



Cold Vulcanizing Adhesives.

FORECH INDIA LIMITED

Rubber Products for Mining, Mineral Processing and Conveying Industries

Cold Vulcanizing adhesives.

Applications:

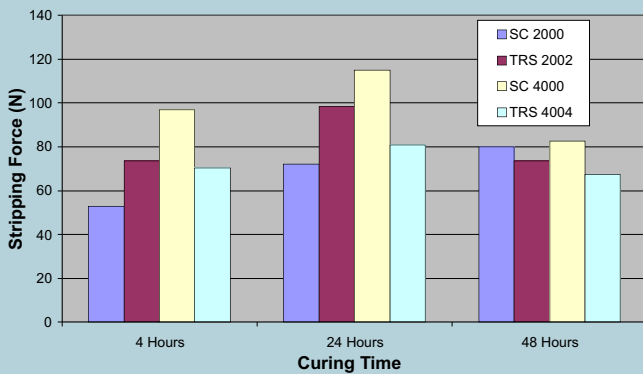
- Rubber to Rubber bonding for Natural, SBR, Neoprene and Nitrile materials
- Rubber to Fabric bonding
- Rubber to Metal bonding
- Belt Splicing and repairs
- Pulley Lagging
- Rubber Lining
- As Vulcanising solution for hot curing processes

Performance:

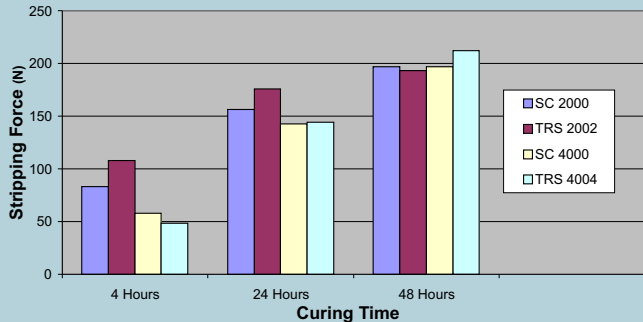
TRS 2002 & 4004 cold vulcanizing adhesives have been tested for rubber to rubber, rubber to fabric and fabric to fabric adhesion by TUNRA LTD the commercial division of the University of Newcastle. The following graphs show the comparative results between the TRS 2002 & 4004 and the Rema Tip Top adhesives SC2000 and SC4000.

Comparison Graphs

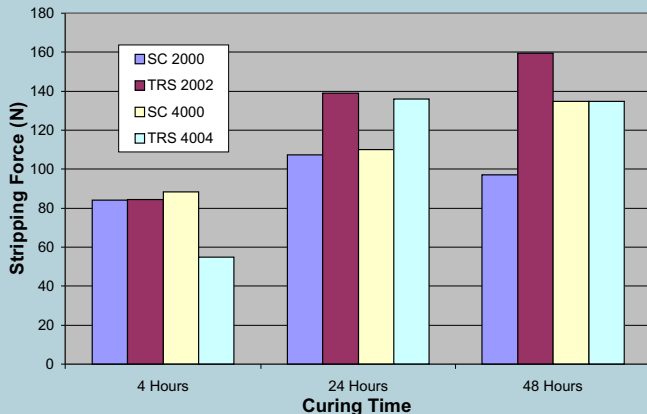
Rubber to Rubber Adhesion



Fabric to Fabric Adhesion



Rubber to Fabric Adhesion



Preparation for Use:

TRS 2002 and TRS 4004 must be mixed with the hardener TRS 1000E or TRS 1000M. The hardener is added at the rate of 4-5% of adhesive by volume. Adhesive and hardener must be well mixed ensuring all solids are fully dispersed. (Before use of 200Kg drums, the drums must be rolled for approx 5 minutes to ensure adequate mixing.)



Adhesive Open Time:

The open time of the mixed adhesive is dependant on ambient temperature and humidity. Typical open times are as follows:

	TRS2002	TRS 4004
• Cold / normal temps (15-30° C)	20-25 minutes	30-35 minutes
• Hot temps (>30°C)	12-20 minutes	20-25 minutes

After application to the work surface, before stitching, test surface of adhesive with knuckle if the surface is still tacky then it is ready for stitching.

Pot Life of Mixed Adhesive:

The higher the ambient temperature the lower the pot life will be when the mixed adhesive starts to thicken, discontinue use.

Average pot life at approx 20° C:

TRS 2002	TRS 4004
1 hour	5 hours

Surface Preparation Rubber:

For buffing rubber surfaces always use rough tools (Rocket) the rougher the surface, the better the adhesion. Never scorch the rubber surface as this will cause adhesion problems. Use only slow running grinders with very rough buffing discs. TRS Solvent should be used to remove any grease, oil or dirt from the surfaces to be bonded.



Surface Preparation - Metal:

Always use TRS Metal Primer prior to adhesive application. The metal surface should be freshly sandblasted or ground and be free of dust, dirt, rust and grease etc. TRS Solvent should be used to remove any grease, oil or dirt from the surfaces to be bonded. Apply TRS Metal Primer to the surface and allow drying for 1-2 hours before applying adhesive. Primer must be completely dry before applying adhesive. TRS Metal Primer can also be used for hot vulcanising.



TRS Plasto adhesive for the bonding of Polyurethanes and PVC and is the ideal adhesive for repair work on conveyor belting.

Applications:

- Polyurethane to Polyurethane bonding
- Polyurethane to Fabric bonding
- PVC to PVC bonding
- PVC to Fabric bonding





Preparation for Use:

TRS PLASTO must be mixed with the hardener TRS 1000E or TRS 1000M. The hardener is added at the rate of 4-5% of adhesive by volume. Adhesive and hardener must be well mixed ensuring all solids are fully dispersed. (Before use of 200Kg drums, the drums must be rolled for approx 5 minutes to ensure adequate mixing.)

Pot Life of Mixed Adhesive:

The higher the ambient temperature the lower the pot life will be when the mixed adhesive starts to thicken, discontinue use.

Average pot life at approx 20° C: TRS PLASTO 1 hour

Surface Preparation:

Surface preparation for TRS PLASTO is the same as for TRS 2002 and TRS 4004.

Bonding Instructions:

Rubber to Rubber (without TRS Bonding Layer):

Buff rubber surfaces to be bonded. Apply TRS 2004 / 4004 (mixed with hardener) to both surfaces and allow to dry approx. 40-60 mins. Apply a second coat to both surfaces and allow drying until tacky approx. 10-20 mins. Put surfaces together and stitch down well.

Rubber to Rubber (with TRS Bonding Layer):

Solvent wipe over TRS bonding layer surfaces and allow to dry. Apply TRS 2004 / 4004 (mixed with hardener) to both surfaces and allow to dry approx. 40-60 mins. Apply a second coat to both surfaces and allow drying until tacky approx. 10-20 mins. Put surfaces together and stitch down well.



Rubber to Metal:

Metal surface must be sandblasted to a white finish. Apply a single coat of TRS Metal Primer and allow to dry approx. 60 mins. Apply TRS 2004 / 4004 (mixed with hardener) to both surfaces and allow to dry approx. 40-60 mins. Apply a second coat to both surfaces and allow drying until tacky approx. 10-20 mins. Put surfaces together and stitch down well.

Specifications and packaging

TRS 2002

Shelf Life unmixed	: approx 2 years store below 35°C
Pot Life	: approx 1 hour subject to ambient temp
Improved Thermal Stability	: max 100 deg C
Colour	: Black
Packaging	: 2 Kg cans 10 cans / carton 5 Kg cans 6 cans / carton 200 Kg drums

TRS 4004

Shelf Life unmixed	: approx 2 years store below 35° C
Pot Life	: approx 1 hour subject to ambient temp
Improved Thermal Stability	: max 100°C
Colour	: Black
Packaging	: 2 Kg cans 10 cans / carton 5 Kg cans 6 cans / carton 200 Kg drums

TRS 1000E & TRS 1000E Hardeners

TRS 1000E	: 30 gm bottles 10 bottles / carton 235 gm bottles 6 bottles / carton
TRS 1000M	: 40 gm bottles 10 bottles / carton 200 gm bottles 6 bottles / carton

TRS PLASTO

Shelf Life unmixed	: approx 2 years store below 35° C
Pot Life	: approx 1 hour subject to ambient temp
Improved Thermal Stability	: max 100° C
Colour	: Grey
Packaging	: 1 Kg cans 10 cans / carton 5 Kg cans 6 cans / carton 200 Kg drums

TRS METAL PRIMER

Shelf Life	: unlimited if unopened store below 35° C
Packaging	: 1 Kg cans 10 cans / carton 5 Kg cans 6 cans / carton

TRS SOLVENT

Shelf Life	: unlimited if unopened store below 35° C
Packaging	: 1 Kg cans 10 cans / carton 5 Kg cans 6 cans / carton

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