Technical Data Sheet

Bonding AFLAS® FEPM with MEGUM® W-2525

MEGUM® W-2525 is a waterborne, one-coat adhesive, which is clear and designed for bonding elastomeric compounds to metal. MEGUM® W-2525 is designed to create a strong bond between metal and a variety of polymer types including:

- AFLAS® FEPM
- FKM, fluoroelastomers
- Vamac® ethylene acrylic
- Peroxide-cured EPDM, HNBR, and NBR

AFLAS® FEPM is an elastomer widely used in industrial applications including automotive, oil and gas, and other applications where resistance to high temperature oil, heat, water, and high pH fluids is critical.

Using compounds supplied by AGC Chemicals Americas, Inc., MEGUM® W-2525 was evaluated for bonding to steel with two AFLAS® FEPM based compounds, AFLAS 600X (a 90 durometer compound – ID D6017307) and AFLAS 100S (a 90 durometer compound – ID D1017309). Bond testing to carbon steel performed by test method ASTM D429 Method D on both elastomer compounds and the results are shown below:

Product	Compound	Peel Strength	Rubber Retention	Non-Rubber Failure
Megum W 2525	100S	42.5	100	
Megum W 2525	600 X	34.5	100	

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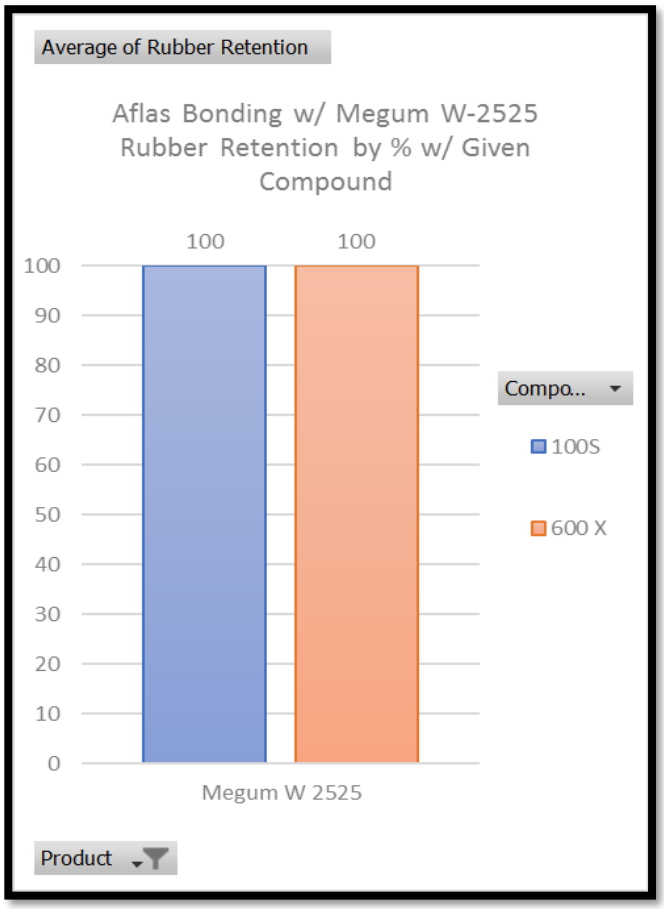

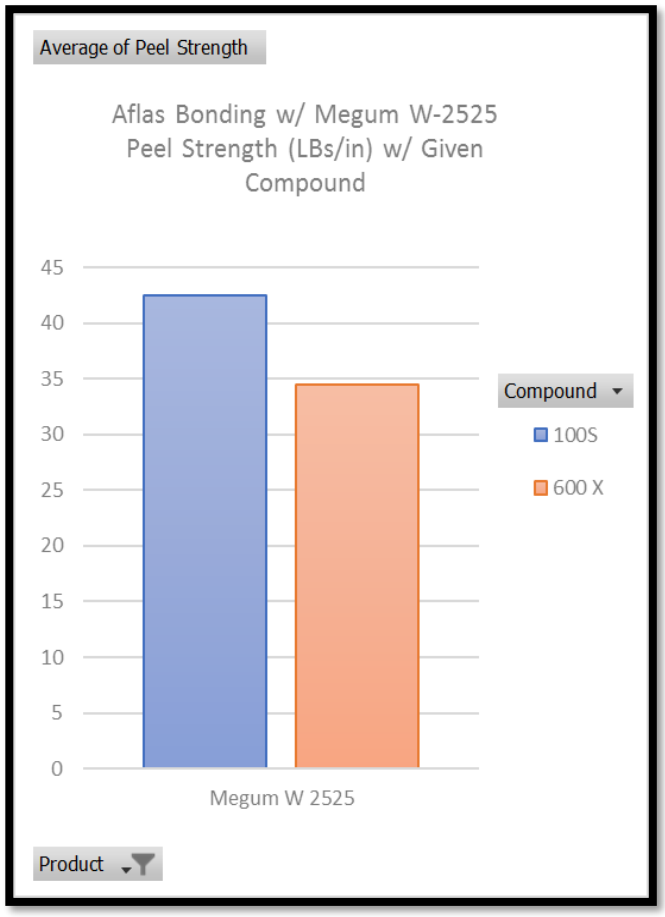

Conclusions

MEGUM® W-2525 retained 100% rubber retention and held a high peel strength. The waterborne adhesive is a viable bonding system for AFLAS® FEPM based compounds. Waterborne adhesives such as MEGUM® W-2525 can improve processing in in a production environment, limit employee exposure to VOCs, lower environmental emissions with a strong rubber to metal bond.

Megum® W-2525 is distributed by HM Royal Inc. www.hmroyal.com

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