

TRS PLASTO

COLD VULCANIZING CEMENT

Plastic Conveyor Belts

The **TRS PLASTO** Cold-vulcanizing adhesive is TRS' system for cold splicing and cold repair plastic conveyors. By using **TRS PLASTO** with **TRS 1000 E** or **TRS 100 TRISO** Hardeners you can also work in all areas of wear and corrosion protection are needed as in cooling water towers.

Scope

TRS PLASTO is a two-component cold vulcanizing adhesive based on thermoplastic PUR specially developed to bond PUR, PVC, leather, ABS... **TRS PLASTO** bonds perfectly PVC to PVC belting, fabric to polyurethane, PVC or polyurethane foils to metal... at room temperature.

Physical Properties

Basis	Polyurethane
Solvent System	Ketone Solvents
Colours	Translucent
Brookfield Viscosity RVT (Sp4, 20 rpm, 20°C) – UNE 12092	3700 ± 500 mPa·s
Kinematic Viscosity	4300 ± 575 cSt
Flash Point	Approx. -10°C (method: closed cup)
Oil Resistance	Excellent
Application Temperature	+10°C to +40°C
Environmental and Materials Temperature	+ 5°C to 45°C (minimum 5°C above the dew point)
Thermal stability - UNE EN 12964	Max. 55 °C continuous
Open Time UNE EN 14022 met 4 – Temp. (15-30°C)	10 – 15 minutes
Pot Life (3% Hardener TRS 1000 E) - UNE EN 14022 MET 3	Approx. 20 minutes @ 20°C
Shear strength PVC/PVC (UNE EN 1465)	> 2,6 N/ mm ² (Substrate Breakage)
Peel strength PVC/Aluminium (UNE EN 28510-1)	> 5 N/mm
Coverage	300 g/m ² per coat
Shelf life	At least 36 months after production date

Mixing instructions

Add the Hardener slowly. It is recommended our **TRS Hardener 1000 E** (3 – 5% in weight = 20:1) and stir for at least 2 minutes until you have a homogeneous blend.

Application

1.- Conditioning the materials

Before to begin to work over the materials, be sure that you have all of them inside the correct temperature and humidity application conditions. If possible, let the materials in the working zone to assure this.

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

2.- 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, you should clean previously with **TRS Cleaning Solvent MEK** paying attention that the solvent does not attack the surface.

Buff the surface of the rubber using a grinder. The rougher the surface, the better the adhesion. Be careful not to melt the plastic surface.

Use only slow running angle grinders and very rough buffing discs. The rougher the buffed surface the bigger is the surface you are coating with **TRS PLASTO** and of course the better the final adhesion.

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

3.- Application

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

Once first layer is dry, apply a uniform and thin layer of glue with the help of a brush. As it has been 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 this way eliminates the air avoiding the formation of bubbles on the joint.

3.1- Hot Application

TRS PLASTO can be re-activated exposing cure adhesive to a temperature between 55 – 65°C. In this case it is recommended to work with a hot plate press applying pressure and heat at the same time.

Maximum strength will be reached after 48h.

Storage

Shelf life of unopened containers is 3 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 compound, increasing the viscosity of the glue that can arrive to jellified. It is not possible to use the glue under these conditions because the adhesive is so thick that 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 PLASTO contains hazardous ingredients: acetone, propan-2-one, propanone; butanone, ethyl methyl ketone. 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 PLASTO

TRS code	Description	Pieces/carton	Quantity/Palet
303110	TRS PLASTO - 700 mL	10 cans	49 cartons – 490 units
303111	TRS PLASTO - 20 Kg	1 pail	21 pails
303112	TRS PLASTO - 200 L / 170 Kg	1 drum	2 drums



COMERCIAL QUÍMICA MASSÓ, S.A.
odštěpný závod

Předvoje 449/32. 162 00 Praha 6 - CZECH REPUBLIC
Tel: + 420 241 481 798
masso@cqm.cz - www.cqmasso.com



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