




# POLYURETHANE-TO-METAL CILBOND® SELECTOR GUIDE

Solvent-Based



Solvent-Based	Color	Cold Cast PU Dry Environments		Cold Cast PU Wet Environments		Hot Cast PU Dry Environments		Hot Cast PU Wet Environments		NDI systems e.g. Vulkollan®	TPU	Mildable PU NCO Cured	Mildable PU SI Preoxide Cured	Heat Resistance	Boiling Water Resistance hours	Salt Spray Testing hours @ <math>3.4\text{ mm}</math>	Maximum Pre-bake Resistance
		✓✓✓	✓✓	✓✓	✓	✓✓	✓	✓✓	✓								
<b>Cilbond 41</b>	Clear to Yellowish	✓✓✓	✓✓	✓	✓									120 °C	300 h	400 h	2 h @ 95 °C
<b>Cilbond 41 + Cilcure B</b>	Clear to Yellowish	✓✓✓	✓✓✓	✓	✓									140 °C	400 h	700 h	1 h @ 105 °C
<b>Cilbond 48</b>	Clear	✓✓	✓✓	✓✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓			150 °C	400 h	700 h	48 h @ 100 °C or 24 h @ 110 °C or 16 h @ 130 °C
<b>Cilbond 48 + Cilcure B</b>	Clear	✓✓	✓✓	✓✓✓	✓✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓			180 °C	500 h	700 h	30 Min @ 105 °C
<b>Cilbond 49SF</b>	Red			✓✓✓	✓✓	✓✓✓	✓✓	✓✓	✓✓	✓✓	✓✓			130 °C	350 h	450 h	48 h @ 100 °C or 24 h @ 110 °C or 16 h @ 130 °C
<b>Cilbond 49SF + Cilcure B</b>	Red			✓✓✓	✓✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓			180 °C	500 h	700 h	30 Min @ 105 °C
<b>Cilbond 12E / 80ET</b>	Grey / Black											✓✓✓		180 °C	100 h +	500 h	15 Min @ 160 °C
<b>Cilbond 89ET</b>	Black											✓✓✓		170 °C	100 h +	300 h	15 Min @ 160 °C

-  Recommended
-  Highly recommended
-  Used regularly for the application

### Notes on Environmental Test Information

Heat Resistance: The highest temperature whilst achieving  $\geq 90\%$  failure within the PU.  
 Boiling Water Testing: No Rubber-Cement or Cement-Metal fail : Test halted at 1000 hours (1000 hours means no observed failure).  
 Salt-Spray Resistance: DIN/ISO 9227 2006; time to show <math><4\text{ mm}</math> edge failure with PU bonded parts  
 Pre-Bake Resistance: A typical maximum time parts can be heated, pre-bake resistance is also PU dependent.

For more information, see the Cilbond Product Technical Data Sheets.

Cilbond 49SF is recommended by Bayer Material Sciences for Vulkollan® bonding

[Learn more about these products and others at hbfuller.com/cilbond](https://www.hbfuller.com/cilbond)

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