

# germanBond® 4kR

**Uses:** 2 component contact adhesive free of chlorinated hydrocarbon and aromates for cold bonding of conveyor rubber belts, rubber linings, friction laggings for pulleys and rollers as well as for the permanent-elastic and high-strength bonding of rubber, fabrics, leather, polyurethane and other materials.

**Specifications:**

Base:	polychloroprene (CR)
Solvent :	ethyle acetate, cyclohexane
Colour:	black
Spissitude:	approx. 0.85 g/cm <sup>3</sup>
Hardener:	<b>germanBond® RE or germanBond® AR</b>
Diluent/Cleaner:	<b>germanBond® CLR</b>
Application:	brush, spatula
Application quantity:	approx. 150 g/m <sup>2</sup> per coat
Flash-off time:	approx. 10 min (20°C)
Pot life:	approx. 2 h (20°C)
Hazardous material designation:	highly inflammable (F), harmful (Xn), dangerous for environment (N)
Shelf life:	<b>germanBond® 4kR adhesive:</b> minimum of 24 months <b>germanBond® RE hardener or germanBond® AR:</b> minimum of 12 months
Storage requirements:	dry, cool, free of frost, in tightly closed buckets

**Using the product:**

**1. Surface preparation:**

**Rubber:** The bonding surfaces must be completely clean, dry, and free from grease and oil. Buff surface by using abrasive disc or similar, remove all shiny areas. Completely remove all dust particles. In case of rubber with buffing is not necessary, but clean CN backing in any case using fast evaporating solvent.

**Metal:** The metal surfaces must be totally clean, dry, and free from grease and oil. Sand- or shotblast the metal surface to a roughness of Rz 90 - 140, remove dust and wash with fast evaporating solvent (**Cleaner germanBond® CLR**). For maximum adhesion use imperatively **metal primer germanBond® MP**, apply one thin coat on pretreated metal surface and let dry completely (appr. 30 min).

**2. Mixing the components:**

**Mixing ratio:** adhesive **germanBond® 4kR**: hardener **germanBond® RE/germanBond® AR** = 100:5.  
Mix thoroughly (2-3 min). Max. Handling time of mixed product is up to 2 hours in covered/closed buckets.

**3. Applying the product:**

2-3 coats are necessary. CN backing only need 1 coat. Apply the first thin and even coat to both bonding surfaces using a paint roller or brush, and allow drying completely (min. 30 min). Apply last thin and even coat on both surfaces, and allow drying until slightly tacky (appr. 10 min), checking with back of finger nail. If too dry by false timing, apply third coat.

**4. Joining:** Join bonding surfaces together by applying strong and short contact pressure (e.g. using hammer, manual or pneumatic, with rubber head, rollers etc.). Adhesion surfaces must have 100% contacts with each other.

**Warning:** The adhesive swells at low temperature (< 0°C) but is fit for use again when warmed up at normal room temperature! In case of bad weather conditions such as cold, rain and heavy sun, normal working conditions have to be restored by means of protections such as a provisory roof, hot air supply etc.

**Operator's protection:** Take note of the danger warnings and follow the security advice on the packaging! Request the "Security Data sheet"!

**Packing units:** 650 g tin, 4 kg tin, 24 kg barrel, 170 kg barrel

Important notice: This product information sheet is the result of extensive research and engineering experience. All information is given to the best of our knowledge. The information contained herein does not constitute a product promise and does not exempt the user from carrying out his own tests prior to applying the product for his special uses. The advice contained in this product information is given without the manufacturer accepting any liability for damages or legal claims of any kind. All information is subject to changes through technical innovation. 11/2018

germanBelt GmbH  
Carl-Vollrath-Str. 8  
D-07422 Bad Blankenburg, Germany  
Tel.: +49 36741/5680-0, Fax: +49 36741/5680-70  
E-Mail: sales@germanbelt.com www.germanbelt.com

**germanBelt®**