HRJ-1367

Description

HRJ-1367 is an oil-soluble, heat-reactive, phenolic resin based on a para-substituted alkylphenol. This resin is used in the formulation of polychloroprene contact cements with good green strength and heat resistance. The outstanding features of this resin are its high reactivity, narrow molecular weight, and light color.

General Product Data

Product Specifications:

Softening Point, B&R, (°C)	92 - 100
Methylol Content, (%)	14 – 18
Color, Gardner, 64% Solution in Toluene	1 – 6
Gardner Holdt Viscosity, 64% solution (sec)	18 - 26

Test Methods available upon request

Typical Properties:

Specific Gravity	1.10
Physical Form	Flake

Solubility:

HRJ-1367 is soluble in aromatic and aliphatic hydrocarbons, esters, ketones and higher alcohols.

Application

HRJ-1367 is used in high performance polychloroprene contact cements and pressure sensitive adhesives. It can also be used in formulating hard ink resins and coatings with high chemical resistance. HRJ-1367 is formed by reacting formaldehyde with a phenol derivative listed in 21CFR 175.300(b)(3)(vi)(a). HRJ-1367 is completely compatible with polychloroprene and nitrile rubbers. It has a compatibility limit of approximately 25 parts by weight in combination with 100 parts by weight of SBR, natural, and reclaimed rubbers. In polychloroprene contact cements, HRJ-1367 imparts good green strength, extends open tack time, increases heat resistance, increases specific adhesion of the film to metal and glass, and increases the cohesive strength of the adhesive film itself.

Typical Contact Cement Formula

Part A: Rubber Base:

Material	Parts by Weight
Polychloroprene AD	100.0
Zinc Oxide	5.0
Magnesium Oxide	4.0
Ethanox® antioxidant[1]	2.0

Dissolve to 25 percent solids in solvent of choice.

Part B: Resin Pre-Reaction:

Material	Parts by Weight
HRJ-1367	75.0
Magnesium Oxide	7.5
Water	2.0

Dissolve to 50 percent solids in solvent of choice. Agitate a minimum of three hours.

Finished Adhesive:

Add **Part B** to **Part A** with mixing to complete the formulation.

1 Product of SI Group Inc. – Ethanox® 310, Ethanox® 4702

Storage And Shelf Life

HRJ-1367 should be stored where temperatures do not exceed 86 ºF (30 °C) for long periods of time. For best results, it is recommended that this product be used within 1 year of manufacture date. As with all phenolic resins, HRJ-1367 will become darker with age. Pallets should never be stored double stacked.

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.

Packaging

HRJ-1367 is packaged in bags at 25 kilograms net weight, stretch-wrapped on pallets.

Safety And Regulatory Information

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For a current Safety Data Sheet (SDS) or other regulatory information, contact SI Group, Inc. at productinfo@siigroup.com.