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# TECHNICAL DATA SHEET

## '60' DUROMETER Rapid Paste Elastomer

**ThistleBond '60 DUROMETER Rapid Paste Elastomer'** is a 60 Durometer high performance rapid curing paste grade elastomer which has been specifically developed for the repair of rubber components by trowel or putty knife and is suitable for use on impellers, chutes, hoppers, valves, rollers, gaskets, hoses, conveyor belts, off road tyres etc.

**ThistleBond '60 DUROMETER Rapid Paste Elastomer'** is based on a complex blend of polyols and polyesters in combination with amine catalysts and activators to produce a cold vulcanising product with outstanding mechanical strength.

The properties of **ThistleBond '60 DUROMETER Rapid Paste Elastomer'** have been designed to match factory produced rubbers.

**Before proceeding, please read the following information carefully to ensure that the correct application procedure is fully understood.**

### SURFACE PREPARATION

All existing dirt, oil and grease should be removed and the surface wiped with **ThistleBond 'Cleaner'**.

Any areas of frayed or fragmented rubber should be cut away to provide a sound repair area.

Smooth surfaces, including metals, should be mechanically etched to produce a good profile, with abrasive blasting being preferred for metal substrates. Rubber surfaces are best roughened using a stiff wire brush / comb.

Edges of repair areas of belts, hoses, tyres etc. should be undercut.

All loose dust and particles should be blown clear of the prepared surface.

On certain repairs such as gaskets and castings where one surface is not required to bond to the **ThistleBond '60 DUROMETER Rapid Paste Elastomer'**, these surfaces should be treated with **ThistleBond 'Release Agent'**.

### PRIMING

All areas to be repaired or resurfaced should be first primed with **ThistleBond 'Elastomer Primer'**.

**ThistleBond 'Elastomer Primer'** is supplied as a two component product comprising 100 gm of primer in a cone topped tin and a small glass bottle of catalyst.

The contents of the catalyst bottle should be added to the primer container immediately prior to use and the container should then be shaken to ensure complete mixing is achieved.

After use the container should be resealed, taking care not to contaminate the contents, this resealed **ThistleBond '60 DUROMETER Rapid Paste Elastomer'** will have a limited shelf life of up to 3 months.

The primer should be applied with a soft bristled brush to give an even, but low coating thickness, taking care to avoid ponding of the primer.

The primer should be allowed a minimum of 10 minutes and a maximum of 1 hour at 20°C (68°F) before applying the **ThistleBond '60 DUROMETER Rapid Paste Elastomer'**

### MIXING

**ThistleBond '60 DUROMETER Rapid Paste Elastomer'** is a two component material which must be mixed together prior to use.

Two volumes of resin and one volume of hardener should be measured onto a clean surface and the two components mixed thoroughly to produce a smooth streak free material.

Thorough mixing is extremely important, and once the material appears mixed, a further period of mixing should be carried out to ensure there is not unmixed material.

The mixed material should be used within 10 minutes of mixing at 20°C (68°F).

## APPLICATION

The mixed material should be pressed firmly onto the prepared area working the product into cracks or defects on the surface. Where necessary, reinforcement tape should be bedded into the material and overlapped to provide multi-layer reinforcement.

All equipment must be cleaned IMMEDIATELY after use with **ThistleBond 'Cleaner'**.

### Volume Capacity

900cc (54.8 cu ins) per kilo

## PHYSICAL CONSTANTS

Mixing Ratio	Resin	Hardener	
	2	1	By volume
	2	1	By weight

Appearance	Resin	Hardener
	Resin	Opaque Straw Paste
	Hardener	Coloured Paste

### Drying & Cure times at

20°C (68°F)	Usable Life	10 minutes
	Initial Set	30 minutes
	Machining	1 hour
	Full Mechanical	24 hours

Volume Solids	100%
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V.O.C.	Nil
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**Shelf Life** Use within 12 months of purchase. Store in original sealed containers at temperatures between 5°C (40°F) and 30°C (86°F)

### Operating Temperature

	Maximum	Continuous
Dry Heat	120°C (250°F)	80°C (176°F)
Wet Heat	80°C (175°F)	50°C (122°F)

FOR FURTHER INFORMATION PLEASE CONTACT

## PHYSICAL PROPERTIES

<b>Tensile Strength</b> ASTM D412	70 kg/cm <sup>2</sup> (1000 psi)
<b>Tear Strength</b> ASTM D624	36 kg/cm (200 pli)
<b>Elongation</b> ASTM D412	800%
<b>Shore A Hardness</b> ASTM D2240	60
<b>Peel Adhesion (concrete and steel)</b> ASTM D903	9 kg/cm (50 pli) - cohesive failure in Flexi-Tech
<b>Dielectric Strength</b> ASTM D149	16 volts/micron (400 volts/mil)

## HEALTH AND SAFETY

As long as normal good practice is observed **ThistleBond '60 DUROMETER Rapid Paste Elastomer'** can be safely used.

Protective gloves should be worn.

A fully detailed **Material Safety Data Sheet** is either included with the material or is available on request.

## PACKAGING

Supplied in 0.125kg sachets.

The information provided in this Product Data Sheet is intended as a general guide only and should not be used for specification purposes. The information is given in good faith but we assume no responsibility for the use made of the product or this information because this is outside the control of the company. Users should determine the suitability of the product for their own particular purposes by their own tests. Detailed specifications are available on request from the company.



[www.thistlebond.com](http://www.thistlebond.com)

ThistleBond Division of E. Wood Ltd.  
Standard Way, Northallerton,  
N. Yorks. U.K. DL6 2XA  
Tel: +44(0)1609 780170  
Fax: +44(0)1609 780438 & 777905