



TECHNICAL DATA SHEET

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RUSCOE DH-103

DESCRIPTION:

Ruscoe DH-103 is a nitrile rubber based adhesive designed for bonding many vinyl and rubber compounds. It can also be used to bond rubber compounds, leather, glass, metal, fabric and aluminum. The adhesive will air dry by solvent evaporation to form a strong, flexible bond that is resistant to water, oil and gasoline. It also has very good heat resistance and excellent resistance to plasticizer migration.

PHYSICAL PROPERTIES:

BASE	Nitrile Rubber
SOLVENTS	Methyl Ethyl Ketone, MIBK
SOLIDS	20%
WEIGHT PER GALLON	7.2 LBS
FLASH POINT	20°F (Closed Cup)
COVERAGE	292 sq.ft./gal./mil.
SHELF LIFE	6 months @73°F

APPLICATION:

1. Thoroughly clean surfaces to be bonded. Remove all dirt, grease, oil or waxes.
2. Stir Adhesive before use.
3. The adhesive can be applied by brush or with a roller. It can be thinned with lacquer thinner, ketone or acetate solvents.
4. For best results, apply adhesive to each surface to be bonded. Porous materials, such as fabrics, may require more than one coat. Successive coats of adhesive may be applied to the surface or porous materials after the previous coat has become dry. Sufficient adhesive should remain on the surface of each material to form a thin film.
5. Allow adhesive to become tacky dry – approximately 5 minutes after application. Adhesive is considered to be tacky dry when it is sticky to the touch, but will not transfer to the finger.
6. Assemble the materials while adhesive is tacky dry using sufficient pressure to insure intimate contact. At room temperature adhesive remains tacky dry for at least 10 minutes. If the adhesive film is dried beyond the tacky state, it may retackified by wiping with a suitable solvent such as MEK or by softening with moderate heat – approximately 160°F to 180°F. Full bond strength will develop after adhesive has become thoroughly dry – approximately 96 hours after material assembly.

A thermosetting bond can be obtained by heating assembly to temperatures up to 450°F. Adhesive has thermoset when it is no longer soluble in methyl ethyl ketone.

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