



**ENGINEERED SOLUTIONS**



# THERMOSETTING ADHESIVES

Raybestos® Powertrain's OEM-quality Ray-Bond™ friction bonding adhesives stay strong in high temperatures with high shear strength – and they have a virtually unlimited range of uses and applications. From torque converter pressure plates to friction plates to electrical connectors, we have the dependable adhesive solution you need. Each type of Ray-bond friction bonding adhesive is available in convenient 1 quart, 5 gallon and 50 gallon sizes.

**RECOMMENDED USE:**

Torque converter pressure plates, transmission bands, friction plates, brake bands, brake shoes and pads, electrical connectors, military applications



**WITHSTANDS HIGH TEMPERATURES**



**OEM QUALITY BONDING**



**HIGH SHEAR STRENGTH**



**LARGE RANGE OF APPLICATIONS**



**INDUSTRY VERSATILE**



# 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