Smiley Monroe’s COLD BOND™ system for bonding rubber to metal consists of COLD BOND™ METAL PRIMER and COLD BOND™ COLD VULCANISING ADHESIVE with ACTIVATOR – a two part adhesive system, based on chloroprene rubber in a solvent base.
INSTRUCTIONS

1. Ensure that the metal surface has been freshly keyed (shotblasted or buffed with 24 grit) and that your rubber material with a bonding layer (‘tackyback’) has already been cut to suit the metal surface. Rubber material without a bonding layer must be keyed using a buff with 24 grit and if stored for a long time, the bonding layer material must be keyed. The materials to be bonded and the adhesive must be at room temperature.

2. The metal surface should then be brushed down with a soft bristled brush and cleaned with cellulose thinners to ensure that it is free of dust, oil and grease. Allow the metal surface to dry for 10 mins at room temperature.

3. Apply a coat of COLD BOND™ METAL PRIMER to the metal surface and allow to dry for 30 mins at room temperature. Shake container before opening and stir well. Storage time of coated metal max. 2 weeks at room temperature.

4. While the metal primed surface is drying, thoroughly mix 1x bottle (40g) of COLD BOND™ ACTIVATOR with 1x container (700g/800ml) of COLD BOND™ ADHESIVE and stir well. When the metal primed surface is dry, apply a coat of the activated adhesive and allow to dry for 30 mins at room temperature. Use within 1 hour of mixing.

5. Apply a coat of the activated adhesive to the bonding layer/keyed area of the rubber material and apply a second coat to the metal. When both surfaces are tacky to the touch (max. 10 mins), they should be brought into contact.

6. Using a steel hand roller or rubber mallet, press the rubber material onto the metal to expel any air. Pressure depends on surface properties. Short pressing is sufficient.

For best results allow the rubber to metal bond to cure for 24 hours before use.

Operating temperature range of activated COLD BOND™ VULCANISING ADHESIVE = -20°C to +70°C

Bonding area coverage (Approx)

COLD BOND™ METAL PRIMER (700g/750ml) = 3M²

COLD BOND™ COLD VULCANISING ADHESIVE (700g/800ml) = 1.5M²

Find out more
www.smileymonroe.com