CILBOND® - ELASTOMER SELECTOR TICK GUIDE

	ACM	Vamac® G series	Vamac® DP series	IIR, Halo IIR	CR	CSM / ACSM	CPE	ECO	EPDM	NR / SBR Sulphur High	NR / SBR Medium Sulphur	NR / SBR Low Sulphur	BR, IR	PNR	NBR	XNBR	HNBR	PVC / NBR	Parel	VMQ Peroxide Cured	VMQ / Pd Cured Pt	FVMQ	FKM / FFKM Peroxide Cured	FKM Bisphenol / Bisamine Cured	EVM	Millable PU S / Peroxide Cured	Millable PU NCO Cured	Heat Resistance : Max temp for 48 hrs	Boiling Water Resistance : Hours	Glycol Resistance : Hours @ 160 °C	Salt Spray Testing : Hours to ≤4 mm	Pre-bake Resistance : Minutes @ 160 °C
SOLVENT BASED																																
Cilbond 10E	✓✓✓	✓✓	✓✓					✓✓✓							✓✓✓	✓✓✓	✓✓	✓✓✓										170°C	60h	100h	600h	30m
Cilbond 20	✓✓✓	✓✓✓	✓✓		✓✓	✓✓	✓✓	✓		✓✓✓	✓✓	✓✓	✓✓	✓✓✓		✓✓	✓		✓✓				✓✓		✓✓			220°C	100h	1000h	1000h	30m
Cilbond 23	✓✓	✓✓			✓✓✓	✓✓✓	✓✓	✓		✓✓✓	✓✓✓	✓✓	✓✓	✓✓✓		✓✓	✓✓		✓✓						✓			180°C	100h	1000h	500h	30m
Cilbond 24	✓✓	✓✓			✓✓✓	✓✓✓	✓✓	✓		✓✓✓	✓✓✓	✓✓	✓✓	✓✓✓		✓✓	✓		✓✓✓						✓			180°C	100h	1000h	500h	30m
Cilbond 33 A/B																					✓	✓	✓✓✓					250°C				
Cilbond 36	✓	✓✓	✓✓✓														✓✓			✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓	✓✓			230°C	100h	600h	400h	20m
Cilbond 49SF (+B)																											✓✓✓	180°C	100h		400h	2400m
Cilbond 12E / 80ET	✓✓	✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓	✓✓	✓✓	✓✓✓	✓✓	✓						✓✓✓	✓✓✓		180°C	100h	600h	500h	10-15m
Cilbond 20 / 82	✓✓	✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓✓✓	✓	✓✓✓	✓✓✓	✓✓✓	✓✓	✓						✓✓✓	✓✓✓		190°C	100h	1000h	1000h	10-15m
Cilbond 89ET	✓✓	✓	✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓						✓✓	✓✓	✓✓	170°C	20h	200h	300h	10-15m
WATER BASED																																
Cilbond 62W	✓✓✓	✓✓✓			✓✓			✓✓✓							✓✓✓	✓✓	✓	✓							✓			450°C	100h	1000h	1000h	30m
Cilbond 65W			✓														✓✓			✓✓✓	✓✓✓		✓✓✓					180°C	20h	100h	200h	20m

✓ Can be used

✓✓ Recommended

✓✓✓ Highly Recommended

Notes on Environmental Test Information

Heat Resistance : The highest temperature when parts are heated for 48 hours, whilst achieving ≥ 90% failure within the rubber.

Boiling Water Testing: No Rubber-Cement or Cement-Metal fail : Test halted at 100 hours (100 hours means no observed failure).

Hot Glycol Testing : Tests conducted at 160°C and halted when failure detected as blisters in bond-line and /or Cement-Metal failure

Salt-Spray Resistance : DIN/ISO 9227 2006; time to show <4mm edge failure with NR bonded parts; (10E was used under 80ET, 62W was used under CB R-7040, whilst 36 and 65W were tested with VMQ).

Pre-Bake Resistance : A typical maximum time parts can be heated, prior to moulding at 160°C, in minutes - pre-bake resistance is also compound dependent. 49SF is the max time for a 110°C pre-bake.

For more information, see the Cilbond Product Technical Data Sheets.

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