



## NA-600RC COLD BOND PVC CEMENT

A two component clear translucent thermoplastic PUR cold bond adhesive designed for repairing, splicing, and fabricating PVC and polyurethane belting, parts, and sheeting. Mixed with RC-hardener, this CFC free FDA compliant adhesive is used in static and or dynamic applications and cures at room temperature. Heat activation is possible. Used without the aid of heat, pressure, or special equipment.



*The direction for the use of our products are based upon tests believed to be reliable but no warranty is given. Since conditions for the use of this product are beyond the Seller's control, all risks are assumed by the user. Please Contact your local Agent or Call Normac Inc. (905) 332 6455 for further assistance.*

### COVERAGE

Approximately 6sqm (64.5sqft) per lkg per coat by brush. One liberal even coat on each surface is required to achieve adhesion for most applications. Two coats is an option and can be tested. Surface roughness and application tools may influence coverage rates.

### POT LIFE

A three (3) hour pot life is used as a guide for mixed 600RC cement with RC-hardener at 23C (73F). The pot life and contact open time will vary depending on climate conditions which include temperature, humidity, and ventilation air.

### BOND ASSESSMENT

Optimum adhesion values are achieved with proper cleaning and adequate surface roughness. Typical values on PVC and polyurethane belting is over 500 lbs in shear strength.

### APPLICATION CONDITIONS (guide available)

Stir or shake cement with hardener for 1 minute.

**Precondition material:** +10°C (50°F)

**Ambient/surface temperature:** similar +10°C (50°F)

**Relative humidity:** < 80%

**Dew point:** > 3°C (5°F)

Protect surface from direct sunlight and contamination.

### PROPERTIES

**Colour:** Clear/ translucent

**RC hardener:** 4.5% by cement weight (100 : 4.5)

**Contact open time:** < 4 minutes

**Solids content:** 18.5%

**Consistency:** Brushable liquid

**Diluents:** Acetone, MEK, Methyl Acetate, Tert-Butyl Acetate

**Flammable**

**Flash Point:** -18C (-0.4F)

**Oil Resistance:** Excellent

**Chemical Resistance:** Usually, pH 3 to 11

**Operating Temperatures:** 45°C to 93°C (-50°F to 200°F)

**VOC's:** 77gm/L

### STORAGE

Shelf life is two (2) years when unopened and stored between 15°C to 25°C (60°F to 77°F) in a cool dry dark place away from heat, sparks, and flame. Protect from freezing.

### KIT PACKAGING

NA6RCPK.....0.375kg/ Pint/ 0.5L, includes 1 x 17g RC-hardener

NA6RCQK.....0.75kg/ Quart/ 1L, includes 1 x 34g RC-hardener

NA6RCGK.....3kg/ Gallon/ 4L, includes 4 x 34g RC-hardener

NA6RC5K.....15kg/ 5 Gallon/ 20L, includes 20 x 34g RC-hardener

NA6RC55K.....150kg/ 55 Gallon/ 200L, includes 200 x 34g RC-hardener

*Cement and hardener can be purchased separately*

### SAFETY

FOR INDUSTRIAL USE ONLY. Flammable liquid. See the NORMAC NA-600RC and RC-hardener product SDSs. Strict adherence to regional safety regulations must be practiced.