

# RUBBOND HM 650

## TECHNICAL DATA SHEET

**Issue No**  
002/02

**Revision Date**  
17.07.2018

**Product - Trade Name**

RUBBOND HM650

- Scorch protection higher than HMT
- Non toxic and no skin irritation

**Classification**

Dry Bonding Agents - Methylene Donor  
Adhesion Promoter

Principally used as a component of Dry Bonding Agent. It is recommended for use in final mix in case of two stage mixing.

**Composition**

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

**Application**

RUBBOND HM650 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 TECHNIC B19S / B20S through formation of an in-situ resin. The recommended dosage above shows the level for initial evaluations.

**Physical properties**

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

**Handling precautions**

Irritating to the eyes, respiratory system and skin. Avoid contact with eyes, skin and clothing. Wash thoroughly after handling.

**Chemical properties**

HMMM content		%	65 ± 1
Ash content	(850°C/ 1hr)	%	28 ± 2
Moisture Content	(Karl Fisher)	%	4.0 max
Loss Of Drying	(105°C/hr)	%	5.0 max
Free Formaldehyde		%	0.1 max
Sieve Residue	(100 mesh)	%	0.1 max
Oil Content		%	5 ± 0.5

**Packaging**

25 kg in HDPE laminated paper bag / Jumbo bag.

**Storage properties**

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

**Solubility**

Alcohol : Partly soluble  
Pet. Ether : Partly soluble  
Water : Insoluble

**Shelf Life**

12 months from the date of manufacturing.

**Processing behavior**

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

**Recommended Dosage**

RUBBOND HM650 : 4 – 5 Phr  
RUBBOND RSA (Resorcinol Dispersions) : 3.5– 4 Phr  
TECHNIC RF Resin : 4 – 5 Phr

**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.

**Advantages**

- Easy Handling
- Easy Dispersion in compound
- Non corrosive effects on coated steel
- Non dusting

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