

## Application / Properties

ENERKOL is a two-component contact adhesive for joining and repairing conveyor belts, lining steel containers and applying rubber coating to steel-rollers. Bondings made with ENERKOL are temperature, plasticizer and moisture resistant. The pertinent values are dependant on the composition of the rubber compound and the stress to which the part is exposed.

## Technical Data

<b>Base</b>	Polychloroprene
<b>Colour</b>	Black
<b>Viscosity (Brookfield)</b>	Ca. 2.500 - 4.500 mPas*
<b>Density</b>	Ca. 0,85 g/cm <sup>3</sup>
<b>Thinner / Cleaner:</b>	Solvent 676
<b>Hardener (percentage)</b>	5% Hardener 500 AE
<b>Pot life</b>	Ca. 3 hours
<b>Application</b>	Brush or spatula
<b>Coverage</b>	Ca. 300 g/m <sup>2</sup>
<b>Drying time</b>	Ca. 20 - 30 minutes
<b>Contact life</b>	Ca. 30 minutes
<b>Setting time</b>	Ca. 24 hours
<b>Conditions for storage and transport</b>	Well closed at temperatures between 10°C and 30°C
<b>Sensitive to cold</b>	Yes, reversible
<b>Inflammable</b>	Yes
<b>Labelling acc. to regulations for dangerous goods</b>	F, Xi, N - See Safety data sheet

\*The viscosity indicated above is based on a temperature of 20°C prevailing at the time of production. Minor deviations may occur during storage.

## Pre conditions

The materials to be bonded must be dry and free from grease and dust. If necessary, they should be cleaned with a cleaning agent (SBEN). Rubber surfaces must be roughened thoroughly. Since roughened surfaces lose part of their effectiveness during longer periods of storage, adhesive must be applied to the roughened rubber surfaces right away. Warning: do not roughen textile/fabric surfaces of conveyor belts, this leads to serious weakening of the strength of the bonding or product itself. To improve the adhesion of ENERKOL to metal surfaces, it is recommended to apply a coat of primer (SwiftPrime)

## Instruction for use

Carefully mix (stir thoroughly) ENERKOL with the Hardener 500 AE. The best adhesion to various rubber materials is achieved within 15 to 30 minutes after the mixture with the hardener. After this mixture has been stored for a longer period, its adhesion decreases to a certain extent. The adhesive/hardener mixture is applied to the suitably prepared surface of the materials to be bonded by means of a brush or spatula. The surfaces must be coated firmly (with some force). When bonding rubber to rubber, it is recommended to apply the adhesive twice, waiting at least 10 minutes after the first application for the adhesive to dry and another 10 minutes after the second application. The adhesive should be just dry. When bonding textiles the adhesive must be applied three times to achieve good adhesion (in this case at least ca. 30 minutes should be allowed for drying of the adhesive after the first application and 10 minutes after the second application). The adhesive should be just dry. The bonding must be done by connecting both bonding surfaces. Hit the surfaces hard by using a hammer, but best is to use a press or double pressure rollers. To attain the best bonding, room- or ambient temperature and the adhesive should not be allowed to drop below 18°C. In case of lower or higher temperatures keep adhesive apart from the work area at a conditioned place, only mix and apply the adhesive when all the preparatory work is done. In case of temperature < 4°C / < 40°F it is also recommended to warm up the workplace and / or product as well.