



Developed in Germany

5005

COLD VULCANIZING CEMENT
Free of chlorinated solvents - Monocomponent

TRS 5005 Cold-vulcanizing adhesive is TRS' system for cold splicing and cold repair of rubber conveyor belts when a high thermal resistance is not required. It is designed as the solution to all your industrial rubber bonding problems.

By using TRS 5005 you can work also in areas where wear and corrosion protection are required, bonding rubber sheets to metal or concrete.

SCOPE

TRS 5005 is a mono-component cold vulcanizing adhesive based on polychloroprene rubber (CR). By using TRS 5005, synthetic rubber, natural rubber, fabrics, metal and others can be bonded to each other without heat or special equipment even for dynamic demands.

PHYSICAL PROPERTIES

Basis	➔ Polychloroprene rubber (CR)	Thermal stability - UNE EN 12964	➔ Max. 50°C constant
Solvent System	➔ Ethyl Acetate, cyclohexane, acetone	Open Time UNE EN 14022 met 4 - Temp. (15-30°C)	➔ 10 - 20 minutes
Colours	➔ Dark grey	Open Time UNE EN 14022 met 4 - Temp. (+30°C)	➔ 5 - 10 minutes
Brookfield Viscosity RVT (Sp4, 20 rpm, 20°C) UNE 12092	➔ 1600 ± 200 mPa·s	Coverage	➔ 600 g/m ² with 2 layers or 300 g/m ² per layer
Kinematic Viscosity	➔ 1860 ± 225 cSt	Shelf life	➔ At least 24 months after production date
Flash Point	➔ app. -10°C		
Application Temperature	➔ +10°C to +40°C		
Environmental and Materials Temperature	➔ +5°C to 45°C (minimum 5° above the dew point)		

MIXING INSTRUCTIONS

It is normal that TRS 5005 has a little of sedimentation at the bottom of the can or drum. If so, to be sure that you do not lose this critical component, it is recommend to stir it with the aid of a non-metal and non-round stirrer made of wood or plastic before adding the hardener for at least 2 minutes. Please do not scrape off the spatula that you use to inspect the bottom of the can on the edge of the can losing this material.

STORAGE

Shelf life of unopened containers is 2 years after production date when stored under conditions according DIN 7716. Temperatures below 5 °C can cause a reversible change in the structure of the rubber compound, increasing the viscosity of the glue that can jellify. It is not possible to use the glue under these conditions because the adhesive is so thick that it cannot wet the surfaces to bond. If the cement arrives to this point, the solution is to put the containers at room temperature and let them time to recover, without trying to heat or stir it.

SAFETY



TRS 5005 contains hazardous ingredients: ethyl acetate; hydrocarbons: C7, n-alkanes, isoalkanes, cyclics; rosin colophony. It is classified under CLP regulation.

For safety instructions for transport, manipulation or storage please read and understand the Material Safety Data Sheet.

PACKAGING SIZES

TRS code	Description	Pieces/carton	Quantity/Palet
302920	TRS 5005 - 700 ml	10 cans	49 cartons - 490 units



COMERCIAL QUÍMICA MASSÓ, S.A. odstepný závod
Předvoje 449/32, Praha 6 162 00 - Česká Republika
Tel.: +420 241 481 798
trs@cqmasso.com





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APPLICATION

CONDITIONING THE MATERIALS:

Before working on the materials, be sure that you have all of them within the correct temperature and humidity application conditions. If possible, leave materials in the work area to ensure this the day before.

Pay special attention to humidity, it should not exceed 80%, and the temperature of the substrate should be at least 5°C above the dew point to avoid surface condensation of water.

SURFACE PREPARATION:

In general, the surfaces to be bonded must be clean, dry, and free of oil, paint, or other kind of contamination. If not, the surfaces must first be cleaned with **TRS Cleaning Solvent MEK**.

Rubber without bonding layer:

Buff the surface of the rubber using a grinder. The rougher the surface, the better the adhesion. Pay attention to not scorch the rubber. Scorched rubber cannot be glued.

Use only slow running angle grinders for buffing rubber and very rough buffing discs (ex. Silicium carbide - P24). The rougher the buffed surface the bigger is the surface you are coating with **TRS 5005** and of course the better the final adhesion.

Once the surface is buffed, remove dust in dry avoiding the application of any kind of solvent after buffing.

Rubber with bonding layer:

Fresh bonding layer: Wash the surface with **TRS Cleaning Solvent MEK** and let it dry.

Dry bonding layer: Prepare the surface as if it had not bonding layer.

Metal:

Be sure that the metallic surface is degreased and free of any kind of contamination. If not, wash the surface with **TRS Cleaning Solvent MEK** and let it dry.

Buff the surface of the metal using an angle grinder with rough buffing disc (ex. Ceramic - P24). Remove all dust dry.

Fabric:

In this case it depends on each fabric (treatment, weight and weave) but, in general, clean and let it dry.

APPLICATION:

We strongly recommended to always apply two layers of the product to every surface. The first layer acts as a primer, so it is really important that it is totally dry before applying the second layer.

In the case of metal surfaces, we recommended to apply as a first layer **TRS Metal Primer**. It is proven that the application of the **TRS Metal Primer** can improve the resistance and the reliability of the bonding.

It is always important to let at least 1 hour (20 °C) before applying the second layer. If possible, we recommended to apply the first layer the day before.

Apply the product with the help of a brush or a nap roller. It is important to apply a thin and even layer. The scrub-like motion when working with a brush can help us ensure this by avoiding leaving air in the polished surface voids.

The second layer is always glue (also in metal). Apply a uniform and thin layer of glue with the help of a brush. As we have done the same treatment to both surfaces, drying process will be uniform.

After around 10 minutes, the surfaces are dry to a tack and ready to bond (check it with the back of the hand). Join surfaces and, with a hand-held roller, roll from the centre to the edges applying pressure to bond surfaces together. Working on this way we eliminate the air avoiding the formation of bubbles on the joint.

Our technical advice - whether verbal, in writing or by the way of trials - is given in good faith but without warranty, and this also applies where proprietary rights of third parties are involved. It does not release you from the obligation to test the products supplied by us as to their suitability for the intended processes and uses
Application use and processing of the products are beyond our control and, therefore, entirely your own responsibility. If, despite this, liability should be established for any damage, it will be limited to the value of the goods delivered by us and used by you. We will, of course, provide products of consistent quality within the scope of our General Conditions of Sale and Delivery.



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