

Bonding Rubbers

	Maximum Hardness (Shore A)	Maximum Elongation	Critical Surface Tension (dynes/cm)	Loctbond Adhesive Solution
Butyl Rubber (IIR)	80	800%	32	CA
Chlorosulfonated Polyethylene (CSM)	ND	ND	ND	CA
Copolyester TPE	ND	ND	ND	CA, UV
Epichlorohydrin Rubber (CO, ECO, GCO, GECO)	ND	ND	ND	CA, UV
Ethylene Acrylic Rubber (EEA)	ND	ND	ND	Primer 7701 + CA
Ethylene Propylene Rubber (EPM, EPDM)	90	600%	32.5	Flexible CA
Ethylene-Vinyl Acetate Copolymer (EVA)	ND	ND	ND	Primer 7701 + CA, UV
Fluorocarbon Rubber (FKM)	95	300%	31	Flexible CA, UV
Fluorosilicone Rubber (FVMQ)	80	600%	24	Primer7701 + CA
Halogenated Butyl Rubber (BIIR, CIIR)	ND	ND	ND	CA, Flexible CA
Hydrogenated Nitrile Rubber (H-NBR, HSN)	90	340%	35	CA, UV
Melt Processible Rubber (MPR)	ND	ND	ND	CA, UV
Natural Rubber (NR)	90	700%	32	CA
Neoprene Rubber (CR)	90	600%	31	CA, Flexible CA
Nitrile Rubber (NBR, XNBR)	90	600%	33	CA, Flexible CA, UV
Polyacrylate Rubber (ACM)	90	600%	37	CA, Flexible CA, UV
Polyisoprene Rubber (IR)	90	700%	31	CA, Flexible CA
Polyolefin Elastomers (POE)	ND	ND	ND	CA, UV
Poly(propylene oxide) Rubber (GPO)	ND	ND	ND	CA, Flexible CA, UV
Polysulfide Rubber (TM)	ND	ND	ND	CA, Flexible CA, UV
Silicone-Modified EPDM	85	600%	90	CA, Flexible CA, UV
Silicone Rubber (MQ, VMQ, PMQ, PVMQ)	80	800%	24	Primer 7701 + CA
Styrene-Butadiene Rubber (SBR)	90	600%	29	CA, Flexible CA
Styrenic TPE (S-B-S, S-I-S, S-EB-S)	ND	ND	ND	CA, UV
Thermoplastic Vulcanizates (TPV)	ND	ND	ND	Primer 7701 + CA

ND

ND - Stand for " No Data"

Maximum Hardness (Shore A)

Thermoplastic Elastomers are measured in Shore A and Shore D according to ISO 868. Shore hardness is a measure of the resistance of a material to the penetration of a needle under a defined spring force. It is determined as a number from 0 to 100 on the scales A or D. The higher the number, the higher the hardness. The letter A is used for flexible types and the letter D for rigid types. Though, the ranges do overlap.

Maximum Elongation

Elongation is the change in length due to stress. Elongation is a type of deformation which refers only to the change in length of an object. Elastic deformation of rubber, is temporary and is recoverable. For example, a rubber band after stretching will return to its original length. But if the rubber band is not recoverable and become a permanent deform, the maximum elongation is determined by this length.

Critical Surface Tension (in mJ/m², or equivalents to Dynes/cm)

Generally determined by the wetting tension method (using solutions of 2-ethoxyethanol and formamide, per ASTM Std. D-2578.

Loctbond's Solutions - Choices of Adhesives & Primers

- CA - Cyanoacrylate Adhesives
- Flexible CA - Flexible Cyanoacrylate
- UV - UV Adhesives (based on methacrylate or urethane)
- Primer - Cyanoacrylate Primers

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