

# RUBBER-TO-METAL CILBOND® SELECTOR GUIDE

Water-Based



Water-Based		ACM	Vamac® G series	Vamac® DP series	BR / IR	IIR, Halo IIR	CR	CSM / ACSM	ECO	EPDM	NR High Solubur	NR Low Solubur	SBR	NBR	XNBR	HNBR	VMQ	FVMQ	FKM / FFKM Peroxide Cured	FKM Bisphenol / Bisoximino Cured	Heat resistance Max. temperature for 48 hrs	Boiling water resistance	Glycol resistance hours @ 100 °C	Salt Spray Testing hours to fail min	Pre-Bake Resistance minutes @ 160 °C	
ONE-COAT	Cilbond 62W	✓✓✓	✓✓✓			✓✓		✓						✓✓✓	✓✓	✓✓					450	100	1,000	1,000	30	
	Cilbond 72W				✓	✓	✓✓		✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓						180	1,000	1,000	500	30
TWO-COAT	Cilbond R-7296W / 72W				✓	✓	✓		✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓						180	1,000	1,000	750	30
	Cilbond R-7296W / R-7300W	✓	✓	✓	✓✓		✓✓		✓	✓✓	✓✓✓	✓✓✓	✓✓✓	✓	✓	✓						200	1,000	1,000	600	30
SPECIALTIES	Cilbond 65W																✓✓✓	✓✓	✓	✓	180	20	100	200	20	
	Cilbond R-7264W																✓✓✓	✓✓	✓✓✓	✓	210	120	200	200	90	

- ✓ 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](https://www.hbfuller.com/cilbond)



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