



MEGUM™ W-7100

Description High performance water-based single coat adhesive intended for bonding sulfur and peroxide cured NBR and HNBR and other rubber compounds in transportation seal applications.

Benefits & Features Durable adhesion to a variety of metal and rubber compounds, excellent environmental resistance, improved in-plant process and handling.

Uncured Properties	Nominal Value	Unit
Color ¹	Grey	
Solids Content ²	24 to 26	%
Dry Film Density	1.0 to 1.2	g/cm ³
VOC Content	< 1.25	lb/gal
Viscosity ³ (25°C, Brookfield RVT)	0.020 to 0.15	Pa·s
Shelf Life ⁴ (0°C)	> 6	month

Cured Properties	Nominal Value	Unit
Volume Expansion ⁵	17	%

Elastomer

NBR, HNBR, AEM, ACM rubber compounds.

Substrate

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

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 MEGUM™ W-7100 before using to assure that the ingredients are uniformly distributed. Do not stir the adhesive so vigorously as to entrain air. This will cause the adhesive to foam and make it difficult to apply. Continue to mix MEGUM™ W-7100 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

Dip Immersion, Spray and Brush applied

Molding and Curing

Minimum of 240°F to 420°F

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 24 months (from the date of manufacture) at temperatures below 78oF 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 Dark-Grey to Bluish Black

² 1 gram, 1 hr at 100°C

³ Brookfield Viscometer, RV #1 at 25°C, 100 rpms

⁴ >32°F and < 100°F

⁵ Calculated

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Published: 2016-10-05

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