



The Glue People

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Tradegrip HypaBond

High performance adhesive system.

General Description

'Tradegrip HypaBond Two' is a quality, high performance polychloroprene adhesive. It can be used as either a single or two part adhesive depending on the materials to be bonded and the bond strengths required. It was developed primarily for use with Tradecure 200 curing agent to bond a range of rubbers and rubber coated fabrics (e.g. neoprene, hypalon, natural rubber, etc.) in inflatable constructions such as life rafts, dinghies, high-speed inflatable RIBs, etc. It may also be used in the manufacture of dry and wet suits for the bonding of rubber or nylon coated fabrics to themselves.

'Tradegrip HypaBond Two' may also be used as a single component adhesive in many general purpose applications for bonding materials such as Formica, Melamine and laminates to wood, metal, etc.

Not suitable for bonding plasticised PVC (unless the substrate is first primed with Tradegrip PVC) or expanded polystyrene.

Application

Surface Preparations

All substrates to be bonded should be thoroughly cleaned before bonding. Abrade surfaces using sandpaper or wire brushing followed by cleaning with Tradesolve 1 or similar to remove any grease and other contaminants liable to impair adhesion.

Application - Mixing ratio

Tradegrip HypaBond	100 parts by weight / volume
Tradecure 200	6% by weight / 3.4% by volume

Materials should be mixed thoroughly; this usually takes 3-4 minutes mixing by hand. Mixed adhesive should not be used after 4 hours.

Apply a thin, even coat of the mixed adhesive to both substrates and allow to dry thoroughly. When dry, apply a further thin coat to both substrates and allow to tack off (15 - 30) minutes depending on drying conditions. Bring surfaces together and press firmly, finishing with a hand roller to ensure an even pressure.

PVC bumpers and other fittings should be primed with Tradegrip PVC to stop plasticiser migration.

Cross linking giving full strength and durability may take up to 7 days.

General use, single part

Apply an even coat of adhesive to both surfaces to be bonded and allow to dry for 10-20 minutes; until the solvent has evaporated but the adhesive remains tacky. Bring both surfaces together and consolidate the bond by use of roller or press.

Packaging - 250ml set, 969ml set, 4.445L set.

Precautions

This type of product has been used quite safely for many years, but it is essential that the following are noted and observed.

- Keep the solution covered as much as possible; only have sufficient amount on the bench for immediate use.
- Contact between skin and eyes should be avoided – Wear gloves and goggles.
- In case of skin or eye contact irrigate affected area with plenty of clean water.
- Ensure good extraction or ventilation at point of application.
- Solvent base gives off a highly inflammable vapour; No smoking or pilot lights in the vicinity.
- Used wiping cloths should be washed in an excess of water before disposal.

Physical Data

	Tradequip HypaBond Two	Tradecure 200
Physical form	Liquid	Liquid
Colour	Off White	Pale brown
Chemical type	Polychloroprene rubber, Synthetic resin blend,	Polyisocyanate
Solvent	Mixture of hydrocarbons, Toluene and Ketones.	Dichlormethane
Viscosity (Brookfield RVT, 10rpm @ 20°C)	2400 mPas (approx.)	---
Solids content	22% (approx.)	27% (approx.)
Specific gravity	0.85(approx.)	1.3approx.)
Flammability	Highly flammable	Highly flammable
Open time	10 - 30 minutes subject to substrate conditions and length of time after addition of Tradecure 100.	
Pot life (2 component mix)	4 hours (approx.)	
Packaging	4.275 Litres 932ml 240ml	170ml 37ml 10ml
Application Temperature	10°C to 25°C	

Special comments**Storage**

Store in accordance with the requirements of The Petroleum Regulations in a flameproof area between 5°C and 25°C.

Important Notice

Data contained in this document is for information only and is believed to be reliable. Trade Grade Products Ltd (TGP) cannot assume responsibility for results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability of the product for any specific purpose and TGP is pleased to provide a sample upon request.

Before using this product ensure that you have been supplied with and have read carefully the following information.

- < The hazard label (complying with latest CDG/CPL regulations) applied to the container.
- < Material Safety Data Sheets, Tradequip HypaBond and Tradecure 200.