

**RV/MARINE ADHESIVES & SEALANTS PROPERTIES GUIDE**

KEY: ●Flammable Solvent-Based ◆Water-Based

PRODUCT NAME OR DESCRIPTION	PRODUCT NUMBER	BASE POLYMER	SOLIDS %	COLOR (DRY)	TYPICAL VISCOSITY (CPS)	TEMP RANGE	FEATURES
Rubber Roofing & Vinyl Flooring Adhesive	◆DC12243	Acrylic	56	Clear	4500	-30°F to 220°F	Very high solids water-based PSA. High peel strength and creep resistance. Excellent weather resistance.
Rubber Roofing & Vinyl Flooring Adhesive	●DC12008	Nitrile	30	Brown	1000	-35°F to 350°F	Suitable for brush, spray or roll-coat application. Good plasticizer resistance. Retains flexibility at low temperatures.
All Weather Sealant	●General Purpose (Non-Sag)	EPDM	63	Various	Extrudable	-65° to 210°F	Versatile high-solids, high viscosity sealant with excellent weather resistance; fills widest range of applications. Best for vertical surfaces.
All Weather Sealant	●Self-Leveling Sealant	EPDM	50	Various	Extrudable	-65°F to 210°F	Self-leveling high solids, high viscosity sealant for horizontal seams. Excellent weather resistance.
All Weather Sealant for Oil-Milled Surfaces	●Non-Sag and Self-Leveling	EPDM	Varies by Product	Various	Extrudable	-65°F to 210°F	Specially formulated to provide weather-tight seals to oil-milled metals. Excellent weather resistance.
Contact Adhesive	●M6302	Polychloro-prene	23	Yellow	450	-40°F to 280°F	Suitable for brush, spray or roll-coat application. Non-staining, good plasticizer resistance. Superior heat resistance.
Contact Adhesive	●M6306	Polychloro-prene	22	Yellow	400	-50°F to 250°F	Very fast drying with excellent early strength, and high ultimate strength. Long open time.
Contact Adhesive	●DC11957	Urethane	15	Clear	1300	-20°F to 150°F	Especially effective on flexible vinyl substrates. Highly resistant to oils, solvents and water. Retains flexibility at low temperatures. Resistance to 200°F can be achieved by adding M6566.
HAPs Free Contact Adhesive	DC12339	Synthetic Rubber	30	Light Amber	400	-20°F to 160°F	Immediate aggressive tack with long open time. Provides non-dimpling seams. Non-flammable solvent carrier (NPB)
HAPs Free Contact Adhesive	DC12340	Synthetic Rubber	35	Amber	60	-20°F to 160°F	Quick setting, fast drying. Sprays with low pressure. Acetone carrier.
Water-based Contact Adhesives	◆Hydra FAST-EM® Product line	Polychloro-prene or natural rubbers	Varies By Product	White (standard - can be tinted)	Varies By Product	-50°F to 240°F	Solventless - no VOC's. Environmentally friendly. Fast tack and excellent green strength. Easy clean up.
Plastic Adhesive	●M6562	ABS	42	Milky	40,000	-20°F to 400°F	Fast drying, solvent weld for permanent bond of ABS, PVC, and polystyrene. Best for flame retardant grades of ABS.
Plastic Adhesive	●M6546	ABS	47	Black	70,000	-20°F to 400°F	Adhesive/sealant for ABS and most other plastics. Fast permanent bonds. Extrudable.
Adhesive/Sealant	Silaprene® SolidSeal™	Urethane	98	Various	Extrudable	-40°F to 200°F	One-component, fast cure. Low VOC's. Bonds to most substrates. Recommended sealant for Marine applications above and below the waterline.
Adhesive/Sealant	Silaprene® SolidBond™	Urethane	98	Various	Extrudable	-40°F to 200°F	One-component, fast cure. High green strength for rivetless assemblies. Low VOC's. Bonds to most substrates.

**LIMITED WARRANTY AND REMEDY**

These products are warranted to the original purchaser to meet published specifications, if any, and, in the absence of published specifications, to be **MERCHANTABLE QUALITY**. Such warranty may not be assigned or otherwise transferred by purchaser. **NO OTHER WARRANTY, EXPRESSED OR IMPLIED, OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY OTHER THING IS MADE.** Purchaser's exclusive remedy for breach of this warranty shall be a refund of the price paid for the products by the purchaser. Except as stated above, Uniroyal Adhesives & Sealants shall not be liable for any defect in, or breach of obligation relating to the defects in this product, regardless of the theory that may be asserted, including, without limitation, negligence, contract, absolute liability in tort or misrepresentation. If the purchaser does not accept goods on these terms, they are to be returned at once, unopened.



Uniroyal Adhesives & Sealants  
2001 W. Washington St.  
South Bend, IN 46628  
800-999-GLUE

**ROYAL**  
ADHESIVES & SEALANTS



**Adhesives & Sealants**



**For the Highways or the High Seas, Count on Holding Power from R O Y A L ADHESIVES & SEALANTS**

# High Performance Adhesives and Sealants

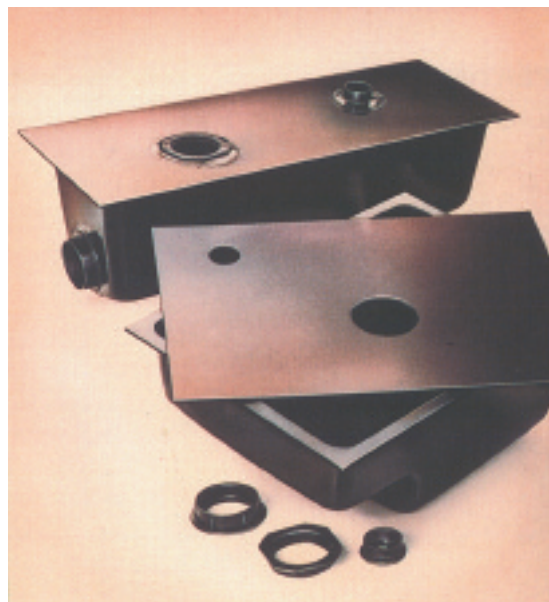
## Specialty Adhesives

In addition to the Silaprene® products shown on these pages, Royal Adhesives & Sealants has over 200 standard products to solve bonding and sealing problems. Our technical advisers and fully staffed laboratory are always available to develop solutions for your special applications.

**PRESSURE SENSITIVE:** Where quick-stick and one-way application is preferred, Silaprene PSAs can be supplied in both solvent-based and water-based formulations.

**CONTACT BOND:** When bonding dissimilar materials, a high strength adhesive applied to both surfaces provides a more permanent bond. Silaprene adhesive compounds are available for virtually all materials used in RV manufacturing.

**SOLVENT WELD:** A preferred method of joining plastic to itself. Silaprene solvent-weld adhesives provide a bond that is usually as strong as the plastic material.



## All-Weather Sealants

A Silaprene family of exterior sealants with exceptional weather resistance. Formulated in viscosities for general purpose, non-sagging vertical or self-leveling horizontal applications. Each sealant is paintable and available in a wide range of standard and custom colors. No tooling necessary, remains clean looking and will not peel with aging.

**APPLICATIONS:** Roofs of all types (especially formulated for EPDM membranes), windows, doors, trim, sidewalls, vent opening, baggage doors.

**SUBSTRATES/MATERIALS:** Painted or clean metal surfaces; polyethylene and other plastics; EPDM and other rubber compounds; glass, masonry and wood.

## Plastic Adhesives

**Silaprene M6562 and M6546** are adhesives that provide strong permanent bonds for ABS plastics. Silaprene M6562 provides a solvent-weld type bond. Silaprene M6546 is a higher viscosity adhesive/sealant extrudable manually or by machine.

**APPLICATIONS:** Permanent bonding for butt seaming ABS holding tanks and other applications.

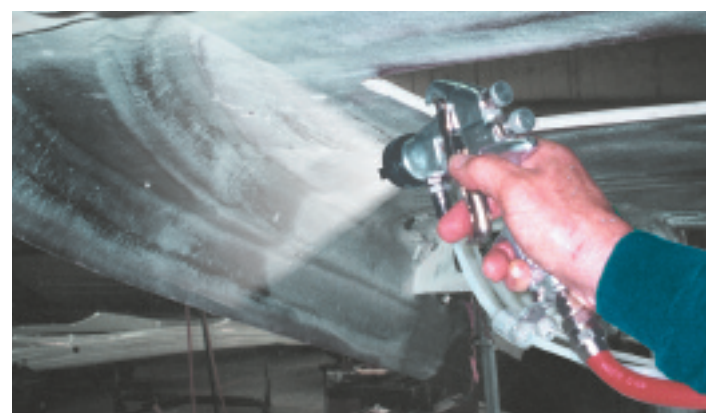
**SUBSTRATES/MATERIALS:** ABS (including flame-retardant types such as Royalite 59), Rovel, rigid vinyl, and rigid polystyrene.

## High Performance Adhesive/Sealant

**Silaprene Adhesive/Sealant** is the premier product when high bond strength is required in a sealant. Remains resilient and grows stronger with age. Outstanding resistance to UV, heat, cold, moisture, oils, gasoline and highway chemicals. Available in a range of viscosities and colors. Paintable.

**APPLICATIONS:** Wherever a high bond strength sealant is required. Especially suitable for bonding dissimilar materials such as fiberglass to metal. Used for bonding metal roofs to roof bows.

**SUBSTRATES/MATERIALS:** Bonds and seals metals, fiberglass, wood, glass.



## Water-Based Spray Contact Adhesives

**Hydra FAST-EN®** sprayable contact adhesives are designed to bond any porous surface (such as open cell foam) to a wide variety of porous and non-porous surfaces. They are used in applications where using solvent-based systems may be either a health or environmental concern. A wide variety of formulations are available to match the performance and processing requirements of your application. They are compatible with most standard spray systems. Sprayed parts can be bonded within seconds after application of the adhesive and exhibit excellent green strength.

**APPLICATIONS:** RV furniture and Marine seating manufacturing, headliners and carpeting.

**SUBSTRATES/MATERIALS:** Bonds foam, carpet, foam-backed vinyl headliner material, metal, wood, fiberglass and other plastics.

## Rubber Roofing and Vinyl Flooring Adhesives

**Silaprene® DC12243** is a water-based pressure sensitive adhesive especially formulated for bonding EPDM rubber roof membranes to RV roof decks and Koroseal® vinyl floor matting to wooden floor decks. **Silaprene® DC12008** is also available for flooring applications where a quick solvent based contact type adhesive is desired. These products have superior bond strength and exhibit outstanding resistance to heat, cold, and moisture. Excellent for bonding carpeting as well.

**APPLICATIONS:** Motorhomes, travel trailers, bus conversions, truck campers, horse trailers and specialty RV applications.

**SUBSTRATES/MATERIALS:** Bonds rubber, EPDM, vinyl, wood, metal, fiberglass, foam, plastics, glass, fabric and painted surfaces.

## SolidSeal™

**Silaprene SolidSeal™ and SolidBond™ High Solids-Low VOC Adhesive/Sealants** are one-component, permanently flexible polyurethane products that cure in the presence of atmospheric moisture to produce high strength bonds that can replace rivets, welds and other fasteners.

**Silaprene® SolidSeal™** is also ideal for sealing applications in a marine environment both above and below the waterline with excellent adhesion to wood and fiberglass.

**APPLICATIONS:** Waterproofing lap seams, bonding and sealing metal or fiberglass roofing materials to roof bows, interior and exterior sidewalls. Weather resistant seals on joints and boat hardware (not recommended for sealing wood deck seams due to possible softening by certain teak cleaners).

**SUBSTRATES/MATERIALS:** Excellent adhesion to metals (bare and pre-painted), plywood, glass, fiberglass, Kemlite® and other plastics.



## Solvent Based Contact Adhesives

**Silaprene® M6302 and DC11957** are high strength solvent-based contact adhesives designed for bonding vinyl coated and other fabrics to metal, fiberglass, plastics and foam for RV furniture and marine seating applications. **DC12239 and DC12340** are **HAPs Free** products designed to bond foam to itself and many other materials. DC12339 is made with NPB, a non-flammable carrier, and DC12340 is acetone based.

**APPLICATIONS:** Interior and exterior applications including side-walls, doors, metal and fiberglass roof panels, and counter tops as well as seating applications.

**SUBSTRATES/MATERIALS:** Bonds almost all types of plastics, metals, wood, foam and fabric. Bonds various skin materials to honeycomb cores.



**Hydra FAST-EN®**

**Silaprene®**

**ROYAL**  
ADHESIVES & SEALANTS