

HARTDUR E333

Description **HARTDUR E333** is an established, universal curing agent for adhesives based on hydroxyl polyurethane, natural and synthetic rubber.

Specification

Chemical composition	Contain 27% thiophosphoric-tris- (4-isocyanato-phenyl ester) and 73% ethyl acetate.
Appearance	Clear, yellow to brownish liquid
NCO content, % by weight	7.2 ± 0.2
Solubility	Soluble in acetone, toluene and methyl ethyl ketone.
Storage stability	Reacts readily with moisture. For best life, it should be stored under dry and 5°C -- 32°C.

Performance similar to Bayer's Desmodur RFE

HARTDUR E333 shows good bonding strength in PVC with much plasticizer, SBR with plenty of oil, coating leather, silk and so on.

HARTDUR E333 not only can substitute for Bayer's Desmodur RFE but even more satisfactory with the aspect of environmental protection and industrial hygiene.

Compatibility with solvents **HARTDUR E333** can be diluted with anhydrous and alcohol-free ethyl acetate dichloropropane, trichloroethylene, acetone, methyl ethyl ketone, toluene, and other organic solvents. When adding in a large proportion of **HARTDUR E333**, aliphatic hydrocarbons would cause turbidity; but solutions of natural rubber in aliphatic hydrocarbons show good compatibility with **HARTDUR E333**, without any addition of solvents.

Application After the addition of a proper **HARTDUR E333**, the ready-for-use adhesive should be applied within a period (potlife) which is determined not only by its content of rubber, but also by the other ingredient of the formulation (resins, antioxidants, solvents, etc.). As the potlife elapses, it generally extends over several hours or one workday, the adhesive becomes increasingly difficult to apply and its viscosity increases rapidly until irreversible gelling ultimately occurs.

Suggested addition

For curing 100 p.b.w. adhesive based on:		
Graft- Chloroprene rubber		
(rubber content approx. 16%)	3-5 p.b.w.	HARTDUR E333
Chloroprene rubber		
(rubber content approx. 20%):	5-7 p.b.w.	HARTDUR E333
Hydroxyl polyurethane		
(polyurethane content approx. 16%)	3-5 p.b.w	HARTDUR E333

Packing

A: 20 bottles in each carton, 0.75 kg in each aluminum bottle
B: 180 kgs in each iron drum