



# CILBOND® - ELASTOMER SELECTOR TICK GUIDE

SOLVENT BASED	ACM	Vamac® G series	Vamac® DP series	IR, Halo IIR	CR	CSM / ACSM	CPE	ECO	EPDM	NR / SBR High Sulphur	NR / SBR Medium Sulphur	NR / SBR Low Sulphur	BR, IR	PNR	NBR	XNBR	HNBR	PVC / NBR	Parel	VMQ Peroxide Cured	VMQ Pt / Pd Cured	FVMQ	FKM / FFKM Peroxide Cured	FKM Bisphenol / Bisamine Cured	EVM	Mililable PU S / Peroxide Cured	Mililable PU NCO Cured	Heat Resistance : Max temp for 48 hrs	Boiling Water Resistance : Hours	Glycol Resistance : Hours @ 160°C	Salt Spray Testing : Hours to 54 mm	Pre-bake Resistance : Minutes @ 160°C		
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
<b>WATER BASED</b>																																		
Cilbond 62W	✓✓✓	✓✓✓			✓✓			✓✓✓							✓✓✓	✓✓	✓	✓								✓				450°C	100h	1000h	1000h	30m
Cilbond 65W			✓														✓✓			✓✓✓	✓✓✓		✓✓✓							180°C	20h	100h	200h	20m

**Notes on Environmental Test Information**

- ✓ Can be used
- ✓✓ Recommended
- ✓✓✓ Highly Recommended

**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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