

PRODUCT DATA SHEET

SikaBond® R&B-210

STRUCTURAL ADHESIVE FOR RUBBER BONDING

DESCRIPTION

SikaBond® R&B-210 is a 2-part, flexible acrylic adhesive which bonds most synthetic rubbers. It is based on Sika's Acrylic Double Performance (ADP) polymer technology which provides easy and precise application.

USES

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- Designed to replace mechanical fixings such as rivets, screws or welding and hot vulcanized rubber bonding
- Repairing rubber conveyor belts
- Structural bonding of most synthetic rubbers
- Designed for dynamic and static rubber bonding applications
- Bonds different types of construction materials: rubber, metal, plastic, glass, wood, etc.
- For interior and exterior use

CHARACTERISTICS / ADVANTAGES

- Strength development within minutes after application
- Adhesion to a wide range of substrates
- High tensile strength
- Chemical resistant
- Easily mixed with dual cartridge and static mixer
- Thixotropic
- Fast curing

PRODUCT INFORMATION

Composition	Acrylic resin		
Packaging	All contents packed in a box:		
	SikaBond® R&B-210 Dual Cartridge	~250 ml	
	SikaBond® R&B Aktivator	~100 ml	
	Static Mixers (×6)		
Colour	Part A	White	(CQP* 001-1)
	Part B	Black	
	Mixed	Grey	
	*Sika Corporate Quality Procedure		
Shelf life	12 months from date of production.		
Storage conditions	The product must be stored in original, unopened and undamaged packaging in dry conditions at temperatures between +5 °C and +25 °C. Always refer to packaging.		
Density	Part A	~1,13 kg/l	(CQP 006-4)
	Part B	~1,48 kg/l	
	Part A + Part B mixed	~1,16 kg/l (calculated)	
Consistency	Thixotropic paste		

TECHNICAL INFORMATION

Shore A Hardness	~90 (+23 °C / 50 % r.h.)	(CQP 023-1)
Shore D Hardness	~50 (+23 °C / 50 % r.h.)	(CQP 023-1)
Tensile Strength	~10 N/mm ² (+23 °C / 50 % r.h.)	(CQP 023-1)
Modulus of Elasticity in Tension	~400 N/mm ² (+23 °C / 50 % r.h.)	(CQP 036-1)
Elongation at Break	~150 % (+23 °C / 50 % r.h.)	(CQP 036-1)
Chemical Resistance	Resistant to many chemicals. Contact Sika Technical Services for additional information.	
Glass Transition Temperature	~+65 °C	(CQP 301-2)
Service Temperature	-40 °C to +60 °C	

APPLICATION INFORMATION

Mixing Ratio	Part A : Part B = 10 : 1.3 by weight Part A : Part B = 10 : 1 by volume	
Consumption	The amount of SikaBond® R&B-210 required for the repair or bonding must be evaluated for each application.	
Layer Thickness	0,5 mm min. / 3 mm max.	
Ambient Air Temperature	+5 °C min. / +40 °C max. Minimum +3 °C above dew point temperature.	
Open Time	~30 minutes (+23 °C / 50 % r.h.)	(CQP 526-2)
Curing Time	~75 minutes (+23 °C / 50 % r.h.) Time to reach 80 % of final strength	

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

For the preparation of rubber conveyor belts, refer to the Sika Method Statement: SikaBond® R&B-210 Conveyor Belt Splicing.

MIXING

Refer to the Sika Method Statement: SikaBond® R&B-210 Conveyor Belt Splicing

APPLICATION METHOD / TOOLS

Strictly follow installation procedures as defined in method statements, application manuals and working instructions which must always be adjusted to the actual site conditions.

Specific advice on the type and function of the application gun is explained in the Sika Method Statement: SikaBond® R&B-210 Conveyor Belt Splicing.

CLEANING OF EQUIPMENT

Uncured excess material can be removed before curing with a dry wipe.

Clean all tools and application equipment with Sika® Remover-208 immediately after use. Hardened material can only be mechanically removed.

Hands and exposed skin must be washed immediately using Sika® Handclean Towel or a suitable industrial hand cleaner and water. Do not use solvents.

FURTHER INFORMATION

- Sika Method Statement: SikaBond® R&B-210 Conveyor Belt Splicing

IMPORTANT CONSIDERATIONS

Installation work must only be carried out by Sika® trained applicators experienced in this type of application.

- If product is applied in large quantities, heat is generated by an exothermic reaction. To avoid excessive temperature increases, layer thickness must not exceed 3,0 mm as stated in the layer thickness section.
- The work area used must be safe and secure, free of environmental contamination during the repair process, protected from direct sunlight and away from sources of ignition. Adequate light and ventilation must be provided.

- The precise repair techniques for each application must be established by authorised and competent personnel with experience of assessing the type of damage (abrasion, cuts, perforations, etc.) extent and suitability of the product for use.
- Tests with actual substrates and under real application conditions must be performed to ensure adhesion and material compatibility.
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BASIS OF PRODUCT DATA

All technical data stated in this Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for the exact product data and uses.

ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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PRODUCT DATA SHEET

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