



ADHESIVE SELECTION GUIDE

| Product # | R-81005 | R-81816 | R-84017 | R-84048 | R-85014 |
|--------------------------|---|---|---------------------------------|---------------------------------|---------------------------------|
| Type: | Nitrile Phenolic Thermosetting Adhesive | Nitrile Phenolic Thermosetting Adhesive | Phenolic Thermosetting Adhesive | Phenolic Thermosetting Adhesive | Phenolic Thermosetting Adhesive |
| Color: | Black | Black | Amber | Amber | Amber |
| Recommended Usage: | Friction material to metal | Friction material to metal | Friction material to metal | Friction material to metal | Protective coat & bonding aid |
| Application Method: | Knife spread, roll coat, brush, spray | Roll coat, brush, extrusion | Brush, spray, or dip | Roll coat, or brush | Spray or dip |
| Solids %: | 27-31 | 28.5-30 | 32-36 | 52-55 | 23-25 |
| WT/Gal: | 8.2 lbs. | 7.6 lbs. | 7.7 lbs. | 8.4 lbs. | 7.5 lbs. |
| Viscosity 25 °C (77 °F): | 3500-4500 (cps) | 1700-2200 (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 |
| RM Temp. psi: | 1750 | 1750 | 1850 | 2000 | N/A |
| 400 °F psi: | 600 | 600 | 1500 | 600 | N/A |
| Flash Point: | 37 °F | 37 °F | 66 °F | 71 °F | 48 °F |
| Shelf Life 45 °F: | 90 days | 45 days | 180 days | 90 days | 90 days |
| Shelf Life 70 °F: | 45 days | 30 days | 45 days | 30 days | 45 days |