



RUBBOND® HM 72

TECHNICAL DATA SHEET

Issue No
002/03

Revision Date
01.12.2022

Product - Trade Name

RUBBOND® HM72

Classification

Dry Bonding Agents – METHYLENE DONOR
Adhesion Promoter

Composition

72% of Hexa Methoxy Methyl Melamine Coated
with Silica
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, %	72 ± 1	RCPL T-14
Ash Content, @ 850°C, 1hr, %	26±3	D4574
Moisture Content, % (Karl Fischer)	4.0 Max	D6304/ E203
Loss On Drying, % @105°C, 1hr.	5.0 Max	D4571
Free Formaldehyde, % wt/wt	0.10 Max	ISO11402/ D1198
Sieve Residue on 100 mesh -Wet, %	0.10 Max	D5461

Solubility

Alcohol, Petroleum Ether : Partly soluble
Water : Insoluble

Storage properties

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

Processing behavior

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

Recommended dosage

RUBBOND® HM72 4-5.0 phr
TECHNIC B19S (RF Resin) 3-4.5 phr

Advantages

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

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

Application

RUBBOND® HM72 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 RUBBOND® RSA / RUBBOND® RS / RF Resin
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.
Refer MSDS for complete details

REACH Compliance:

Material is meeting the REACH compliance.

Packaging

25 kg in HDPE laminated paper bag / Jumbo bag

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.

RAJSHA CHEMICALS PRIVATE LIMITED

www.twc.in

Works:

Block No.: 637, Lamdapura Road, At. Manjusar
PO: Lamdapura, Ta: Savli, Dist. Vadodara 391 775, India
Tel – +91 9662049271
Email – office@rajsha.com

TWC Group, Corporate Office:

Hi Tech Chambers, 5th Floor, 84/1B Topsia Road (S)
Kolkata 700 046, India
Tel – +91 33 2285 1278 / 1279. Fax - +91 33 2285 1280
E mail – info@twc.in