

TECHNICAL DATA SHEET



RELIOBOND SC-215A

DESCRIPTION

Ruscoe's 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%).



METHOD OF APPLICATION

All bonding surfaces must be free of oils, dirt and other contaminants. Metal surfaces should be de-greased 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 contaminants.

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 be 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.

STORAGE AND SHELF LIFE

Recommended storage temperature for Reliobond SC-215A is 40°F-60°F (4°C-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.

HEALTH AND SAFETY

Health and safety data sheets available upon request at The Ruscoe Company. Contact with skin and eyes should be avoided and necessary protective equipment and clothing should be worn.

HEAT CURING

Reliobond SC-215A can be heat cured at 280°F-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.

TYPICAL PROPERTIES

Color	Tan
Solids, by Weight %	14% - 16%
Solvent Formulation	Acetone / MEK
Viscosity, Brookfield, CPS	100 – 125
Pounds Per Gallon @77°F (25°C)	7.01
Shelf Life	12 Months