LOCTITE® RGB 100

February 2013

PRODUCT DESCRIPTION

LOCTITE® RGB 100 provides the following product characteristics:

Technology	Solvent based
Chemical Type	Chloroprene rubber/solvent
Appearance	Light yellow, translucent liquid
Odor	Ketone
Consistency	Brushable
Cure	Solvent evaporation
Components	One component - requires no mixing
Application	Bonding
Specific Benefit	• Provides extra strong tack • Excellent adhesion to various synthetic materials of solid gaskets • Economical to use

LOCTITE® RGB 100 a single component material for bonding solid gaskets on both horizontal and vertical flange surfaces of engines, gear boxes, etc. It is a solvent based product that does not contain toluene, which is harmful to human health and the environment. LOCTITE® RGB 100 is ideal for positioning and holding gaskets so they do not shift during assembly even on vertical surfaces. It is ideal for industrial uses including mobile uses like railway equipment. It bonds porous surfaces like leather, most plastics and different gasket materials to a variety of substrates, including metal.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 30 °C	0.85 to 0.95
Viscosity, mPa·s (cP)	1,500 to 3,500
Solids Content, %	20 to 35
Flash Point - See MSDS	

TYPICAL CURING PERFORMANCE

The cure times below are based on normal climactic conditions (23°C / 50%RH). Other climatic conditions can result in a lengthening or reduction of curing and drying times.

Curing Properties

Open Time @ 23 °C, minutes:	
Pressure Sensitive / Contact bonding	10 to 40
Working life, minutes:	
Pressure Sensitive / Contact bonding	120
Cure Time @ 23 °C, hours	24

TYPICAL PERFORMANCE OF CURED MATERIAL

After 24 hours @ 25 °C

Lap Shear Strength, kgf/cm² :		
Flexible Flooring PVC to Wood		3.99
Flexible Flooring PVC to Aluminum		3.29
Peel Adhesion (pli method), ASTM D 903:		
Steel to Canvas	kg/cm	0.93*

*Substrate failure

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

Directions for use:

Surface Preparation:

Surfaces must be clean, free from structural defects, firm, dry and free of substances which may impair adhesion.

Application:

- Shake the adhesive well before application.
- Use a suitable notched trowel, brush or roller for application.
- **When solid gasket is porous:** Apply an even coat of adhesive on one or both surfaces. Application on both surfaces is preferred because it gives higher adhesion strength. Bond while adhesive is still wet or tacky. Press both surfaces.
- **When solid gasket is non-porous:** Apply the adhesive to the back of the gasket as well as on the substrate with either brush or roller. Allow the adhesive to air-dry until it has taken on a uniformly yellowish to transparent color (approx. 10-40 minutes). Then test with a gloved finger to ensure it is touch-dry. Allow to dry for an additional 5 minutes after touch-dry to improve adhesion. Place the gasket and rub or roll it down with hand.

Technical Tips for Working With Solvent Based Adhesives

- Remove any skin of dried adhesive which may have formed (e.g. due to improper storage). Do not stir in.
- Immediately remove fresh spots of adhesive with a cloth soaked in solvent.
- Clean tools with solvent immediately after use.
- Tightly close opened buckets and use them up as soon as possible.
- Open and working time may vary depending on temperature, relative humidity and absorbency of the

substrate. They will be shorter at higher temperatures and lower humidity, but longer at lower temperatures and higher humidity and with non-absorbent substrates.

Not for product specifications
The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

Storage
Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.
Optimal Storage: 10 °C to 25 °C. Storage below 10 °C or greater than 25 °C can adversely affect product properties. Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Conversions
(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

Disclaimer
Note:
The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.
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