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MINING ADHESIVES TIGROSTIK SC-022

TECHNICAL DATA SHEET:

Tigrostik SC-022 is a contact adhesive made from special polymers.

APPLICATION:

Tigrostik SC-022 is used for bonding rubber to metal, textiles to metal, rubber to rubber, textile to textile and rubber to textile.

TECHNICAL DATA:

Appearance:	Black homogeneous solution
Viscosity (ISO 2431, 0,8 20oC), s	80 ± 10
Specific gravity (ISO 2811,20oC), g/cm ³	1.41
Total solids (ISO 3251),%	Min. 14.5
Flash point (ISO 3679),0C	Non-flammable
Application	By brush
Consumption, g/m ²	400-600
Package	1 & 6 kg tin cans
Storage conditions	In original package at temperatures from 5 to 25°Celcius
Storage life	2 year

INSTRUCTIONS FOR USE:

Prepare the surfaces which are to be bonded. Roughen the rubber with a steel brush, avoiding the textile. Remove dust from the roughened areas with a brush. Clean any corrosive metal surfaces and wash with a cleaning solvent such as Tigrosol NL. Add 5% of Hardener SC to the **Tigrostik SC-022** and stir thoroughly to prepare the adhesive. Pot life is approximately 2 hours.

Apply 3 coats of the prepared adhesive to the textile and rubber. The first coat should be allowed to dry for approximately 10 minutes. The second coat should be tried a little longer, approximately 30 minutes. The third coat should be allowed to dry until it reaches a "tack free" state, which takes between 15 and 20 minutes. If the third coat is allowed to dry for too long, it will be necessary to apply an additional fourth coat.

When bonding rubber to metal, insure that the adhesive is applied to both the metal and rubber surfaces. The first coat should be left for approximately 30 minutes to dry while the second coat should dry for between 10 and 20 minutes. Assemble the surfaces and press tightly with a press or rollers to insure maximum adhesion.



WARNING:

The Tigrostik SC-022 adhesive is non-flammable. Please ensure adequate ventilation before use. Smoking and working with open flame are forbidden in work areas.