

COLD VULCANISATION LAGGING ADHESIVE – CVLA

TECHNICAL DATA SHEET



DESCRIPTION & USES:

- Elastotec CVLA** Is a two component, room temperature curing solvent based adhesive that, when cured with CVLA Hardener, yields high strength bonds.
- Elastotec CVLA** Has been formulated to provide high strength rubber tear bonds with the CN Bonding layer used on Elastotec pulley lagging.

MIXING INSTRUCTIONS:

- Elastotec CVLA** Bonding system is comprised of an adhesive and hardener in the ratio of 5% by weight (900 grams of **Elastotec CVLA** to 45 grams of CVLA Hardener).
- These two components must be thoroughly mixed (hand stirred for two minutes until uniform). Inaccuracies and poor mixing will result in lower physical properties of the cured system. The mixed adhesive should be used within 4 hours.

SURFACE PREPARATION:

- Rubber to Metal** All surfaces must be clean, dry and free of oil, paint and other contamination.
 - Metal surfaces should first be cleaned with NC Solvent and then sandblasted and cleaned again with NC Solvent to obtain maximum adhesion.
 - After the metal surface is prepared it should be primed with Elastotec Metal Primer. The primer should be allowed to dry completely, approximately 1 hour depending upon atmospheric conditions (it is preferable to allow the Primer to dry overnight).
 - Apply one coat of adhesive to metal surface (coating should be proceed with coating method of application on page 2) and one coat to the lagging surfaces to be bonded. Allow to dry 60 minutes.
 - Apply a second coat to the metal surface and to the lagging surface. The drying time of second coat is temperature dependent (refer to Figure 1 below) so only apply adhesive to an area of the pulley that can be coated and have the lagging applied at the optimum drying time shown in the graph below.
- THIS IS VERY IMPORTANT TO OBTAINING THE MAXIMUM ADHESION STRENGTH**
Inaccuracies of drying time of second coat will result in lower physical properties of the cured system.
- The final step is to bond the rubber and metal surface together (follow the method detailed in the **Elastotec CVCL Application Procedure**).

Drying Time

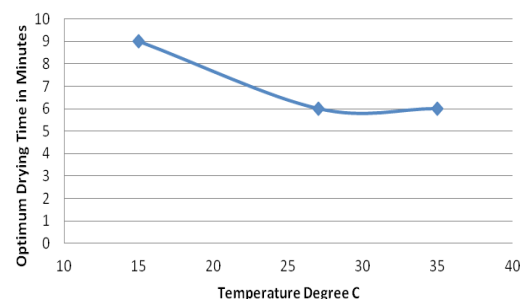


Figure 1. Optimum drying time of second coat versus different ambient temperature.

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COATING METHOD OF APPLICATION:

When applying the Elastotec CVLA adhesive a scrubbing motion with a cement brush is preferred so that all voids on the surface to be bonded are filled in.

The first coat of adhesive on substrate and rubber should be allowed to completely dry for at least 1 hour (preferably overnight) before the second coat, or “tack coat” is applied.

To the properly prepared surfaces apply a tack coat of Elastotec CVLA to each surface at the same time so they dry at the same rate.

As rapidly as possible, apply a uniform coat with a brush.

IMPORTANT NOTE: Avoid heavy builds, puddles, uneven coating. Surfaces must dry uniformly. The first applied coating must be uniform light blue colour - no black/grey streaks visible. This will mean continuing to apply the adhesive over the pulley/lagging surface after the initial application has dried. Application by spraying is not recommended.

PROPERTIES:

- Appearance:** Blue liquid.
- Kit Sizes:** Adhesive 1 litre Hardener 50 mls
Adhesive 15 litres Hardener 750 mls
- Viscosity:** Approx. 2500cps.
- Solids:** Approx. 22%
- Pot Life:** The gel time or working life of mixture is approximately 4 hours at 20°C.
- Coverage:** Approximately 2 sqm per 1 litre per coat by brushing.
- Storage:** Shelf life of unopened containers is 2 years when stored under normal conditions.
- Elastotec CVLA** and hardener should be stored in a cool dark place away from heat, sparks and flame under 20°C.
- Note:** **Additional information on physical properties, health hazards, storage, handling and transport is available in the Material Safety Data Sheet (MSDS).**

