

ThinkBond Adhesives Selection Recommendation

Substrate	Rubber	Cure System	Recommendation I	Recommendation II	Recommendation III
Rigid: CRS, SS, Aluminum, Cooper, Nylon, and other rigid substrate.	NR	CV, Semi-EV, EV	11HS+27MS (primer + cover coat)	11HS+24S	24S
	SBR, BR, CR, NBR	Conventional Vulcanization	11HS+27MS	11HS+24S	24S
	EPDM, IIR	Various	11HS+23-2	11HS+27MS (CV)	4S, 236 (Peroxide)
	NBR, HNBR	Peroxide	4S, 3H, 236 (clear)	9 (CV, Peroxide)	
	VMQ, FVMQ	Peroxide	4S	236 (FVMQ 1 st choice)	336
	VMQ	Platinum	1+236		
	FKM	Peroxide, Bis phenol	3H	233A/B	8
	FKM, QCM, AEM	Amine	236	3H	8
	CPU		40T, 42(low temp.), 40W(water base)	248, 249	349
TPU		42A(blue color)	42M		
Substrate	Rubber	Cure System	Recommendation I	Recommendation II	Recommendation III
Soft: Textile, Fiber, etc.	NR, SBR, BR, CR, NBR	CV	22	24S	
	VMQ, NBR, EPDM, HNBR	Peroxide	4S	24S	
	EPDM, IIR	Various	23-2	24S	

- NR: natural rubber, SBR: styrene-butadiene rubber, BR: polybutadiene rubber, CR: neoprene, NBR: nitrile rubber, IIR: butyl rubber, HNBR: hydrogenated NBR, VMQ: silicone rubber, FVMQ: fluorosilicone rubber, FKM: fluoro rubber, ACM: acrylate rubber, AEM: ethylene-acrylate rubber, CPU: castable polyurethane, TPU: thermoplastic polyurethane
- CV: conventional vulcanization, EV: efficient vulcanization

Characters of Typical ThinkBond Products

Functional	Product Name	Main Characters
Primer	11HS	General primer, gray
	12	Excellent oil, heat, glycol resistance
	10, 10C	Excellent corrosion resistance, water base primer, 10 (black), 10C (clear after curing)
Cover Coat	27MS	General cover coat, black
	24S	General cover coat, also can work as one coat, yellow
PU Bonding	40T, 42, 40W	Bond CPU, 40W is water base product
PU Bonding	42A	Bond TPU
Special Rubber	3H, 233A/B, 8	Bond FKM (suit for peroxide, bis-phenol, amine cure system) and VQM (peroxide cure system)
Special Rubber	4S, 236, 336	Bond VQM (suit for peroxide cure system, 236/336 also suit for platinum system) and AEM/AEM (amine cure system)
Special Vulcanization	8, 9	Bond NBR (sulphur cure system), HNBR (peroxide cure system) for sealing industry
Soft Substrates: Textile, Fiber, etc.	22	Textile bond with general rubber
	23-2	Both rigid and soft substrates with EPDM