



ROBOND™ TR-7115

Description ROBOND™ TR-7115 is a high-performance waterborne one-coat adhesive for bonding peroxide-cured HNBR and EPDM to metal.

Benefits & Features Excellent bonding system for peroxide cured HNBR, EPDM and blends for sealing applications. Onset of cure is delay to allow for pre-bake of metal inserts.

Uncured Properties	Nominal Value	Unit	Test Method
Color	Grey, Primer		
Solids Content			
-- 1	29	%	
-- 2	28 to 33	%	ASTM D2369
Density	1.04 to 1.08	g/cm ³	ASTM D1475
Dry Film Density	1.1	g/cm ³	
VOC Content	1.20	lb/gal	
Viscosity ³ (25°C, Brookfield RVT)	0.040 to 0.085	Pa·s	ASTM D1084
Viscosity (25°C)	19 to 26	sec	Zahn Cup 2
Theoretical Coverage ⁴	39.1	m ² /l	
Recommended Film Thickness	5.1	µm	
Recommended Film Thickness Range	2.5 to 15	µm	
Shelf Life ⁵ (25°C)	6	month	

Elastomer

HNBR, EPDM Seal 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

Stir ROBOND™ TR-7115 before using to assure that the ingredients are uniformly distributed. Do not stir the adhesive so vigorously that air beaten in. This will cause the adhesive to foam and make it difficult to apply.

Continue to mix ROBOND™ TR-7115 while spraying or dipping 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 0.2 mil

⁵ Unopened

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Additional Information

North America		Europe/Middle East	+800-3694-6367
U.S. & Canada:	1-800-441-4369		+31-11567-2626
	1-989-832-1426	Italy:	+800-783-825
Mexico:	+1-800-441-4369		
Latin America		South Africa	+800-99-5078
Argentina:	+54-11-4319-0100		
Brazil:	+55-11-5188-9000		
Colombia:	+57-1-219-6000	Asia Pacific	+800-7776-7776
Mexico:	+52-55-5201-4700		+603-7965-5392

www.dowautomotive.com

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