

18027 Bishop Avenue  
 Carson, CA 90746-4019  
 Phone: (800) 374-3872  
 Fax: (310) 202-7247  
[www.evroboters.com](http://www.evroboters.com)



**Resin Formulators  
 Technical Data Sheet**

**RF-7050  
 SOLVENT BASED NEOPRENE ADHESIVE**

**Description**

RF-7050 is a easy-to-use, one part, fast drying neoprene adhesive. This type of adhesive is used for bonding neoprene rubber to itself and to a wide variety of other materials. These products are particularly useful for boding seals and insulation gaskets made from rubber or foamed rubber.

- Excellent adhesive strength
- Flexibility to withstand joint movements and vibrations
- Service temp from -65°F - +180°F
- Final product can be painted by most paints

**Typical Performance Characteristics**

**Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.**

180° Peel Strength Canvas/Steel			Overlap Shear Strength** 1/8" Birch / 1/8" Birch	
Time @75°F (24°C)	Test Temp.	Value (piw)	Test Temp.	Value (psi)
1 day	75°F (24°C)	18	-30°F (-34°C)	343
3 days	75°F (24°C)	48	75°F (24°C)	549
5 days	75°F (24°C)	51	150°F (65°C)	195
7 days	75°F (24°C)	52	180°F (82°C)	136
2 weeks	75°F (24°C)	30*	200°F (93°C)	85
3 weeks	75°F (24°C)	20*	225°F (110°C)	85
After 3 weeks	-30°F (-34°C)	49		
After 3 weeks	150°F (66°C)	32.5		
After 3 weeks	180°F (82°C)	26		

\*These values DO NOT reflect a loss in strength – but do represent an increase in modulus. Because of the adherends and procedure, bond failure is from the canvas. The actual strength of these adhesives is increasing.

\*\*Bonds aged 2 weeks at room temperature before testing.

## Typical Physical Properties

Property	RF-7050
Viscosity; Brookfield RVF #4 @ 20 rpm	1500-4000 cps
Solids (be wt.)	34-39%
Color	Yellow
Net Weight	7.1-7.5 lb/gal
Flashpoint	- 14F

## General Instructions for Use

### Directions For Use:

#### 1. Surface Preparation

Remove all dust, dirt, oil, grease, wax, loose paint, etc. Wiping with solvent such as 3M™ Scotch-Grip™ Solvent No. 3\* or MEK\* will aid in preparing the surface for bonding.

#### 2. Application Temperature

For best results the temperature of the adhesive and surfaces to be bonded should be at least 65°F (18°C). If stored below 30°F (-1°C), allow adhesive to warm to room temperature by placing in a warm room only (do not exceed 120°F [49°C]) followed by thorough agitation.

#### 3. Application

Stir well before using. Brush, flow or spray a thin, uniform coating of adhesive to each surface. A coating of 2.5 gms to 3.5 gms/ft.<sup>2</sup> dry weight per surface is recommended. Porous surfaces may require more than one coat. A uniform, glossy film indicates sufficient adhesive.

#### 4. Drying Time

Allow adhesive to dry until no longer wet (maximum dry time about 4 minutes).

#### 5. Bonding Range

Once dry, these adhesives have a short bonding range (up to 8 to 12 minutes).

#### 6. Assembly

Position surfaces carefully before assembly. Bonding is immediate upon contact. Apply sufficient pressure to ensure good contact between coated surfaces. Bonded parts may be handled immediately.

#### 7. Reactivation

Greater immediate strength may be obtained by solvent reactivation. To solvent reactivate, coat both surfaces with adhesive and allow to dry tack free. Lightly wipe one surface with methyl ethyl ketone (MEK)\* and complete bonding within 30 seconds.

#### 8. Cleanup

Use a solvent such as 3M™ Scotch-Grip™ Solvent No. 2\* or No. 3\* or MEK\* to clean brushes immediately after use. Excess adhesive may be removed from other surfaces with 3M™ Citrus Base Industrial Cleaner\* or equivalent.

**\*Note:** When using solvents, extinguish all ignition sources including pilot lights and follow manufacturer's precautions and directions for use.

RF-7050

PN11418

**Storage**

Store product at 60-80F for maximum storage life. Higher temperatures can reduce storage life. Lower temperatures can cause increased viscosity.

**Shelf Life**

When stored at the recommended temperature and conditions in the original, unopened container this product has a shelf life of 12 months from date of shipment.

**Notice to Buyer: Exclusion of Warranties and Limitation of Liability**

All information supplied by Resin Formulators and E.V. Roberts is considered accurate, but is furnished upon the express condition that the person receiving it shall make their own tests to determine its suitability for their particular purpose. ***NO WARRANTY IS EXPRESSED OR IMPLIED REGARDING SUCH INFORMATION, THE DATA UPON WHICH THE SAME IS BASED, OR THE RESULTS TO BE OBTAINED FROM THE USE OF SUCH INFORMATION OR PRODUCT WILL NOT INFRINGE ANY PATENT. UNDER NO CIRCUMSTANCES SHALL RESIN FORMULATORS OR E.V. ROBERTS. BE LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES RESULTING FROM THE USE OR HANDLING OF ITS PRODUCTS, AND, IN ANY EVENT, LIABILITY FOR BREACH OF ANY WARRANTY OR CONTRACT WITH RESPECT TO SUCH PRODUCTS IS LIMITED TO THE NET SELLING PRICE OF THE PRODUCT OR THE REPLACEMENT THEREOF AT THE OPTION OF RESIN FORMULATORS OR E.V. ROBERTS.***

Revision: DOS 5-1-08