

# RUBBOND HM 65

## TECHNICAL DATA SHEET

**Issue No**  
002/02

**Revision Date**  
17.07.2018

**Product - Trade Name**

RUBBOND HM65

**Classification**

Dry Bonding Agents - Methylene Donor  
Adhesion Promoter

**Composition**

65% of Hexa Methoxy Methyl Melamine (HMMM)  
Coated with Silica  
Melamine Formaldehyde Resin  
Methylated Melamine Formaldehyde Resin  
Modified Melamine Formaldehyde Resin

**Physical properties**

Form : Free flowing powder.  
Sp. Gr. @ 25°C : 1.41 +/- 0.05

**Chemical properties**

HMMM content		%	65 ± 1
Ash content	(850°C/ 1hr)	%	33 ± 2
Moisture Content	(Karl Fisher)	%	4.0 max
Loss on Drying	(105°C/hr)	%	5.0 max
Free Formaldehyde		%	0.1 max
Sieve Residue (Wet)	(100 mesh)	%	0.1 max

**Solubility**

Alcohol : Partly soluble  
Petroleum Ether : Partly soluble  
Water : Insoluble

**Processing behavior**

It is safe in processing both non-black & black reinforced compounds.

**Recommended dosage**

RUBBOND HM72 : 4 – 5 phr  
Resorcinol Donor : 3 – 4.5 phr

**Advantages**

- Easy Handling
- Easy Dispersion in compound
- Non corrosive effects on coated steel
- Non dusting
- Scorch protection higher than HMT

- Non toxic and no skin irritation
- Principally used as a component of Dry Bonding Agent. It is recommended for use in final mix in case of two stage mixing.

**Application**

RUBBOND HM65 has been successfully designed to meet the stringent needs of cord-rubber properties of tyre and non - tyre industries. It offers a balanced combination of good adhesion and excellent fatigue resistance in conjunction with Methylene acceptors like RUBBOND RSA / RUBBOND RS / RF Resin through formation of an in-situ resin. The recommended dosage above shows the level for initial evaluations.

**Handling precautions**

Irritating to the eyes, respiratory system and skin. Avoid contact with eyes, skin and clothing. Wash thoroughly after handling.  
Refer MSDS for complete details

**Packaging**

25 kg in HDPE laminated paper bag / Jumbo bag.

**Storage properties**

Stable for one year, when stored tightly at normal room temperature.

**Shelf Life**

12 months from the date of manufacturing.

**Note:**

Information in this publication is believed to be accurate and is given in good faith, but it is for the customer to satisfy itself of the suitability for its own particular purpose. RCPL gives no warranty as to the fitness of the product for any particular purpose and any implied warranty or condition (statutory or otherwise) is excluded except to the extent that law prevents such exclusion.

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