



TECHNICAL DATA SHEET

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Reliobond SC-215A Low VOC General Purpose Adhesive

Reliobond SC-215A is a general purpose adhesive that can be used to bond a variety of plastics, fabrics, and metals. Reliobond SC-215A is particularly well suited for bonding flexible vinyl as it is highly resistant to plasticizer migration. Reliobond SC-215A can be applied as a contact adhesive or heat cured for additional bond strength. Reliobond SC-215A has a low VOC solvent system (<110 g/L, <1.5%).

TYPICAL PROPERTIES:

(NOT FOR SPECIFICATION PURPOSES)

	Reliobond SC-215A
Solids (Non-Volatiles)	14-16%
Viscosity (#2 Zahn Cup)	15-20 seconds
Density (Weight per Gallon)	6.93 #/gal

APPLICATION INSTRUCTIONS:

Surface Preparation:

All bonding surfaces must be free of oils, dirt, and other contaminates. Metal surfaces should be degreased using an alkaline cleaning solution or a solvent rinse. Plastics should be wiped clean with isopropyl alcohol or toluene to remove any mold releases or other surface contaminates.

Adhesive Application:

Reliobond SC-215A can be applied by brush, spray, or roller. For spray application, dilution of Reliobond SC-215A with methyl ethyl ketone, methyl acetate, acetone, or n-butyl acetate may be necessary.

When using Reliobond SC-215A as a contact adhesive, coat both bonding surfaces. After 2-3 minutes drying time, the bonding surfaces can mated and pressed together. If the adhesive gets too dry and a good bond cannot be formed the adhesive can be reactivated by wiping with acetone or methyl ethyl ketone or by applying a fresh coat of adhesive.

Heat Curing:

Reliobond SC-215A can be heat cured at 280-350°F for 5 minutes to 1 hour to create a stronger, more chemical resistant bond. During this cure process, pressure is also recommended for creating the best bond. 75-150 psi should be applied.

Cleaning:

Reliobond SC-215A can be cleaned prior to cure using methyl ethyl ketone, acetone, n-butyl acetate, methyl acetate, or t-butyl acetate solvents. If the adhesive is fully cured the only practical methods of removal are abrasion, burning, heating above 600°F (316°C) for many hours, or soaking in a highly caustic solution. Consult MSDS for instructions on spill clean up and disposal.

Storage:

Recommended storage temperature for Reliobond SC-215A is 40°-60°F (4°-16°C). Prolonged storage at temperatures above 60°F can cause curing or gelling of the adhesive. If cold storage is not available, try to keep the adhesive in a cool, dry area.

All statements, technical information and recommendations contained herein are based on tests believed to be reliable, but the accuracy or completeness thereof is not guaranteed, and the following is made in lieu of all warranties expressed or implied.

Seller's and manufacturer's only obligation shall be to replace such quantity of the product proved to be defective. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use of, or the inability to use the product. Before using, user shall determine the suitability of the product for their intended use and user assumes all risk and liability whatsoever in connection therewith.

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