

# SP-134

## Description

SP-134 is a modified alkylphenol-formaldehyde resin used in making polychloroprene contact cements that require long open times. SP-134 is formed by reacting formaldehyde with a phenol derivative listed in 21CFR 175.300(b)(3)(vi)(a).

## General Product Data

### Product Specifications:

Melting Point, Capillary Tube (°F)	140 - 165
Melting Point, Capillary Tube, (°C)	60 - 75
Color, Gardner, 60% in Toluene	1 - 7
Gardner-Holdt Viscosity, 60% Solution	C - H
Methylol Content, (%)	13 - 18

Test Methods available upon request

### Typical Properties:

Specific Gravity	1.10
Physical Form	Flake

### Solubility:

SP-134 is soluble in aromatic and aliphatic hydrocarbons, esters, ketones, and partially in higher alcohols.

## Application

SP-134 is extensively employed in the preparation of general -purpose and heat-activating polychloroprene cements. It can also be used in formulating adhesives with NBR, SBR, natural and reclaimed rubbers. SP-134 is completely compatible with nitrile and polychloroprene 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 adhesives, SP-134 increases open time and cohesive strength of the adhesive film.

## Typical Contact Cement Formula

### Part A: Rubber Base:

Material	Parts by Weight
Polychloroprene AD	100
Zinc Oxide	5
Magnesium Oxide	4
Ethanox® antioxidant	2

Dissolve to 25 percent solids in solvent of choice.

### Part B: Resin Pre-Reaction:

Material	Parts by Weight
SP-134	45
Magnesium Oxide	4.5
Water	2

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

SP-134 should be stored where temperatures do not exceed 86 °F (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, SP-134 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

SP-134 is packaged in bags at 25 kilograms net weight, stretch-wrapped on pallets.

## **Safety And Regulatory Information**

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