**MEGUM™ W-7025**

**Description**  
MEGUM™ W-7025 is a waterborne-based seal adhesive for bonding NBR, HNBR, and XNBR compounds.

**Benefits & Features**  
There is no chlorinated polymers in the make up of this bonding system giving the optimum corrosion resistance.

<table>
<thead>
<tr>
<th>Uncured Properties</th>
<th>Nominal Value</th>
<th>Unit</th>
<th>Test Method</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>Grey</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Solids Content</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>... 1</td>
<td>21</td>
<td>%</td>
<td></td>
</tr>
<tr>
<td>... 2</td>
<td>26 to 30</td>
<td>%</td>
<td>ASTM D2369</td>
</tr>
<tr>
<td>Density</td>
<td>1.05 to 1.10</td>
<td>g/cm³</td>
<td>ASTM D1475</td>
</tr>
<tr>
<td>Dry Film Density</td>
<td>0.98</td>
<td>g/cm³</td>
<td></td>
</tr>
<tr>
<td>VOC Content</td>
<td>2.20</td>
<td>lb/gal</td>
<td></td>
</tr>
<tr>
<td>Viscosity (25°C, Brookfield RVT)</td>
<td>0.050 to 0.35</td>
<td>Pa·s</td>
<td>ASTM D1084</td>
</tr>
<tr>
<td>Viscosity (25°C)</td>
<td>20 to 72</td>
<td>sec</td>
<td>Zahn Cup 2</td>
</tr>
<tr>
<td>Theoretical Coverage</td>
<td>18.6</td>
<td>m²/l</td>
<td></td>
</tr>
<tr>
<td>Recommended Film Thickness</td>
<td>5.1</td>
<td>µm</td>
<td></td>
</tr>
<tr>
<td>Recommended Film Thickness Range</td>
<td>2.5 to 15</td>
<td>µm</td>
<td></td>
</tr>
<tr>
<td>Shelf Life (25°C)</td>
<td>12</td>
<td>month</td>
<td></td>
</tr>
</tbody>
</table>

**Elastomer**  
NBR, HNBR, AEM, ACM rubber 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

Thoroughly stir ROBOND™ TR-7021-D before using to assure the ingredients are uniformly distributed. Do not stir the adhesive so vigorously that air is beaten in. This will cause the adhesive to foam and make it difficult to apply. Measure the specific gravity using a Hydrometer or other instrument to assure the adhesive is properly mixed. When needed, a mixture of at least four parts diluent to one part ammonium hydroxide should be used to adjust the pH.

Continue to mix ROBOND™ TR-7021-D while spraying 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 0.4 mil
5 Unopened
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c. use as a critical component in medical devices that support or sustain human life; or

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Additional Information

North America

U.S. & Canada: 1-800-441-4369
1-989-832-1426
Mexico: +1-800-441-4369

Latin America

Argentina: +54-11-4319-0100
Brazil: +55-11-5188-9000
Colombia: +57-1-219-6000
Mexico: +52-55-5201-4700

Europe/Middle East

+800-3694-6367
1-800-441-4369
989-832-1426
+1-800-441-4369

Italy: +31-11567-2626
+800-783-825

South Africa

+800-99-5078

Asia Pacific

+800-7776-7776
+603-7965-5392

www.dowautomotive.com

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