



# THIXON™ 2001-EF

**Description** THIXON™ 2001-EF is a vulcanizing adhesive that can be used as a one-coat adhesive or as a two-coat system applied over THIXON™ P-11-EF or THIXON™ P-6-EF adhesive primers. Bonds a wide variety of elastomers, including natural rubber, SBR, chloroprene, EPDM, butyl and nitrile.

Formulated at the proper viscosity and solids content to give the desired dry film thickness for maximum bonding in one coat brushing or roller coat applications.

**Benefits & Features** Vulcanizing Adhesive that can be used as a one-coat adhesive or as a two-coat system applied over THIXON™ P-11-EF or P-6-EF adhesive primers. It represents the highest reactivity of any of the cover coat adhesives in our product line and is used to pick up difficult to bond rubber compounds. THIXON™ 2001-EF is formulated at the proper viscosity and solids content to give the desired dry film thickness for maximum bonding in one coat brushing or roller coat applications.

Uncured Properties	Nominal Value	Unit	Test Method
Color	Black		
Solids Content			
-- 1	15	%	
-- 2	22 to 26	%	ASTM D2369
Density	1.01	g/cm <sup>3</sup>	ASTM D1475
Dry Film Density	2.1	g/cm <sup>3</sup>	
VOC Content	6.20	lb/gal	
Flash Point	4.00	°C	DIN 53213
Viscosity <sup>3</sup> (25°C, Brookfield RVT)	0.30 to 1.8	Pa·s	ASTM D1084
Viscosity (25°C)	21 to 52	sec	Zahn Cup 4
Theoretical Coverage <sup>4</sup>	11.3	m <sup>2</sup> /l	
Recommended Film Thickness	21	µm	
Recommended Film Thickness Range	18 to 25	µm	
Shelf Life <sup>5</sup> (25°C)	12	month	

**Elastomer**

NR, IR, SBR, BR, EPDM, IIR, CR, NBR, etc.

**Substrate**

CRS, SS, Cu, Brass, Zn and Mg Alloys with a THIXON™, MEGUM™ or ROBOND™ Primer. This system can be used as a 1-coat bonding system since it has been formulated to be used with or without primer. Thorough component design and development efforts are required to assure proper fit and function.

**Surface Prep**

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

**Mix Instructions**

Diluents - Aromatic solvents, such as toluene or xylene

Product may appear thick or gelled when opened. May require heat or shear to reduce the viscosity for use. Typically, drum will need to be agitated for 8-16 hours prior to use and cans/pails will need to be place on a paint shaker 30-45 minutes prior to opening.

First, thoroughly mix THIXON™ 2001-EF with a high speed propeller-type agitator. If diluting, slowly add the diluents to the adhesive while mixing constantly.

**Application Technique**

Brushing: use undiluted. To obtain the required film thickness, brush on a heavy wet film without brushing excessively.

Dipping: use undiluted or dilute 7 parts product with 1 part diluent. For use as a covercoat over THIXON™ P-11-EF or THIXON™ P-6-EF adhesive primers, dilute 3 or 4 parts product with 1 part diluent.

Spraying: dilute two parts product with one part diluent to obtain a viscosity of 20 sec. #2 G.E. Zahn cup.

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**Drying the Film**

The drying time is approximately 30 minutes at 16°-27°C (60°-80°F). At lower temperatures, dry longer. The drying time can be shortened by force drying five minutes at 82°C (180°F). Do not dry at temperatures above 121°C (250°F).

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**Molding and Curing**

Can be used with all common molding and curing methods. Cure temperatures between 100°C and 193°C (212°F and 380°F) are recommended.

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**Pre-Bake Resistance**

Coated inserts can be pre-baked for up to 3 minutes at 160°C (320°F) without adversely affecting bond quality.

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**Dry Film Stability**

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

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**Clean-up**

Equipment clean up should be done using recommended dilution solvents.

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**Packaging/Sizes Available**

Drums, pails and cans.

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**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.

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<sup>1</sup> By volume

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<sup>2</sup> Non-volatile solids by weight

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<sup>3</sup> Spindle #4, @ 100 RPM

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<sup>4</sup> Applied at a dry film thickness of 0.6 mil

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<sup>5</sup> Unopened

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