

REPAIRS TO RUBBER COMPONENTS



TR300	60 Fluid Elastomer
TR305	60 Paste Elastomer
TR310	60 Rapid Grade Elastomer
TR315	80 Fluid Elastomer
TR320	80 Paste Elastomer
TR 325	80 Brushing Elastomer



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Engineering Repair & Maintenance Manual

ELASTOMERIC REPAIR SYSTEMS - CHARACTERISTIC CHART

Product Code	Product Name	Pack Size	Mixing Ratio	Usable Life (20C)	Cure Time	Machine Time	Coverage Rate per unit	Applied By	Max Temp Dry	Continuous	Max Temp	Surface Prep	Degrease	- Manual - Blasted
TR300	60 Durometer Elastomer Fluid	2 x 600g m	2:1	25 mins	3 hours	16 hours	N/A	Brush	120	80	50	*		*
TR305	60 Durometer Elastomer Paste	2 x 600g m	2:1	25 mins	3 hours	16 hours	N/A	Spatula	120	80	50	*		*
TR310	60 Durometer Elastomer Rapid Grade	10 x 125g m	2:1	10 mins	30 mins	1 hour	N/A	Spatula	120	80	50	*		*
TR315	80 Durometer Elastomer Fluid	2 x 600g m	13:2	15 mins	4 hours	16 hours	N/A	Brush	120	80	50	*		*
TR320	80 Durometer Elastomer Paste	2 x 600g m	3:2	15 mins	4 hours	16 hours	N/A	Spatula	120	80	50	*		*
TR325	80 Durometer Elastomer Brush Grade	1 x 3kg	13:2	15 mins	4 hours	16 hours	1.9sq m at 500 microns	Brush	120	80	50	*		*

Max Temp Dry – maximum temperature when in contact with dry products ie – powders

Max Temp Wet – maximum temperature when in contact with wet products ie – water, sewage, chemicals



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ELASTOMERIC REPAIR SYSTEMS

Use the table below to choose the right product for the application, then look at the following page for general characteristics on the product chosen. **NOTE** the table below is only a guide, if in doubt please contact our technical department for confirmation of the choice made

Product Name	Cables	Castings	Conveyor Rebuild	Conveyor Coating	Gaskets	Hosing - Low Pressure Repair ++	Moulds	Pump - Impeller	Tyre Repair - Off Road	Rapid Repairs	Conveyor	Hosing	Tyres
TR300 60 Durometer Paste	*		*			*			*				
TR305 60 Elastomer Fluid				*					*				
TR310 60 Durometer Rapid Grade Paste											*	*	*
TR315 80 Durometer Paste		*			*		*						
TR320 80 Durometer Fluid		*			*		*						
TR325 80 Durometer Brushing Grade								*					

REPAIRING FENDERS AND FLOATING HOSES

The following ThistleBond section is concerned with the repairing of Fenders and Floating Hoses and should be read in conjunction with the Technical Data sheets of the following ThistleBond Products: 60 Durometer Elastomer Paste and 80 Durometer Elastomer Paste.

COMMON DEFECTS

Mechanical damage or wear.

PREPARATION

All work should be carried out in strict accordance with the relevant ThistleBond Technical Data Sheet. Product selection and application should be based upon the nature and severity of the damage, the time available for work the system pressure and operating temperatures.

N.B. Repairs must not be attempted if damage to reinforcement layers is evident.

SURFACE PREPARATION

All loosely adhered material should be cut away and the repair area cut back using a sharp knife, this leaves a sound edge terminated square or undercut. Where exposed reinforcement fabric has become wet, it should be allowed to dry out. The complete area of damage and an area at least 3" around the damage should then be abraded to produce a woolly finish. This can be accomplished by using a rotary wire brush, or by the use of a roughing brush. Where metallic reinforcements are exposed, this should be thoroughly roughened and then washed with ThistleBond Universal Cleaner in order to remove all dirt, grease and other surface contaminants.

PRIMING SYSTEM

Apply the ThistleBond Primer supplied with the product in a thin film to the entire prepared area, be sure to use a stiff bristled brush.

APPLICATION TECHNIQUE

Mix the selected product and apply a thin layer to the prepared area. Ensure this layer of product is kept within the prepared area and is pushed will into the prepared profile. Wet out an appropriate length of ThistleBond reinforcement tape with the mixed product and apply this to the repair area. Where more then one length of reinforcement tape is required, ensure an overlap of a minimum of ¼" between lengths.

Finally, apply further product to totally encapsulate the reinforcement tape and in fill the repair area using a correctly contoured rigid applicator to re-profile the surface. If required a suitable rotary grinding tool can be used to finally contour the surface, after a full mechanical cure of the product has taken place.

TECHNICAL SUMMARY

PRODUCT	HARDNESS	WORKING LIFE (20 °C)	FULL CURE (20 °C)
60 DUROMETER ELASTOMER PASTE	60	25 MINUTES	72 HOURS
80 DUROMETER ELASTOMER PASTE	80	25 MINUTES	72 HOURS

MAIN SYSTEM SELECTION

Required for High Abrasion Resistance	80 Durometer Elastomer Paste
General Repair Work	60 Durometer Elastomer Paste