

RUBBOND® HM 50

TECHNICAL DATA SHEET

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01.12.2025

Product - Trade Name
RUBBOND® HM50

Classification

Dry Bonding Agents – Methylene Donor
Adhesion Promoter

Composition

50% of Hexa Methoxy Methyl Melamine (HMMM)
Coated with Silica
Melamine Formaldehyde Resin
Methylated Melamine Formaldehyde Resin
Modified Melamine Formaldehyde Resin

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.

Physical properties:

Parameter	Specification
Physical Form	Free flowing powder

Chemical properties:

Parameters	Specification	Test Method
Sp. Gravity @ 25°C	1.41±0.05	D1817
HMMM content, %	50 ± 1	RCPL T-14
Ash Content, @ 850°C, 1hr, %	45±2	D4574
Moisture Content, % (Karl Fischer)	4.0 Max	D6304/E203
Loss On Drying, % @105°C, 1hr.	5.0 Max	D4571
Free Formaldehyde, %	0.10 Max	ISO11402/D1979
Sieve Residue on 100 Mesh -Wet, %	0.10 Max	D5461
Nitrogen content, %	11.6±0.5	D3533/T26 (SM)

Application

RUBBOND® HM50 has been successfully designed to meet the stringent needs of cord-rubber properties of tire and non - tire industries. It offers a balanced combination of good adhesion and excellent fatigue resistance in conjunction with Methylene acceptors like RUBBOND®/TECHNIC B19S/B20S 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.

Storage properties

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

Shelf Life

12 months from the date of manufacturing.

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® HM50 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.

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