

HRJ 11331

Manufacturer: SI Group
 Classification: Thermoreactive p-alkyl-phenol formaldehyde adhesive resin
 Chemical Composition: p-t-Butylphenol formaldehyde polymer

| Specification Properties | Value | Test Method |
|--------------------------|---------|-------------|
| Color, CHcc | 1-7 | T04M01.03 |
| Gardner-Holdt Viscosity | D-N | T02M02.03 |
| Melting Point, °F | 200-220 | T06M01.01 |
| Methylol Content, % | 10-14 | T17M01.02 |
| Softening Point, B&R °C | 110-120 | T06M02.011 |
| Typical Properties | Value | Test Method |
| Physical Form | Flake | Visual |
| Specific Gravity | 1.10 | Typical |

> APPLICATIONS

Uses: Mainly used in solvent based polychloroprene or nitrile adhesives. Gives excellent green tack, cohesive strength, light color, good heat resistance and excellent storage properties. Has excellent solubility in aromatic hydrocarbons, chlorinated solvents, ketones and esters.

> PROCESSING

Direct Dissolving: All the components of the adhesive are dissolved in one step. The complex resin-magnesia is formed in situ during storage.

Pre-reaction: More often, however, the resin is put into solution in a mixture of solvents and is pre-reacted with the magnesia (high activity type) in the presence of water which acts as a catalyst. A level of 2 parts water per 100 parts of resins is recommended. One must consider the amount of water contained in industrial solvents. The formation of the resin-magnesia complex during the pre-reaction results in a color change and a slight increase in temperature and depends on the following parameters; reactivity of the magnesia, solvents system, temperature and time of pre-reaction, and percentage of water

The process with pre-reaction yields adhesives with a higher heat resistance and better storage stability.

> PACKAGING AND STORAGE

Packaging: 25 kg (55.1 lb.) bags.

Shelf Life: 1 year from date of manufacture if stored as indicated below.

Storage: Store in cool, dry storage area not to exceed 86°C for long periods of time in original packaging. Note: Resins of this type are known to agglomerate or sinter during storage. This condition does not affect the performance of the resin in its normal application and is not considered justification for rejection or return.

Specification Date: January 17, 2018