RUBBOND® HM 650

TECHNICAL DATA SHEET

Issue No	Revision Date
002/03	01.12.2022

Product - Trade Name
RUBBOND® HM65O

Classification
Dry Bonding Agents - Methylene Donor
Adhesion Promoter

Composition
65% of Hexa Methoxy Methyl Melamine (HMMM)
Coated with Silica and oil treated
Melamine Formaldehyde Resin
Methylated Melamine Formaldehyde Resin
Modified Melamine Formaldehyde Resin

Physical properties:

Parameter	Specification
Physical Form	Free flowing powder

Chemical properties:

Parameter	Specification	Test Method
Sp. Gravity @ 25°C	1.40±0.05	D1817
HMMM content, %	65 ± 1	RCPL T-14
Ash Content, @ 850°C, 1hr , %	28±2	D4574
Moisture Content, % (Karl Fischer)	4.0 Max	D6304/ E203
Loss On Drying, % @105°C, 1hr.	5.0 Max	D4571
Free Formaldehyde, %	0.10 Max	ISO11402/ D1198
Sieve Residue on 100 mesh -Wet, %	0.10 Max	D5461
Oil content, %	5.0±0.5	D4573

Solubility

Alcohol	: Partly soluble
Petroleum Ether	: Partly soluble
Water	: Insoluble

Processing behavior
It is safe in processing both non-black & black reinforced compounds.

Recommended Dosage

RUBBOND® HM65O	4 – 5 Phr
RUBBOND® RSA (Resorcinol Dispersions)	3.5– 4 Phr
TECHNIC RF Resin	4 – 5 Phr

Advantages
- Easy Handling
- Easy Dispersion in compound
- Noncorrosive effects on coated steel
- Non dusting
- Scorch protection higher than HMT
- Nontoxic and no skin irritation

Principally used as a component of Dry Bonding Agent. It is recommended for use in final mix in case of two stage mixing.

Application
RUBBOND® HM65O has been successfully designed to meet the stringent needs of cord-rubber properties of tyre and non - tyre industries. It offers a balanced combination of good adhesion and excellent fatigue resistance in conjunction with Methylene acceptors like TECHNIC B19S / B20S through formation of an in-situ resin. The recommended dosage above shows the level for initial evaluations.

Handling precautions
Irritating to the eyes, respiratory system and skin. Avoid contact with eyes, skin and clothing. Wash thoroughly after handling.

REACH Compliance:
Material is meeting the REACH compliance.

Packaging
25 kg in HDPE laminated paper bag / Jumbo bag.

Storage properties
Stable for one year, when stored tightly at normal room temperature.

Shelf Life
12 months from the date of manufacturing.

Note:
Information in this publication is believed to be accurate and is given in good faith, but it is for the customer to satisfy itself of the suitability for its own particular purpose. RCPL gives no warranty as to the fitness of the product for any particular purpose and any implied warranty or condition (statutory or otherwise) is excluded except to the extent that law prevents such exclusion.

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