C)	12	month	

Elastomer

NBR, HNBR, AEM, ACM rubber compounds.

Substrate

CRS, Phosphate pre-treated CRS, Aluminum, Stainless Steel, etc.

Surface Prep

Review Dow 's rubber-to-substrate bonding agent application guide or contact your account manager.

Mix Instructions

Diluents: Deionized or distilled water

Thoroughly stir ROBOND™ TR-7021-D before using to assure the ingredients are uniformly distributed. Do not stir the adhesive so vigorously that air is beaten in. This will cause the adhesive to foam and make it difficult to apply. Measure the specific gravity using a Hydrometer or other instrument to assure the adhesive is properly mixed. When needed, a mixture of at least four parts diluent to one part ammonium hydroxide should be used to adjust the pH.

Continue to mix ROBOND™ TR-7021-D while spraying to keep the dispersed solids from settling to the bottom. This will assure that a homogenous mixture of the adhesive is applied.

Application Technique

Can be applied by brushing, dipping or spraying.

Brushing: apply without dilution.

Spraying: use undiluted.

Dipping: dilute 1 part product with up to 3 parts diluent for tumble dip applications.

Drying the Film

Product should be applied onto the metal inserts which have been heated to 48°C (120°F), then immediately force dried for 3 to 5 minutes at 82°C (180°F), or dry 10 minutes at 65°C (150°F). Do not dry at temperatures above 121°C (250°F).

Molding and Curing

Can be used with all common molding and curing methods. Cure temperatures between 100°C and 205°C (250 and 400°F) are recommended.

Dry Film Stability

Excellent dry film stability. Inserts coated with product can be stored for several weeks if protected from contaminants.

Clean-up

Equipment clean up should be done using recommended dilution solvents.

Packaging/Sizes Available

Drums, pails and cans.

Storage & Stability

The shelf life of this material is assured for 6 months (from the date of manufacture) at temperatures below 78°F in an unopened container.

Toxicity and Safety Information

Read the Safety Data Sheet before using this material. Toxicity and safety information is included in the SDS.

Food Contact Applications

Dow Automotive products are not approved for direct or indirect food contact or drinking water applications. If your applications include food contact or drinking water requirements, please contact your Dow representative. For more information on the regulatory status of this product, please refer to the SDS for this product.

Notes

These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.

¹ By volume

² Non-volatile solids by weight

³ Spindle #2, @ 100 RPM

⁴ Applied at a dry film thickness of 0.4 mil

⁵ Unopened

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Published: 2015-05-15

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