



# Product Data Sheet

## Ray-bond™ R85014 Coating and Bonding Aid

### PRODUCT DESCRIPTION

Ray-bond™ R85014 coating and bonding aid is a resin solution designed as protective coating to be used in conjunction with another binder system. It is highly recommended as a protective coating and bonding aid and is compatible with other phenolic and nitrile phenolic adhesives.

Its greatest usage is for coating clutch plates and brake shoes where the main bonding adhesive is applied to the friction material. In such instances, this coating prevents rusting of the metal parts and aids in the wetting of the metallic member during the bonding operation.

### METHOD OF APPLICATION

Spray or dip - other grades available for other application methods.

### TYPICAL PROPERTIES

Solids (1 hour @ 135°C, 275°F)	23% to 25%
Wt/Gal	7.5 lbs. approximately
Flash point (closed cup)	48°F (8.9°C)
Storage life, 40°F - 60°F (4 - 16°C)	90 days maximum
Storage life, 60°F - 80°F (16 - 27°C)	45 days maximum
Color	Amber

### CURE

Complete cures will be obtained with either of the following cycles:

300°F for 10 minutes or 350°F for 5 minutes

### INSTRUCTIONS

1. Surfaces to be coated must be free of rust, grease, or any similar foreign matter.
2. Apply R85014 via spraying, brushing or dipping.
3. Allow to dry at normal ambient room temperature.
4. Assemble with mating parts and cure.
5. The cure cycle should be suitable to cure both the R85014 and whatever adhesive is used for bonding the parts. The pressure should be sufficient to bring the surfaces into intimate contact. The normal working range is 50 -250 psi (0.34 - 1.7 mPa).



## ***Ray-bond™ R85014 Liquid Adhesive (cont.)***

### **STORAGE**

If stored at normal room temperature (77°F, 25°C). R85014 will have usable life range of 45 days. Refrigeration between 45 - 60°F (7°C - 16°C) will extend the life to 90 days.

### **FREIGHT CLASSIFICATION**

Adhesive, Red Label, UN1133

### **IMPORTANT NOTICE**

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