

Solvent-Based Products

## Thixon® 715-1/715C

### Typical Use:

Thixon 715-1/715C is a very economical one-coat, two-component vulcanizing adhesive for bonding nitrile, polyacrylate and polyurethane elastomers to metal.

### \*Typical Physical Properties as manufactured

Property		ASTM Method
Color	Amber	
Viscosity, Zahn #2	14 seconds	D-1084-88-D
Viscosity, Brookfield #1 spindle at 100 RPM	20cps	D-1084
Non-volatile solids by weight	30%	D-2369 †
Spec. Gravity	0.90	D-1475
Wgt per Gal	7.5lbs	D-1475
Flash Point (Seta)	59°F	
Cure temp range	260 to 400°F	
Shelf life unopened stored at 78°F	12 months	

† Modified to internal Rohm and Haas method

\*These properties are typical and are not to be used for specification purposes.

Shelf life of Thixon 715-1/715 mixture:

Refrigerated ..... 3 months

Room temperature..... 1 month

Store the mixed adhesive in lined cans.

### Directions for Use:

#### Mixing and Diluting:

First mix Thixon 715-1 with a high-speed propeller-type agitator. Then add the pre-measured packet of Thixon 715C powder while stirring constantly. Stir the mixture until the powder is completely dissolved.

### Preparing the Surfaces:

Properly preparing the metal is the most important factor in obtaining consistent, high quality bonds. First remove contaminants by alkaline cleaning or solvent degreasing. Then gritblast the metal surfaces with #40 or #50 grit, and solvent degrease again.

**Diluent** - Use a mixture of 1 part MEK and 1 part methanol as the diluent, or use either MEK or methanol.

### Applying the Adhesive

Thixon 715-1/715C can be applied by brushing, dipping or spraying.

**Brush** - For brush applications, apply undiluted.

**Dip** - Dilute 3 to 4 parts Thixon 715-1/715C blend with 1 part diluent.

**Conventional Air Spray** - Dilute 2 parts Thixon 715-1/715C with 1 part diluent for a viscosity of 29 sec. #1 G.E. Zahn cup.

### Drying the Film:

Thoroughly dry the film of Thixon 715-1/715C, approximately 30 minutes at room temperature. The drying time can be shortened by force drying 5 minutes at 180°F.

### Oven Prebaking:

To keep the adhesive from sweeping during transfer and injection molding, prebake the adhesive-coated insert for 10 to 20 minutes at 300°F. The color of the adhesive will change from amber to golden brown.

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### Theoretical Coverage:

One gallon of Thixon 715-1/715C applied at 0.2 mil dry film thickness will cover approximately 1,845 square feet.

### Toxicity and Safety Information

***Read the Material Safety Data Sheet before using this material.*** Keep flammable material away from heat, sparks and open flame. When pouring flammable material, ground both containers to avoid static discharge (sparking) which could ignite solvents. Do not allow free fall of more than a few inches which could also generate static charges.

Breathing vapors for a prolonged period of time is harmful. Ventilation systems in compliance with applicable local, state, and federal regulations must be used. Repeated contact may cause skin irritation. This material may be harmful or fatal if swallowed. If swallowed, induce vomiting and call a physician.

### Storage & Handling Information

***Read the Material Safety Data Sheet, Section 7, for the safe handling and storage of the product.*** Store in a cool, dry, well-ventilated area away from heat, ignition sources and direct sunlight. Keep containers tightly closed. Containers should be supported and grounded before opening, dispensing, mixing, pouring and emptying.

For questions regarding the handling of empty containers or dry film with respect to the hazardous waste regulations, we suggest you contact the RCRA Hotline sponsored by US EPA at 1-800-424-9346 or your local/state environmental agencies.

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The information contained herein is, to the best of our knowledge and belief, accurate. However, since the conditions of handling and use are beyond our control, we make no guarantee of results and assume no liability for damages incurred by following these suggestions. Nothing contained herein is to be construed as a recommendation for use in violation of any patents or of applicable laws or regulations.

Customer Service and Technical Assistance 1-800-348-8846 (West Alexandria, Ohio USA)