



ROBOND™ TR-3010

Description ROBOND™ TR-3010 is a waterborne-based one-coat clear adhesive for bonding fluoroelastomers, Vamac® (AEM) , and Aflas® .

- 1 - Vamac is a trademark of DuPont DeNemours, Inc.
- 2 - Aflas is a trademark of the Minnesota Mining and Manufacturing Company

Benefits & Features Rubber to substrate bonding system with more aggressive cross-linking chemistry to give good environmental resistance in the finished good.

Uncured Properties	Nominal Value	Unit	Test Method
Color	Clear/Yellow Tint		
Solids Content			
-- 1	12	%	
-- 2	15 to 17	%	ASTM D2369
Density	0.983 to 1.02	g/cm ³	ASTM D1475
Dry Film Density	1.0	g/cm ³	
VOC Content	4.10	lb/gal	
Flash Point ³	52.0	°C	
Viscosity ⁴ (Brookfield RVT)	< 0.015	Pa·s	ASTM D1084
Theoretical Coverage ⁵	311	m ² /l	
Recommended Film Thickness	0.20	µm	
Recommended Film Thickness Range	0.10 to 0.30	µm	
Shelf Life ⁶ (25°C)	12	month	

Elastomer

FKM, AEM and Bisphenol and diamine cured FKM compounds and diamine cured AEM and ACM.

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 water

Dilute ROBOND™ TR-3010 with a ratio of 2 parts adhesive to 7 parts deionized water. When handling the product, do not generate excessive foam. This will cause turbidity (cloudiness) in the product.

Application Technique

Dipping: dilute 1 part product with 1 part diluent. Further dilution is possible to approximately 1 part product to 7 parts diluent. Determination of the optimum dilution is the responsibility of the user. The metal insert temperature should not exceed 37.7°C (100°F). Temperature of the adhesive solution should never exceed 29.4°C (85°F).

Spraying: dilute 1 part product with 1 part diluent. Preheat the metal inserts to 37.8 - 48.9°C (100 - 120°F) before spraying the adhesive, then force dry immediately after spraying for 5 to 10 minutes at 48.9 - 82.2°C (120 - 180°F) . Do not dry at temperatures above 121oC (250oF).

Drying the Film

The drying time is approximately 15 minutes at 82°C (180°F); 10 minutes at 100°C (212°F) or 5 minutes at 130°C (266°F).

Molding and Curing

Can be used with all common molding and curing methods. Cure temperatures between 150°C and 210°C (300°F and 410°F) are recommended.

Pre-Bake Resistance

Coated inserts can be pre-baked for up to 10 minutes at 160°C (320°F) without adversely affecting bond quality.

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 24 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 Seta Closed Cup

⁴ Spindle #2, @ 50 RPM

⁵ Applied at a dry film thickness of 0.04 mil

⁶ Unopened

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