

HRJ-11331/R7522E

Description

HRJ-11331/R7522E is an oil-soluble phenolic resin made from para-tertiary butylphenol and formaldehyde that contains reactive methylol groups. This resin is most widely used in the formulation of polychloroprene contact cements that exhibit very high temperature performance and resistance to phasing.

General Product Data

Product Specifications:

Softening Point, B&R, (°C)	110 – 120
Melting Point, Capillary Tube (°F)	200 – 220
Color, Gardner, 60% Solution in Toluene	1 – 7
Gardner-Holdt Viscosity, 60 % solution	D – N
Methylol Content, (%)	10 – 14

Test Methods available upon request

Typical Properties:

Specific Gravity	1.10
Physical Form	Flake

Solubility:

HRJ-11331/R7522E is soluble in aromatic and aliphatic hydrocarbons, esters, ketones, and partially in higher alcohols.

Application

HRJ-11331/R7522E is extensively employed in the preparation of general purpose and heat-activating polychloroprene cements. It can also be used in formulating adhesives with NBR, SBR, natural and reclaimed rubbers. In polychloroprene adhesives, HRJ-11331/R7522E increases high temperature performance; increases the specific adhesion of the adhesive film to metal and glass, and increases cohesive strength of the adhesive film itself. HRJ-11331/R7522E is completely compatible with nitrile and polychloroprene rubbers. It has a compatibility limit of approximately 25 parts by weight in combination with 100 parts by weight of SBR, natural, and reclaimed rubber.

Typical Contact Cement Formula

Part A: Rubber Base:

Material	Parts by Weight
Polychloroprene AD	100
Zinc Oxide	5
Magnesium Oxide	4
Ethanox® antioxidant	2

Dissolve to 25 percent solids in solvent of choice.

Part B: Resin Pre-Reaction:

Material	Parts by Weight
HRJ-11331/R7522E	45
Magnesium Oxide	4.5
Water	2

Dissolve to 50 percent solids in solvent of choice. Agitate a minimum of three hours.

Finished Adhesive:

Add **Part B** to **Part A** with mixing to complete the formulation.

1 Product of SI Group Inc. – Ethanox® 310

Storage And Shelf Life

HRJ-11331/R7522E should be stored where temperatures do not exceed 86 °F (30 °C) for long periods of time. For best results, it is recommended that this product be used within 1 year of manufacture date. As with all phenolic resins, HRJ-11331/R7522E will become darker with age. Pallets should never be stored double stacked.

Note: Resins of this type are known to agglomerate or sinter during storage. This condition does not affect the performance of the resin in its normal application and is not considered justification for rejection or return.

Packaging

HRJ-11331/R7522E is packaged in bags at 25 kilograms net weight, stretch-wrapped on pallets.