Product Data Sheet

RubbaFIX® is a quick acting hot-melt adhesive for repairs that provide:

- A solution for tears, damage and maintenance of all rubber surfaces.

Application Areas

- Conveyor belts
- Wear liners
- Tank linings
- Pump diaphragms
- PVC

Features and Benefits

- Cures in 30 minutes
- Food grade certification for RubbaFIX® Pucks, White and FRAS
- Easily applied using RubbaFIX® MELTA® Applicators
- Minimal wastage of product
- Maintains durometer
- Single part product
- Non-toxic

Packaging and Coverage

Based on applying 12mm thickness and 1kg of product covering 300mm x 300mm (0.09m^2)

- 0.5kg kit covers 0.045m^2
- 2kg kit covers 0.18m^2
- 5kg kit covers 0.45m^2
- 10kg kit covers 0.9m^2
- Note: Kits are pre-weighed
- Available in Black, White and FRAS grades

Technical Data

Cured Density	0.98 g/cc (25°C)
Tensile Modulus, ASTM D 638	4500 psi (31 MPa)
Tensile Adhesion, ASTM D1623-09	300 psi (50mm ∅)
Tensile Strength, ASTM D 1708	200 psi (1.4 MPa)
Tensile Elongation, ASTM D 1708	200%
Peel Strength ASTM D 1876	3.5 N/mm^2 – PVC; 4.1 N/mm^2 – Neoprene rubber
Shore A Durometer	70
Application Temperature (dependent on service)	-15 °C to 55 °C (Low Temperature Impact Resistance: PVC Peel Strength 3.5 N/mm^2 or greater, Mandrel Bend: -30 °C*)
Shelf Life (unopened containers)	Infinite

* Application temperature above or below range is subject to adhesion trials for suitability.

RubbaFIX® performance against belt temperature

RubbaFIX® adhesion has been tested with an M grade rubber belt at different belt temperatures. At a belt surface temperature of 40 °C, >200 psi (1.4 MPa) is required for pull-off.

Chemical Resistance (ASTM D543 – 7 day exposure)

Chemical	Resistance
Hydrochloric Acid - 36% (w/v)	Extensive softening of surface - Non-resistant
Acetic Acid - 5% (v/v)	Completely resistant
Glacial Acetic Acid	Dissolution - Non-resistant
Trifluoroacetic Acid - 5% (v/v)	Slight softening of surface - Mostly resistant
Trifluoroacetic Acid – 99% (w/v)	Dissolution – Non-resistant
Formic Acid - 5% (v/v)	Completely resistant
Formic Acid – 98% (w/v)	Dissolution – Non-resistant
Sodium Hydroxide – 1% (w/v)	Completely resistant
Sodium Hydroxide – 11% (w/v)	Completely resistant
Sodium Hydroxide - 30% (w/v)	Completely resistant
Sodium Hydroxide – 150% (w/v)	Completely resistant

Surface Preparation

An appropriate preparation of the surface is necessary for proper adhesion. The exact requirements for surface preparation will vary with the specifics of the application. Optimum preparation involves roughening the surface with a wire wheel followed by cleaning with an alcohol based solvent or acetone.

- **Recommended tool:** Angle grinder/Sander/Polisher: minimum 6,500 rpm
- **Recommended attachment:** Twist knot wheel brush (wire wheel): high carbon steel wire
- **Recommended surface temperature of the belt:** 100 °C (heated with a hot air gun)

Safety

Before using any product, review the appropriate Safety Data Sheet (SDS) and follow standard procedures in the operating manual (available online).

Application Information

Time to obtain working temperature: 15 minutes (MELTA® Mini)

All training and preparation required for application is available at: http://www.rubbafix.com

Food Grade Certification

This product is acceptable for use as a coating for the resurfacing of polymer conveyor belts (P1) that are in contact with food in and around food processing areas. The amount used should be the minimum required to accomplish the intended physical or technical effect. This product should be used on conveyor belts that are in contact with dry food only. Use must be consistent with manufacturer's directions.

	Registration Number
RubbaFIX® Pucks	155018
RubbaFIX® White	155019
RubbaFIX® FRAS	155020