

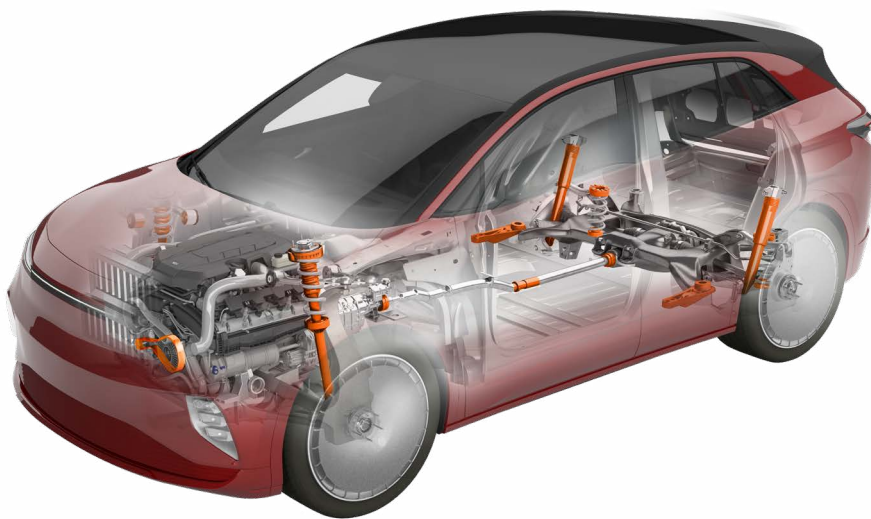
# MEGUM™/THIXON™ Rubber-to-Substrate Bonding Agents

## Product Selector Guide

Bonding elastomeric materials to metal, engineering plastics or other elastomers requires tough adhesives. MEGUM™ and THIXON™ bonding agents can be specially formulated for the specific bonding requirements of various substrates and conditions.

We offer a full line of low-VOC and HAP-compliant systems to help reduce emissions. Our adhesives perform in extremely severe environments and are suited for many automotive applications, including hoses, mounts, belts, bushings, seals, and instrument panels.

Long an industry leader in glass and plastic bonding technology, DuPont offers rubber-to-substrate bonding solutions that help make vehicles more energy efficient, safer, stronger, quieter, cleaner, more comfortable, and better looking. Our experience and diverse technologies enable us to solve your most challenging problems.



High-performance adhesive formulations bond similar and dissimilar substrates in mounts, bushings, belts, brake pads, window profiles, and other applications.

### Customizable Solutions

As a global science and technology leader and full-service supplier, we work closely with our customers to provide solutions based on the optimal combination of material, process, and system costs. Our Technology Centers provide rapid development of new products and solutions, in-the-field technical service, and quick response to your immediate needs.

Our facilities in all major regions include manufacturing plants, research-and-development laboratories, warehouses, shipping areas, and administrative offices. This allows us to perform troubleshooting, problem solving, performance testing, accelerated environmental testing, along with analytical expertise and services globally.

DuPont offers a complete, compatible family of rubber-to-substrate bonding agents designed to meet specific needs for a range of transportation and industrial applications, including belting, hoses, mounts, bushings, and seals.

## Guide for Solvent-based Bonding Agents

Rubber Class	Conditions of Cure or Specific Properties	Primer	Cover	One-coat
Natural rubber (NR)	IM TM	MEGUM™ 3276 MEGUM™ 3351	MEGUM™ 122 J MEGUM™ 128	MEGUM™ 508 MEGUM™ 5382
Styrene-butadiene rubber (SBR)	CM	MEGUM™ 3270 BG THIXON™ P-6-EF THIXON™ P-11 THIXON™ P-21 THIXON™ P-22	MEGUM™ 538 MEGUM™ 1261 MEGUM™ 5382 MEGUM™ 5386 THIXON™ 520-PEF THIXON™ 526	THIXON™ OSN-2-EF-V
Polyisoprene rubber (IR)	Hot glycol	MEGUM™ 3276 THIXON™ P-6-EF MEGUM™ 3270 BG	MEGUM™ 538 MEGUM™ 5386 THIXON™ OSN-2-EF-V	
Polybutadiene rubber (BR)	Coil coating	THIXON™ P-7-6	THIXON™ 547-EF	
Polychloroprene rubber (CR)		MEGUM™ 3276 MEGUM™ 3270 BG THIXON™ P-6-EF THIXON™ P-11 THIXON™ P-21 THIXON™ P-22	MEGUM™ 122 J MEGUM™ 128 MEGUM™ 538 MEGUM™ 1261 MEGUM™ 5386 THIXON™ 520-PEF THIXON™ 526	THIXON™ OSN-2-EF-V
Nitrile rubber (NBR)	Standard	MEGUM™ 3270 BG THIXON™ P-11 THIXON™ P-21	MEGUM™ 538 MEGUM™ 5386 THIXON™ 520-PEF THIXON™ 526 MEGUM™ 1261	MEGUM™ 3276 MEGUM™ 10576 THIXON™ P-11 THIXON™ P-21 THIXON™ 715-EF/B
	Higher heat and oil resistance	MEGUM™ 3276 MEGUM™ 3270 BG THIXON™ P-6-EF	MEGUM™ 538 THIXON™ 520-PEF THIXON™ 526 MEGUM™ 1261	MEGUM™ 3340-1 MEGUM™ 15637 THIXON™ 715-EF/B
	Coil coating			MEGUM™ 15638
Hydrogenated nitrile-butadiene rubber (H-NBR)	Sulfur cured	MEGUM™ 3276 THIXON™ P-6-EF	MEGUM™ 538 MEGUM™ 5386	THIXON™ 715-EF/B MEGUM™ 3340-1
	Peroxide cured			MEGUM™ 3340-1 MEGUM™ 15637 THIXON™ 715-EF/B MEGUM™ W 3295
Blend of NBR with polyvinylchloride (NBR/PVC)		MEGUM™ 3276 MEGUM™ 3270 BG THIXON™ P-6-EF THIXON™ P-11 THIXON™ P-21	MEGUM™ 122 J MEGUM™ 538 MEGUM™ 5382 MEGUM™ 5386	MEGUM™ 3340-1 THIXON™ 715-EF/B
Nitrile carboxylic rubber (XNBR)		MEGUM™ 3276 THIXON™ P-6-EF THIXON™ P-11 THIXON™ P-21	MEGUM™ 538 MEGUM™ 5382 MEGUM™ 5386	

## Guide for Solvent-based Bonding Agents, Continued

Rubber Class	Conditions of Cure or Specific Properties	Primer	Cover	One-coat
Ethylene-propylene rubber (copolymers, terpolymers and EPM/EPDM)	Sulfur cured	MEGUM™ 3276 MEGUM™ 3270 BG THIXON™ P-6-EF THIXON™ P-11 THIXON™ P-21	MEGUM™ 508 MEGUM™ 538 MEGUM™ 5382 MEGUM™ 5386 THIXON™ 560	MEGUM™ 508
	Peroxide cured		MEGUM™ 508 MEGUM™ 538 MEGUM™ 5382 MEGUM™ 5386 THIXON™ 560	
	Coil coating	THIXON™ P-7-6	THIXON™ 547-EF	
Butyl-rubber (IIR)		MEGUM™ 3276 MEGUM™ 3270 BG THIXON™ P-6-EF THIXON™ P-11 THIXON™ P-21	MEGUM™ 538 MEGUM™ 5382 MEGUM™ 5386	
Chlorosulfonized rubber, e.g., Hypalon (CSM)		MEGUM™ 3276 MEGUM™ 3270 BG THIXON™ P-6-EF THIXON™ P-11 THIXON™ P-21	MEGUM™ 508 MEGUM™ 538 MEGUM™ 5382 MEGUM™ 5386	MEGUM™ 508 THIXON™ OSN-2-EF-V
Polyacrylate rubber (ACM)				MEGUM™ 3340-1 MEGUM™ 15637 THIXON™ 15638 THIXON™ 715-EF/B THIXON™ 725
Vamac® (AEM)		MEGUM™ 3290-1 THIXON™ P-6-EF	MEGUM™ 538 MEGUM™ 5382 MEGUM™ 5386 THIXON™ OSN-2-EF-V	MEGUM™ 15637 THIXON™ 15638 THIXON™ 715-EF/B MEGUM™ 3340-1 MEGUM™ 10576
Fluoro rubber (FKM / FPM)	Amine, bisphenolic cured			MEGUM™ 3290-1 THIXON™ 300 / 301
	Peroxide cured			MEGUM™ 3299 MEGUM™ 3417
Silicone rubber (VMQ)				THIXON™ 305 MEGUM™ 2488 MEGUM™ 2840
Epichlorohydrin rubber (ECO, CO)				MEGUM™ 3340-1 MEGUM™ 15637 MEGUM™ 15638 THIXON™ 715-EF/B THIXON™ OSN-2-EF-V
Millable polyurethanes (PU)				MEGUM™ 508 MEGUM™ 3276 MEGUM™ 15637 MEGUM™ 15638 THIXON™ 715-EF/B
Castable polyurethanes (PU)	Curing at room temp			MEGUM™ 4592 THIXON™ 422
	Curing at 100° C without pre-bake			MEGUM™ 4592 THIXON™ 406 THIXON™ 422 THIXON™ 423

## Guide for Solvent-based Bonding Agents, Continued

Rubber Class	Conditions of Cure or Specific Properties	Primer	Cover	One-coat
Castable polyurethanes (PU)	Pre-bake at >100° C			MEGUM™ 4592 THIXON™ 406 THIXON™ 423
Thermoplastic Polyurethanes (TPU)				THIXON™ 422
Thermoplastic (TPV)				THIXON™ 6110-F
PVC				THIXON™ 6106

## Guide for Water-based Bonding Agents

Rubber Class	Primer	Cover	One-coat
Natural rubber (NR) Styrene-butadiene rubber (SBR)	MEGUM™ W 9300 MEGUM™ W 9301	MEGUM™ W 9100 MEGUM™ W 9500	MEGUM™ W 9400 MEGUM™ W 9700
Nitrile rubber (NBR) Hydrogenated nitrile-butadiene rubber (H-NBR) Polyacrylate rubber (ACM), (AEM/Vamac)	MEGUM™ W 9300 MEGUM™ W 9301	MEGUM™ W 9100 MEGUM™ W 9500	MEGUM™ W 9400 MEGUM™ W 9700 MEGUM™ W 25700
Fluoro rubber (FKM) – peroxide cure			MEGUM™ W 2525 MEGUM™ W 3295
Fluoro rubber (FKM) – bisphenol cure			MEGUM™ W 3295
Silicone rubber (VMQ)			MEGUM™ W 2525
Ethylene-copolymers (EPDM)	MEGUM™ W 9300 MEGUM™ W 9301	MEGUM™ W 9100 MEGUM™ W 9200 MEGUM™ W 9500	MEGUM™ W 9400 MEGUM™ W 9700

## Conditions of Use – Solvent-based Products

Reference	Type <sup>1</sup>	Cover Compatibility	Elastomers to be Bonded <sup>2</sup>	Dry Film Thickness, µm	Pre-bake <sup>3</sup>	Bonding Temperature Range, °C <sup>4</sup>
MEGUM™ 122 J	C		GP	10-20	NRP (max. 120° C)	130-190
MEGUM™ 128	C		GP	10-20	NRP (max. 120° C)	130-190
MEGUM™ 508	C		EPDM	15-30	NRP (max. 120° C)	130-190
MEGUM™ 538	C		GP, EPDM	15-25	NRP (max. 120° C)	130-190
MEGUM™ 1261	C		GP	10-20	NRP (max. 120° C)	130-190
MEGUM™ 2840	M		VMQ	<2	NRP	100-260 +P
MEGUM™ 3276	M		NBR, H-NBR, ACM	5-10	NRP	120-205
MEGUM™ 3276	P	MEGUM™ 122 J MEGUM™ 128 MEGUM™ 508 MEGUM™ 538 MEGUM™ 1261 MEGUM™ 5382 MEGUM™ 5386 THIXON™ 511-T THIXON™ 520-PEF THIXON™ 526	GP	5-10	NRP	
MEGUM™ 3290	M		FKM	<2	NRP	150-210 +P
MEGUM™ 3290-1-LD	M		FKM	<2	NRP	150-210 +P
MEGUM™ 3299	M		FKM (peroxide cured)	<2	NRP	150-210 +P
MEGUM™ 3340-1	M		NBR, H-NBR, ACM	5-25	NRP	120-205
MEGUM™ 3351	M		NBR, H-NBR, ACM	5-15	NRP	120-205
MEGUM™ 3351	P	THIXON™ 526 MEGUM™ 1261 MEGUM™ 122 J MEGUM™ 128 MEGUM™ 508 MEGUM™ 538 MEGUM™ 5382 MEGUM™ 5386 THIXON™ 511-T THIXON™ 520-PEF	GP	5-15	NRP	
MEGUM™ 3417	M		FPM /FKM	<2	NRP	150-210 +P
MEGUM™ 4592	M		PU	10-25	R (>100° C)	80-120 +P
MEGUM™ 5382	C		GP, EPDM	5-25	NRP (max. 120° C)	130-190
MEGUM™ 5386	C		GP, EPDM	5-25	NRP (max. 120° C)	130-190
MEGUM™ 8030	C		EPDM, post vulcanization	10-25		120-200
MEGUM™ 10576	M		NBR, CR	5-15		120-205
MEGUM™ 15637	M		NBR, H-NBR, ACM, ECO	5-15	R (15 min. at 115-135° C) NRP	120-205
MEGUM™ 15638	M		NBR, H-NBR, ACM, ECO	5-15	R (15 min. at 115-135° C) NRP	120-205
THIXON™ 300/301	M		FKM	<2	NRP	160-195 +P
THIXON™ 305	M		VMQ	<2	NRP	100-260 +P
THIXON™ 406	M		PU	10-25	R (>100° C)	80-120 +P
THIXON™ 422	M		PU	10-25	NRP (>100° C )	80-120 +P

<sup>1</sup>P=Primer, C=Cover, M=One-coat

<sup>2</sup>GP=General purpose (NR, SBR, CR, IIR, BR)

<sup>3</sup>R=Recommended, NRP=Not recommended but possible

<sup>4</sup>P=Post-cure as required by rubber formulation

## Conditions of Use – Solvent-based Products, Continued

Reference	Type <sup>1</sup>	Cover Compatibility	Elastomers to be Bonded <sup>2</sup>	Dry Film Thickness, $\mu\text{m}$	Pre-bake <sup>3</sup>	Bonding Temperature Range, $^{\circ}\text{C}$ <sup>4</sup>
THIXON™ 520-PEF THIXON™ 526	C		GP	10-20	NRP (max. 120° C)	130-190
THIXON™ 547-EF	C		GP, EPDM	5-8	R (min. 105° C)	130-190
THIXON™ 715-EF/B	M		NBR, ACM, PU, ECO	5-10	R (10 min. at 130° C)	125-205
THIXON™ 725 A/B	M		NBR, ACM, ECO, CO	5-10	R (10 min. at 130° C)	125-205
THIXON™ OSN-2-EF-V	C		NR, SBR, AEM, CR, CSM, ECO	15-40	NRP (max. 120° C)	120-230
THIXON™ P-6-EF	P	MEGUM™ 122 J MEGUM™ 128 MEGUM™ 508 MEGUM™ 538 MEGUM™ 1261 MEGUM™ 5382 MEGUM™ 5386 THIXON™ 511-T THIXON™ 520-PEF THIXON™ 526 THIXON™ OSN 2-EF-V	GP	5-10	NRP	
THIXON™ P-7-6-EF	P	THIXON™ 547-EF	GP	2,5-5	R (210-235° C)	
THIXON™ P-11 THIXON™ P-21	M		NBR, H-NBR, ACM	5-10	NRP	100-205
THIXON™ P-11 THIXON™ P-21	P	MEGUM™ 122 J MEGUM™ 128 MEGUM™ 508 MEGUM™ 538 MEGUM™ 5382 MEGUM™ 5386 THIXON™ 511-T THIXON™ 520-PEF THIXON™ 526 MEGUM™ 1261	GP	5-10	NRP	
MEGUM™ 8030	C		EPDM	15-25		120-200 PV-bonding

<sup>1</sup>P=Primer, C=Cover, M=One-coat

<sup>2</sup>GP=General purpose (NR, SBR, CR, IIR, BR)

<sup>3</sup>R=Recommended, NRP=Not recommended but possible

<sup>4</sup>P=Post-cure as required by rubber formulation

## Conditions of Use – Water-based Products

Reference	Type <sup>1</sup>	Cover Compatibility	Elastomers to be Bonded <sup>2</sup>	Dry Film Thickness, µm	Pre-bake <sup>3</sup>	Bonding Temperature Range, °C <sup>4</sup>
MEGUM™ W 2525	M		VMQ, EPDM, H-NBR (peroxide cured)	<2	R (15 min. at 110-150° C)	150-210
MEGUM™ W 3295	M		FKM, ACM	<2	R (15 min. at 120-150° C)	150-210
MEGUM™ W 9100	C		GP, NBR	15-30	NRP	120-190
MEGUM™ W 9200	C		GP	15-30	NRP	120-190
MEGUM™ W 9300	P	MEGUM™ W 9100 MEGUM™ W 9200 MEGUM™ W 9500	GP, NBR, H-NBR, X-NBR, EPDM	5-15	NRP	120-190
MEGUM™ W 9400	M		GP, NBR, ECO, CR, ACM	20-35	R (5-15 min @ 80° C)	120-190
MEGUM™ W 9500	C		GP, NBR, H-NBR, X-NBR, EPDM	15-30	NRP	120-190
MEGUM™ W 9700	M		GP	15-35	R (15 min @ 80° C)	120-190
MEGUM™ W 25700	M		AEM, ACM	<2	R (15 min @ 110-150° C)	150-210

<sup>1</sup>P=Primer, C=Cover, M=One-coat

<sup>2</sup>GP=General purpose (NR, SBR, CR, IIR, BR)

<sup>3</sup>R=Recommended, NRP=Not recommended but possible

<sup>4</sup>P=Post-cure as required by rubber formulation

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