

# RUBBOND<sup>®</sup> HM 65

## TECHNICAL DATA SHEET

**Issue No**  
**002/04**

**Revision Date**  
**01.10.2022**

**Product - Trade Name**

RUBBOND<sup>®</sup> 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<sup>®</sup> HM65 : 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<sup>®</sup> 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<sup>®</sup> RSA / RUBBOND<sup>®</sup> 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

**REACH Compliance:**

Material is meeting the REACH compliance.

**Packaging**

25 kg in HDPE laminated paper bag / Jumbo bag.

**Storage**

Stable for one year, when stored at ambient temperature in original sealed container & in well ventilated place

**Shelf Life**

1 year 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.

**RAJSHA CHEMICALS PRIVATE LIMITED**

[www.twc.in](http://www.twc.in)

**Works:**

Block No.: 637, Lamdapura Road, At. Manjusr  
PO: Lamdapura, Ta: Savli, Dist. Vadodara 391 775, India  
Tel – +91 9662049271  
Email – [office@rajsha.com](mailto:office@rajsha.com)

**TWC Group, Corporate Office:**

Hi Tech Chambers, 5<sup>th</sup> Floor , 84/1B Topsia Road (S)  
Kolkata 700 046, India  
Tel – +91 33 2285 1278 / 1279. Fax - +91 33 2285 1280  
E mail – [info@twc.in](mailto:info@twc.in)