

# RUBBOND<sup>®</sup> HM 100

## TECHNICAL DATA SHEET

**Issue /Revision No**  
**003/05**

**Revision Date**  
**01.12.2025**

**Product - Trade Name**  
RUBBOND<sup>®</sup> HM100

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

**Classification**

Dry Bonding Agents – METHYLENE DONOR  
Adhesion Promoter

**Application**

RUBBOND<sup>®</sup> HM100 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.

**Composition**

Hexa Methoxy Methyl Melamine  
Melamine Formaldehyde Resin  
Methylated Melamine Formaldehyde Resin  
Modified Melamine Formaldehyde Resin

**Physical properties:**

Parameter	Specification
Physical Form	Clear Liquid

**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

**Chemical properties:**

Parameter	Specification	Test Method
Sp. Gr. @ 25°C	1.20±0.05	D1298
Total Solids, %	98 Min	D4903
Moisture content (Karl Fischer), %	2.0 Max	E203
Refractive Index, 20°C	1.510-1.530	D1218
Free Formaldehyde, %	0.2 Max.	ISO11402 / D1979
Nitrogen Content	21.5-24.0	D3533
Brookfield Viscosity at 23 °C, cps	2500-6500	D1417
Viscosity (Ford cup B4, @25°C), Sec.	250-650	T-27A

**REACH Compliance:**

Material is meeting the REACH compliance.

**Packaging**

200 /225/240 kgs in MS/HDPE drums/1200 Kgs IBC

**Storage properties**

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

**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<sup>®</sup> HM100      2 – 3 Phr  
Resorcinol Donor      3 – 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.  
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
- Noncorrosive effects on coated steel
- Non dusting
- Scorch protection higher than HMT
- Non-toxic and no skin irritation

### RAJSHA CHEMICALS PRIVATE LIMITED

**Plant:**

Block No.: 637 & 634P7, Lamdapura Road, At. Manjusar  
PO: Lamdapura Road, Ta: Savli,  
Dist.: Vadodara, Gujarat, INDIA, PIN Code: 391 775  
Tel – +91 9662049271  
Email – [office@rajsha.com](mailto:office@rajsha.com)

**TWC Group, Corporate Office:**

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