



ADHESIVE SELECTION GUIDE

Product #	R-81005	R-81008	R-81816	R-81817	R-81824	R-84017	R-84048	R-85014
Type:	Nitrile Phenolic Thermosetting Adhesive	Nitrile Phenolic Thermosetting Adhesive	Nitrile Phenolic Thermosetting Adhesive	Nitrile Phenolic Thermosetting Adhesive	Nitrile Phenolic Thermosetting Adhesive	Phenolic Thermosetting Adhesive	Phenolic Thermosetting Adhesive	Phenolic Thermosetting Adhesive
Color:	Black	Black	Black	Black	Black	Amber	Amber	Amber
Recommended Usage:	Friction material, rubber, plastics to metal	Friction material to metal	Friction material to metal	Friction material to metal	Friction mat. to metal & friction mat.	Friction material to metal	Friction material to metal	Protective coat & bonding aid
Application Method:	Knife spread, roll coat, brush, spray	Knife spread, roll coat, brush, spray	Roll coat, brush, extrusion	Roll coat, brush, extrusion	Roll coat, brush, extrusion	Brush, spray, or dip	Roll coat, or brush	Spray or dip
Solids %:	27-31	34-40	28.5-30	28.5-30	26-30	32-36	52-55	23-25
WT/Gal:	8.2 lbs.	8.2 lbs.	7.6 lbs.	7.6 lbs.	7.6 lbs.	7.7 lbs.	8.4 lbs.	7.5 lbs.
Viscosity 25°C (77°F):	3500-4500 (cps)	14000-24000 (cps)	1700-2200 (cps)	1700-2200 (cps)	1400-1900 (cps)	34-54 (cps)	3800-4800 (cps)	N/A
Chemically Resistant to:	Brake fluid, oils, water	Brake fluid, oils, water	Brake fluid, oils, water	Brake fluid, oils, water	Brake fluid, oils, water	Brake fluid, oils, water	Brake fluid, oils, water	Brake fluid, oils, water
RM Temp. psi:	1750	1750	1750	1750	2300	1850	2000	N/A
400°F psi:	600	600	600	600	600	1500	600	N/A
Flash Point:	37°F	40°F	37°F	37°F	37zzz°F	66°F	71°F	48°F
Shelf Life 45°F:	90 days	60 days	45 days	45 days	90 days	180 days	90 days	90 days
Shelf Life 70°F:	45 days	days	30 days	30 days	45 days	45 da	30 days	45 days