

# RUBBER-TO-METAL BONDING CILBOND® SELECTOR GUIDE

Solvent-Based



Solvent-Based		ACM	Vamac® G series	Vamac® DP series	BR / IR	IR, Halo IIR	CR	CSM / ACSM	CPE	ECO	EPDM	NR High Sulphur	NR Low Sulphur	SBR	NBR	XNBR	HNBR	VMQ	FVMQ	FKM / FFKM Peroxide Cured	FKM Biochemical / Resin Cure	Heat resistance max. temperature for 48 hrs	Boiling water resistance	Glycol resistance hours @ 160 °C	Salt Spray Testing hours to 2.5 mm	Pre-Bake Resistance minutes @ 160 °C	
ONE-COAT	Cilbond 10E	✓✓✓	✓✓	✓✓					✓✓✓					✓✓✓	✓✓✓	✓✓						170 °C	60 h	100 h	600 h	30 m	
	Cilbond 24	✓✓	✓✓		✓✓	✓✓✓	✓✓✓	✓✓	✓		✓✓✓	✓✓✓	✓✓✓		✓✓	✓							180 °C	100 h	1000 h	500 h	30 m
	Cilbond 26	✓✓✓	✓✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓		✓✓✓	✓✓✓	✓✓✓		✓✓	✓							220 °C	100 h	1000 h	1000 h	30 m
	Cilbond 89ET*	✓✓	✓	✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓✓	✓✓	✓✓	✓✓						170 °C	20 h	200 h	300 h	10-15 m
TWO-COAT	Cilbond 10E / 80ET	✓✓	✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓	✓✓	✓✓✓						170 °C	100 h	600 h	500 h	10-15 m
	Cilbond 12E / 80ET**	✓✓	✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓	✓✓	✓✓✓						180 °C	100 h	600 h	500 h	10-15 m
	Cilbond 26 / 82	✓✓	✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓						190 °C	100 h	1000 h	1000 h	10-15 m
SPECIALITIES	Cilbond 33C A+B																	✓	✓✓	✓✓✓		250 °C	100 h	1000 h	500 h	15 m	
	Cilbond 36	✓	✓✓	✓✓✓												✓✓	✓✓✓	✓✓✓	✓✓✓	✓		230 °C	100 h	600 h	400 h	20 m	

\*Using Cilbond 12E or Cilbond 26 as a primer will improve all environmental test results.  
 \*\* For roller and dipping applications, use Cilbond 10E/80ET versus Cilbond 12E/80ET for the same elastomers

✓	Can be used
✓✓	Recommended
✓✓✓	Highly recommended

### Notes on Environmental Test Information

Heat Resistance: The highest temperature when parts are heated for 48 hours, whilst achieving ≥ 90 % failure within the rubber.  
 Boiling Water Testing: No Rubber-Cement or Cement-Metal fail : Test halted at 1000 hours (1000 hours means no observed failure).  
 Hot Glycol Testing: Tests conducted at 160 °C and failure detected as blisters in bond-line and /or Cement-Metal failure  
 Salt-Spray Resistance: DIN/ISO 9227 2006; time to show <4 mm edge failure with rubber bonded parts  
 Pre-Bake Resistance: A typical maximum time parts can be heated, prior to moulding at 160°C, in minutes - pre-bake resistance is also compound dependent.

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

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

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