



MEGUM™ W-2525

Description MEGUM™ W-2525 is a waterborne-based one-coat adhesive for bonding fluorocarbon (both peroxide and bisphenol/diamine cure systems), peroxide cured EPDM, VMQ and some peroxide cured AEM compounds to metals and other solid materials under vulcanization conditions.

Benefits & Features This rubber to substrate bonding system is particularly useful in bonding peroxide cured FKM, FFKM and base-resistant (BRE) FKM compounds.

Uncured Properties	Nominal Value	Unit	Test Method
Color	Clear/Yellow Tint		
Solids Content			
-- 1	10	%	
-- 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)	1.0E-3 to 3.0E-3	Pa·s	ASTM D1084
Theoretical Coverage ⁵	86.0	m ² /l	
Recommended Film Thickness	0.20	µm	
Recommended Film Thickness Range	0.10 to 0.30	µm	
Shelf Life ⁶ (25°C)	18	month	

Elastomer

FKM, FFKM, VMQ, BRE-FKM and some peroxide cured HNBR and EPDM.

Substrate

CRS, Phosphate pre-treated CRS, Aluminum alloys, Stainless Steel, copper alloys, and plastics like glass-filled polyamides, polyacetals and polyesters.

Surface Prep

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

Mix Instructions

Diluents - Deionized or distilled water

Do not stir the adhesive so vigorously that air is beaten in. This will cause foam and make the adhesive difficult to apply.

Application Technique

Dipping: dilute 1 part product with 1 part water (~3.5% theoretical solids). Further dilution is possible to about 1 part product with two parts water (~2.3% theoretical solids). 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 up to 8 parts deionized water. Dry immediately after spraying for 30 minutes at 20° - 25.5°C (68° - 78°F). Do not dry at temperatures above 121.1°C/250°F.

Drying the Film

Pre-heating the metal will prevent flash rust on steel substrates due to the acidic nature of MEGUM™ W2525. 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

Coat pre-heated (30C) 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 ULA Spindle, @ 100 RPM

⁵ Solution solids at 5.0%

⁶ Unopened

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