

HIGH PERFORMANCE TRANSPORTATION ADHESIVES & SEALANTS



ROYAL
ADHESIVES & SEALANTS

SEMI TRAILERS

- Seal Exterior Frame & Corner Caps
- Roofing Sealants
- Bonding Roof Bows
- Bonding Sidewalls
- Seal Exterior / Interior Seams
- Bonding FRP Wall Panels



TOWABLE TRAILERS

- Roofing Sealants
- Sealing Vents / Roof Penetrations
- Bonding Roof Bows
- Sealing Windows & Door Frames
- Bonding Sidewalls
- Vinyl Rubber Flooring Adhesives
- Sealing Fenders



RECREATIONAL VEHICLES

Bonding Roof Bows	Roofing Sealants
Bonding Headliners	Bonding Sidewall Insulation
Bonding Interior Wall Panels	Laminating HPL Cabinet Surfaces
Bonding Sidewalls	Sealing Fenders
Sealing Windows & Door Frames	Vinyl & Rubber Flooring Adhesives



EMERGENCY VEHICLES

Bonding Headliners	Sealing Windows and Door Frames
Bonding Interior Wall Panels	Bonding Trim Pieces
Laminating HPL Cabinet Surfaces	Vinyl & Rubber Flooring Adhesives
Roofing Sealants	



SCHOOL VEHICLES

- Bonding Headliners
- Bonding Interior Wall Panels
- Vinyl & Rubber Flooring Adhesives
- Roofing Sealants



PRODUCTS SOLIDBOND™ <i>Silaprene</i> POLYURETHANE ADHESIVE/SEALANT	SOLIDSEAL™ (NON-SAG) <i>Silaprene</i> POLYURETHANE ADHESIVE/SEALANT	SOLIDSEAL™ <i>Silaprene</i> POLYURETHANE ADHESIVE/SEALANT	SOLIDSEAL® MS <i>Silaprene</i> ADHESIVE/SEALANT	NORTH AMERICA'S PREMIER™ ADHESIVE/SEALANT <i>Silaprene</i>
DESCRIPTION SOLIDBOND™ one component, high strength bonding adhesive with excellent sealant properties that provides a permanently elastic bond to most substrates. SOLIDBOND™ is a moisture cured, non sag system, specifically developed for the fabrication and repair of trailers, trucks, busses, trains, RV, utility bodies, van conversions & specialty vehicles.	SOLIDSEAL™ is a one component, 96% solids, fast cure, flexible, silicone free, rubber based, dual purpose adhesive/sealant. It is a moisture cured, non sag system. SOLIDSEAL™ provides a permanently elastic bond to most substrates without a primer.	SOLIDSEAL™ is a one component, 96% solids, fast cure, flexible, silicone free, rubber based, dual purpose adhesive/sealant. It is a moisture cured, non sag system. SOLIDSEAL™ provides a permanently elastic bond to most substrates.	SOLIDSEAL® MS is a one component, NON-YELLOWING, fast cure, high strength, industrial grade elastomeric adhesive/sealant. SOLIDSEAL® MS cures in the presence of atmospheric moisture to provide a permanently elastic bond to fasten materials, which have dissimilar coefficients of expansion. It combines the best qualities of polyurethane & silicone sealants.	North America's Premier Adhesive/Sealant is an exceptional one-part product that combines ease of application, versatility of use, high ultimate strength, permanent bonds & long service life. N.A.P. Adhesive/Sealant is a high quality, high solids elastomeric sealant that provides superior adhesion to a variety of surfaces. Bond strength improves with age.
APPLICATION DESIGNED TO BOND: <ol style="list-style-type: none"> Vehicle bodies & cab construction including panels, underbody components, roofing (metallic & FRP), front & rear spoilers, auto trim, moldings, body seams & welding joints Waterproof lap seams & molding in truck trailers, RV's & autobody repair Floor bonding, subfloor to metal cross members, butt joints & more Bedding compound for exterior accessories as well as bonding trim & all kinds of stylings A variety of general purpose joint sealing applications Replacement of rivets & mechanical fasteners 	DESIGNED TO BOND: <ol style="list-style-type: none"> Various metals, including galvanized steel & aluminum Wood, particle board and plywood Glass, concrete, masonry & rubbers Fiberglass & fiber reinforced plastics Thermoset plastics such as polyurethane, polyester, epoxies Thermoplastics, such as ABS, nylon, PVC Skylight & porthole materials Heating & air conditioning (HVAC) materials 	DESIGNED TO BOND: <ol style="list-style-type: none"> Various metals, including galvanized steel, stainless steel, cold rolled steel, & aluminum Wood, particle board and plywood Glass, concrete, masonry & rubbers Fiberglass & fiber reinforced plastics Thermoset plastics such as polyurethane, polyester, epoxies Thermoplastics, such as ABS, nylon, PVC Skylight & porthole materials Heating & air conditioning (HVAC) materials 	DESIGNED TO SEAL: SOLIDSEAL® MS has been specifically developed for sealing dynamically moving joints, such as: Expansion & control joints, precast concrete panel joints, tilt-up panel joints, curtain wall joints, perimeter caulking (windows, doors, panels) & metal roofs, sidewalls, FRP panels, etc. BASIC USES: <ol style="list-style-type: none"> Waterproofing of lap seams in trucks & trailers As a bedding compound for exterior accessories Sealing of joints including body-to-cap, underside, roof joints & curtain wall joints Perimeter sealing around windows & door openings, skylights, door hinges & air conditioners General purpose joint sealing applications Marine above & below the water line 	DESIGNED TO BOND: <ol style="list-style-type: none"> All kinds of metal, including galvanized Wood, particle board & plywood Rubber, concrete, masonry & glass Thermoplastics, such as ABS, styrene & polyolefins Thermoset plastics like phenolic, polyurethane, polyesters & epoxies Fiberglass & other fiber reinforced plastics
FEATURES <ol style="list-style-type: none"> One component, ready to use, fast cure Low VOC, odorless & particularly low volume shrinkage Suitable for sidewall bonding applications. Silicone free; sandable & paintable with most paints UV stable, heat & moisture resistant Broad adhesion spectrum to most substrates without a primer including: pre-painted metals, plywood, glass, aluminum, steel, SMC, RIM FRP, Kemlite® & many plastics & composites Non-staining 	<ol style="list-style-type: none"> One component, ready to use, fast cure Odorless & particularly low volume shrinkage Suitable for Marine application - above & below water line Silicone free; paintable with most paints UV stable, heat & moisture resistant Broad adhesion spectrum to most substrates without a primer Non-staining characteristics on stone substrates Formulated for superior non-sag characteristics 	<ol style="list-style-type: none"> One component, ready to use, fast cure Odorless & particularly low volume shrinkage Suitable for Marine application - above & below water line Silicone free; paintable with most paints UV stable, heat & moisture resistant Broad adhesion spectrum to most substrates Non-staining characteristics on stone substrates 	<ol style="list-style-type: none"> Excellent adhesion to pre-painted metals, plywood, glass, aluminum, steel, SMC, RIM, FRP, Luan, many plastics & composites Fast Cure time with high bonding & adhesive strength capabilities Paintable, sandable & remains permanently elastic Has Excellent resistance to weathering & road salts, making it ideal for sealing dynamically moving joints Is non-staining & non-yellowing Contains no isocyanates 	<ol style="list-style-type: none"> Extrusion or trowellable grades Fast drying - tack free in less than one hour Excellent early strength, gets stronger with age High strength bonds to most materials Permanently resilient - resists vibration & stress caused by temp. cycling Excellent resist. to water, oils, greases, fuels, industrial chemicals, acids & bases Resists cracking, chipping & peeling Requires no mixing, priming or heating Comes in several colors & is paintable Exceptional weatherability Forms a tight, long-lasting seal to most surface Shelf life: 7 months at temp. not to exceed 80° F
TYPICAL PROPERTIES <i>(Specification ranges available upon request)</i> Base: Polyurethane • Viscosity: Paste extrusion grade • Weight/gallon: 9.8 pounds • Specific Gravity: 1.17 • Temp. Range: -40° F to 200° F • Shelf Life: 12 months when stored in original unopened container under 80° F	<i>(Specification ranges available upon request)</i> Base: Polyurethane • Viscosity: Paste extrusion grade • Weight/gallon: 9.8 pounds • Specific Gravity: 1.17 • Temperature Range: -40° F to 200° F • Shelf Life: 6 months when stored in original unopened container under 80° F	<i>(Specification ranges available upon request)</i> Base: Polyurethane • Viscosity: Paste extrusion grade • Weight/gallon: 9.8 pounds • Specific Gravity: 1.17 • Temperature Range: -40° F to 200° F • Shelf Life: 1 year	<i>(Specification ranges available upon request)</i> Base: Polymer Silyl modified polyether • Viscosity: Paste, extrusion grade • Solids: (90% to 100%) • Specific Gravity: 1.65 • Temperature Range: (-40° F to 200° F) • Shelf Life: 1 year	<i>(Specification ranges available upon request)</i> Base: Polychloroprene • Solvent: Toluene • Solids: 50% • Weight/gallon: 9.2 pounds • Specific Gravity: 1.1 • Temperature Range: -60° F to 250° F • Viscosity: Paste extrusion grade
TYPICAL PHYSICAL CHARACTERISTICS <i>(Specification ranges available upon request)</i> Tensile Strength after 30 days at room temp.: 475 psi • Ultimate Elongation after 30 days at room temp.: 350% • Shore A Hardness after 30 days at room temp.: 50 • Tack-free @ 77° F, 50% RH: 40 Min • Lap Shear: 400+ psi • UV Resistance: Very Good • Ozone, Creep & Sag Resistance: Excellent	<i>(Specification ranges available upon request)</i> Tensile Strength after 30 days at room temp.: 475 psi • Ultimate Elongation after 30 days at room temp.: 600% • Shore A Hardness after 30 days at room temp.: 35 • UV Resistance: Very Good • Ozone, & Creep Resistance: Excellent • Sag Resistance: Superior	<i>(Specification ranges available upon request)</i> Tensile Strength after 30 days at room temp.: 199 psi • Ultimate Elongation after 30 days at room temp.: 700% • Shore A Hardness after 30 days at room temp.: 50 • UV Resistance: Very Good • Ozone, Creep & Sag Resistance: Excellent	Slump, in: Nil • Tack-Free Time at 77° F, 50% RH: 90 min. • Skin Time at 77° F, 50% RH: 20 min • Durometer Hardness, Shore A: 45 • 100% Modulus, psi: 200 • Ultimate Tensile Strength: 300 psi. • Elongation: 350% • Application Temperature: 40° F to 120° F • Service Temperature: -30° F to 200° F	UV Rating: No effect, 3000 hrs. with intermittent water spray every 30 minutes. ASTM 42 • Flammability Rating: Dried film meets MVSS 66 • Slump Resistance: Good • Creep Resistance: Excellent • Ozone Resistance: Excellent • Elongation: 500% • RES Hardness: 65 - 14 day cure
PACKAGING INFORMATION Part No. 12250 White, 12285 Black, 12286 Gray • 10.3 oz. • Cartridge/Sausage 10 oz. & 20 oz. • Sausage - 5 gal. & 55 gal Containers	Part No. 12608 White • 10.3 oz. • Cartridge/Sausage 10 oz. & 20 oz. • Sausage - 5 gal. & 55 gal Containers	Part No. 12176 White, 12232 Black, 12154 Gray (custom colors available) • 10.3 oz. • Cartridge/Sausage 10 oz. & 20 oz. • Sausage - 5 gal. & 55 gal Containers	Part No. 13053 White • 10.3 oz. • Cartridge/Sausage 10 oz. & 20 oz. • Sausage - 5 gal. & 55 gal Containers	Part No. 06324 Off White, 06325 Gray, 06326 Black, 06328 Super White, 06330 Aluminum • 10.3 oz. • Cartridge/Sausage 10 oz. & 20 oz. • Sausage - 5 gal. & 55 gal Containers

PRODUCTS ROYAL SEAL 1000 SEALANT <i>Silaprene</i>	HAPS FREE SEALANT <i>Silaprene</i>	ALL WEATHER SEALANT <i>Silaprene</i>	EXTREME® 300 GENERAL PURPOSE STRUCTURAL ADHESIVE 	EXTREME® 500 GENERAL PURPOSE STRUCTURAL ADHESIVE 
DESCRIPTION <p>Silaprene® Royal Seal Adhesive is an exceptional one-part product that combines ease of application, versatility of use, high ultimate strength, permanent bonds & long service life. Royal Seal adhesive/elastomeric is a sealant that provides superior adhesion to a variety of surfaces.</p>	<p>Silaprene® HAPS FREE Sealant is an exceptional one-part product that combines ease of application, versatility of use, high ultimate strength, permanent bonds and long service life. Adhesive is a high quality, HAPs free elastomeric sealant that provides superior adhesion to a variety of surfaces.</p>	<p>Silaprene® All Weather Sealant is a one-part self leveling solvent release product that combines excellent weather, UV and ozone resistance with ease of application to provide a long service life. All Weather Sealant is a high quality, high solids elastomeric sealant that provides superior adhesion to a variety of surfaces.</p>	<p>EXTREME 300® is a two part, "solvent free" acrylic adhesive system designed to provide flexibility, toughness & excellent adhesion for bonding plastics & metals in any combination. Cured performance shows excellent adhesion & bond strength to nylons, polystyrenes, fiberglass, reinforced plastics, stone, ceramics and most plain & plated metals. EXT-300® can withstand thermal cycling & shock loading between similar & dissimilar materials. Little or no surface preparation required with most materials.</p>	<p>EXTREME 500® is a two part, "solvent free" acrylic adhesive system designed to provide flexibility, toughness & excellent adhesion for bonding plastics & metals in any combination. Cured performance shows excellent adhesion & bond strength to composites, thermoplastics & metals (plain & plated). EXT-500® can withstand thermal cycling & shock loading between similar & dissimilar materials. Little or no surface preparation required with most materials. EXT-500® has excellent elongation properties.</p>
APPLICATION DESIGNED TO SEAL: <ol style="list-style-type: none"> All kinds of metal, including galvanized Wood, particleboard & plywood Rubber, concrete, masonry & glass Thermoplastics, such as ABS, & polyolefins Thermoset plastics like phenolic, polyurethane, polyesters & epoxies Fiberglass & other fiber reinforced plastics 	DESIGNED TO SEAL: <ol style="list-style-type: none"> All kinds of metal, including galvanized Wood, particleboard & plywood Rubber, concrete, masonry & glass Thermoplastics, such as ABS, & polyolefins Thermoset plastics like phenolic, polyurethane, polyesters & epoxies Fiberglass & other fiber reinforced plastics 	DESIGNED TO SEAL: <ol style="list-style-type: none"> All kinds of metal, including galvanized Wood, particleboard & plywood EPDM & other kinds of rubber Thermoplastics, such as ABS, styrene and polyolefins. Thermoset plastics like phenolic, polyurethane, polyesters and epoxies Thermoset plastics like phenolic, polyurethane, polyesters & epoxies Fiberglass & other fiber reinforced plastics Concrete, masonry & glass 	DESIGNED TO BOND: <ol style="list-style-type: none"> Wide range of metals, both plain and plated Wide range of plastics (ABS, PVC, Fiberglass, etc.) Stone and Ceramics Concrete Excellent for bonding dissimilar substrates 	DESIGNED TO BOND: <ol style="list-style-type: none"> Wide range of metals, both plain and plated Wide range of plastics (ABS, PVC, Fiberglass, etc.) Stone and Ceramics Concrete Excellent for bonding dissimilar substrates
FEATURES <ol style="list-style-type: none"> Fast drying with quick tack free times Permanently resilient - resists vibration & stress caused by temperature cycling Outstanding resistance to water, most industrial chemicals, acids & bases Resists cracking, chipping & peeling Requires no priming Smooth, creamy texture Easy to gun - colored versions can be finger tooled. Paintable Exceptional UV resistance & weather ability Forms a tight, long-lasting seal to most surface Shelf life: 12 months when stored below 80° F 	<ol style="list-style-type: none"> HAPS Free Fast drying with quick tack free times Permanently resilient - resists vibration & stress caused by temp. cycling Outstanding resistance to water, most industrial chemicals, acids & bases Resists cracking, chipping & peeling Requires no priming Smooth, creamy texture Easy to gun - colored versions can be finger tooled Paintable Exceptional UV resistance & weather ability Forms a tight, long-lasting seal to most surfaces Shelf life: 12 months when stored below 80° F 	<ol style="list-style-type: none"> Extrusion or trowel application Fast drying - tack free in less than one hour Flexible seals to most materials Outstanding resistance to water and moisture Resists cracking, chipping and peeling Requires no mixing, priming or heating Dried sealant is paintable Exceptional weatherability Shelf life: 1 year at temperatures not to exceed 80°F 	<ol style="list-style-type: none"> Two Component, 1:1 Mix Ratio Cure Speed 5-6 Min. @ 23C (other cure speeds available) Toughness & Durability Little or no surface preparation required in most applications Excellent Adhesion to dissimilar substrates (plastics & metals) High impact resistance High peel strengths 100% Reactive Solids Formulation for VOC compliance Excellent gap filling properties 	<ol style="list-style-type: none"> Two Component, 10:1 Mix Ratio Cure Speed 4-7 Min. @ 23C (other cure speeds available) Toughness & Durability Little or no surface preparation required in most applications Excellent Adhesion to dissimilar substrates (plastics & metals) High impact resistance High peel strengths 100% Reactive Solids Formulation for VOC compliance Excellent gap filling properties
TYPICAL PROPERTIES <i>(Specification ranges available upon request)</i> Base: Block Co-Polymer • Solvents: Aliphatic/Aromatic Hydrocarbons • Solids: 65% • Viscosity: Paste extrusion grade • Weight/gallon: .97 • Temperature Range: -40° F to 200° F	<i>(Specification ranges available upon request)</i> Base: Block Co-Polymer • Solvents: Aliphatic/Aromatic Hydrocarbons • Solids: 62.5% • Viscosity: Paste extrusion grade • Weight/gallon: colors 8.38 lbs. clear 7.53 lbs. • Specific Gravity colors 1.01, clear 0.903 • Temperature Range: -40° F to 200° F	<i>(Specification values available on request)</i> Base: EPDM rubber • Solvent: Naphtha • Solids: 67% • Viscosity: Paste extrusion grade • Weight/gallon: 9.1 pounds • Specific Gravity: 1.09 • Temperature range: -65°F to 210°F	TYPICAL UNCURED PROPERTIES (liquid) <i>(Applies to both the adhesive and activator sides)</i> Viscosity: 200,000 cps mixed • Specific Gravity: 1.01 (20/20C°) • Flashpoint: 51° (COC Method) • Toxicity: Moderate • Color: Straw or Black • Solvent: None • Mix Ratio: 1:1 • Fillers: yes • Clean Up Solvents: MEK, Acetone	TYPICAL UNCURED PROPERTIES Viscosity: Adhsv. 100,000 - 140,000 cps Actvr. 80,000 - 120,000 cps • Specific Gravity: Adhsv. 0.96 - 1.02 Actvr. 1.05 - 1.15 • Mix Ratio: (by volume) 10:1, Color: Adhsv. off white, Activ. Black, Mixed - Grey
TYPICAL PHYSICAL CHARACTERISTICS UV Rating: Little to no effect, 1000 hours; QUV test ASTM G53 • Slump Resistance: Good • Creep Resistance: Excellent • Ozone Resistance: Excellent • Elongation: 400%	UV Rating: Little to no effect, 1000 hours; QUV test ASTM G53 • Slump Resistance: Good • Creep Resistance: Excellent • Ozone Resistance: Excellent • Elongation: 400%	Slump Resistance: Good • Creep Resistance: Excellent • Ozone Resistance: Excellent • NBCC: Approved • FDA: Indirect food cer 175, 105 approved	TYPICAL CURED PROPERTIES (solid) (Typical film thickness = .030") Shore D Hardness: 75 • Thermal Service Range: -65° F to 260° F • Chemical Resistance: Excellent • Elongation: <60% • Impact Resistance: 20 ftlbsin' • Peel Strength: 20-25 pli on aluminum • Lap Shear Strength: CRS as rec'd (no surface prep) 2340 psi, Grit blasted steel 3365 psi, Alum. 3390 psi	TYPICAL CURED PROPERTIES (solid) Tensile Strength: 2,030 - 2,460 psi Tensile Modulus: 58,000 - 87,020 psi Chemical Resistance: Excellent Elongation: >70%
PACKAGING INFORMATION Part No. 13011 White, 12897 Black, 128895 Clear, 14033 Finger Tool Clear • 10.3 oz. • Cartridge/Sausage 10 oz. & 20 oz. Sausage - 5 gal. & 55 gal Containers	Part No. 12381 White, 12788 Black, 12781 Clear • 10.3 oz. • Cartridge/Sausage 10 oz. & 20 oz. Sausage - 5 gal. & 55 gal Containers	Part No. Self-Leveling 12718 White, 12724 Gray, 14041 Tan, Non-Leveling 12345 White, 13437 Grey, 14061 Tan, High Solids 14080 White, 13701 Grey • 10.3 oz. Cartridge/Sausage 10 oz. & 20 oz. Sausage - 5 gal. & 55 gal Containers	Part No. 300 50ml, 220ml, 400ml, 5 gal. pail kit, 55 gallon drum kit	Part No. 500 37ml, 250ml, 490ml, 5 gal. pail kit, 55 gallon drum kit

PRODUCTS

HYDRA FAST-EN
WATER BASED ADHESIVE



SILAPRENE*
SOLVENT BASED ADHESIVE



DESCRIPTION

Part No. 12243 White - wet, Clear - dry BOND-PLUS® is a water based emulsion adhesive for pressure sensitive application.

- DESIGNED TO BOND:**
1. Elastomeric floor coverings
 2. Painted surfaces, glass, and vinyl films
 3. Fabric, wood, leather, felt & composition materials
 4. Thermoplastic, such as ABS, styrene, & polyolefin's
 5. Thermoset plastic like phenolic, polyurethane, polyester and epoxies

Part No. 20760 White BOND-PLUS® Vinyl Acetate-Ethylene Adhesive is a water based product for use in bonding PVC flooring to a plywood base. It is high solids and can be sprayed, brushed or roll coated. Application amounts vary according to substrates & are generally around 8-10 wet mils. Substrates must be wet mated & allowed to dry to develop sufficient bond for subsequent handling. Strength development is rapid (1.5-3 hrs.) at 70°F & above. Full strength develops within 24 hours. Bondline is water resistance & has good resistant to plasticizer migration.

Part No. 20790 Creamy White - wet BOND-PLUS® is a multipurpose water-based contact adhesive for bonding rubber backed carpet to marine grade plywood. Stir thoroughly before use. Apply by brush, roll coater or spray in a uniform film. Coverage of 80-110 sq. ft. per gallon is recommended for most applications depending on the smoothness and porosity of the substrates and the application. Two coats may be necessary on porous parts. Mate parts immediately after coating (wet mate).

Part No. DC 13674 Creamy White - wet BOND-PLUS® is a water-based adhesive for bonding EPDM and TPO membranes for use in RV Roofing and Flooring applications

Part No. DC 12742 Light Amber SILAPRENE® is a light amber, solvent-based, general purpose adhesive that forms a tough, flexible bond to many substrates. Long open time if needed.

- DESIGNED TO BOND:**
1. PVC film, sheet & foam
 2. Acrylic, polyurethane, ABS & other thermoplastics
 3. Most thermoset plastics, such as epoxy, & phenolics
 4. Metal, wood, ceramic, leather and concrete
 5. Nitrile, Neoprene and other elastomer

Part No. DC 12880 Clear to Light Amber HAP's FREE, LOW VOC Contact Adhesive is a high quality, synthetic rubber general-purpose contact adhesive. It utilizes a Hazardous Air Pollutant-free solvent system. Can be used for bonding foam, plastics, carpet, FRP, wood, various metals and many elastomers. Not recommended for highly plasticized materials.

The adhesive should be applied in smooth even coats to both surfaces at a rate of at least 2 dry grams per square foot of bonding area. Porous materials, such as fabric, foam or wood may require two coats of adhesive. Join the surfaces when the adhesive is tacky to the touch but does not transfer to the finger. Adequate pressure must be applied to assure complete contact.

Part No. DC 12786 Amber HIGH TEMPERATURE RESISTANT HAPS FREE ADHESIVE A high quality high temperature resistant synthetic rubber contact adhesive designed for foam bonding. It utilizes a Hazardous Air Pollutant-free solvent system. Can be used for bonding a wide variety of substrates: foam, carpet, FRP, aluminum, wood, plastic, etc.

FEATURES

1. Spray Brush or roll coat viscosity
2. Good resistant to oils, solvents, and water
3. High solids
4. High peel strength
5. Resistant to plasticizer migration
6. Excellent resistance to creep
7. Shelf life: 6 months when stored between 60°F & 80° in unopened containers

1. Spray Brush or roll coat viscosity
2. Good resistant to water & plasticizer migration
3. High solids
4. Rapid strength development
5. Wet mate application

1. Dry adhesive film does not support combustion
2. Good general purpose adhesive
3. Excellent resistance to heat & moisture
4. Flexible to temperatures as low as -40°F.
5. Good adhesion to metal & marine grade plywood

1. Nonflammable in wet state
2. Good adhesive for bonding EPDM, TPO Fleece Back, & TPO membrane to RV Roof decking & flooring
3. Excellent resistance to heat & moisture
4. Flexible to temperatures as low as -40°F
5. Good adhesion to metal, plywood & concrete

1. Spray or brush grade
2. Highly resistant to oils, fuels and water
3. Resistant to plasticizer migration from vinyl films
4. Retains flexibility at low temperatures
5. Pre-coated parts can be solvent reactivated
6. Shelf life. 6 months at temperatures not to exceed 80°F

1. Long open tack time
2. Repositionable
3. Excellent temperature resistance
4. Low-pressure spray ability
5. High tack
6. Can be sprayed, brushed or rolled
7. Light colored & non-staining for light colored fabrics
8. Excellent general purpose adhesion
9. Resistant to humidity & water

1. Quick setting
2. Fast drying
3. Heat resistance up to 240°F
4. Low-pressure spray

TYPICAL PROPERTIES

(Specification ranges available upon request)
Base: Acrylic • **Solids:** 56% • **Solvents:** Water • **Viscosity:** 4500 cps, RVF Brookfield #4 spindle, @ 10 RPM. • **Weight/Gallon:** 8.7 pounds • **Specific Gravity:** 1.04 • **Temperature Range:** -30°F to 220°F

(Specification ranges available upon request)
Base: VAE • pH Approx. 5.0 • **Solvents:** Water • **Viscosity:** 3000 cps, (spindle #3@20 rpm/73F) • **Percent Solids:** Approx. 73% • **Density:** Approx. 9.03 lbs./gal. • **Shelf Life:** 4 months from date of manufacture • **Clean Up:** Water when wet, cleaning solvents when dry

(Specification ranges available upon request)
Base: Synthetic Polymer Emulsion • **Solids:** 49% • **Solvents:** Water • **Temperature Range:** -40° to 200° F • **Viscosity:** 5,500 cps • **Approx. Weight:** 8.7 lbs./gal • **Cleaner:** Water when wet, toluene when dry • **Storage:** Store in closed container under 80° F. Keep from freezing. • **Shelf Life:** 1 year when stored below 80°F in unopened containers

(Specification ranges available upon request)
Base: Synthetic Polymer Emulsion • **Solids:** 44% • **Solvents:** Water • **Temperature Range:** -40° to 200°F • **Viscosity:** 12,500 • **Approx. Weight:** 8.4 lbs./gal. • **Storage:** Store in closed container under 80°F. Keep from freezing • **pH:** 7 • **Disposal Information:** Do not reuse container or remove label. Safely dispose of container & contents in accordance with law

(Specification ranges available upon request)
Base: Nitrile rubber • **Solids:** 27% • **Solvents:** Acetone • **Viscosity:** 900 cps, RVF Brookfield #2 spindle, @ 10 RPM • **Weight/Gallon:** 7.1 pounds • **Specific Gravity:** .85 • **Temperature Range:** -35°F to 350°F

(Specification ranges available upon request)
Base: Synthetic Rubber • **Solids:** 35% • **Solvents:** Acetone, Heptane, Cyclohexane • **Heat Resistance:** 190-200°F • **Viscosity:** 200-400 cps (#2 @ 20 rpm) • **Approx. Wt:** 7.1 lbs./gal. • **Open Tack Time:** 10-15 Min. • **Cleaner:** Acetone • **VOC Content:** <400 g/l • **HAPs Content:** 0 lbs/gal • 1" x 6" 180° peel: 18 pli (cotton duck/AL) • **1 sq. in. shear:** 250 psi. (cotton duck to itself) • **SAFT:** 160°F • **Storage:** In closed container under 80°F • **Shelf Life:** 1 yr. when stored below 80°F in unopened containers

(Specification ranges available upon request)
Base: Synthetic Rubber • **Solids:** 36% • **Solvents:** Acetone, Heptane, Cyclohexane • **Heat Resistance (SAFT):** 240°F • **Viscosity:** 300 cps (#2 @ 10 rpm) • **Approx. Weight:** 6.7 lbs./gal. • **Open Tack Time:** 10-15 Min. • **Cleaner:** Acetone • **VOC:** 455 g/l • **HAPs Content:** 0 lbs./gal. • **Storage:** In closed container under 80°F • **Shelf Life:** 1 yr. when stored below 80°F in unopened containers

PACKAGING INFO

5 Gallon Pail
55 Gallon Drum
275 Gallon Tote

5 Gallon Pail
55 Gallon Drum
275 Gallon Tote

5 Gallon Pail
55 Gallon Drum
275 Gallon Tote

5 Gallon Pail
55 Gallon Drum
275 Gallon Tote

5 Gallon Pail
55 Gallon Drum
275 Gallon Tote

5 Gallon Pail
55 Gallon Drum
275 Gallon Tote

5 Gallon Pail
55 Gallon Drum
275 Gallon Tote

ONE TRUSTED NAME... NOW MANY SOLUTIONS

Royal Adhesives & Sealants is a manufacturer and marketer of high performance adhesives, sealants, encapsulants and specialty polymers. These high performance products are used in a variety of markets including aerospace and defense, automotive, recreational vehicle, bus, truck and trailer, marine, assembly, electrical/electronic, filter, printing, packaging and laminating, roofing and flooring.

We offer a broad spectrum of thermosetting epoxy, urethane, and methyl methacrylate structural adhesives, cyanoacrylate and anaerobic adhesives, energy cured acrylate adhesives and coatings and rubber and acrylic based adhesives, sealants and polymers to meet the most demanding adhesive, sealant and coating applications.

The company offers a wide array of standard and custom-formulated systems and application solutions. They are available in totes, drums, pails, and value-added packaging such as meter-mix and dispense cartridges, foil-wrapped sausages, and single-use packets.

We have over 25,000 sq. ft. of R&D labs that are fully equipped with testing, analytical and scale up equipment.

Headquartered in South Bend, Indiana, Royal operates state-of-the-industry ISO 9001/2008 certified facilities in Indiana, South Carolina, Texas, New Jersey, New Hampshire, Kansas, and California.

REACTIVE

EPOXY / URETHANES / MMA'S



WATER BASE

ACRYLIC / NATURAL RUBBER / SBR / SPECIALTY



SOLVENT BASE

NEOPRENE / EPDM / SBR / NITRILE / URETHANE / SPECIALTY

