

# PRODUCT DATA

## VINYLOK - C CLUTCH PLATE ADHESIVE

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### PRODUCT DESCRIPTION

**VINYLOK-C** is a Fast Reactive viscous solution of Vinyl Phenolic resin in Methanol & Chlorinated Hydro Carbon. This product is supplied for application as moulded Clutch plate adhesive used in, Locomotive & Automobiles industries.

### PHYSICAL PROPERTIES

Specific Gravity	:	1.0
Flash Point	:	23 deg. C
Non Volatiles	:	37 +/- 2 %
Viscosity at 25 deg. C	:	500 - 1000 CPS
Cloud Point	:	< 10 deg C

### APPLICATION OF PRODUCT

Method	:	VINYLOK-C is capable of application by spray, brush or roller and should be applied only to the steel back material.	
Drying	:	At 25-35 deg C	: Overnight (or)
		At 70 deg C	: 20-30 Minutes
Curing	:	( 0.35-1.0 MPa Pressure)	
		180 deg C	: 3 Minutes
		165 deg C	: 5 Minutes
		150 deg C	: 7 Minutes

### PROPERTIES OF CURED PRODUCT

Superior weather, water, chemical and heat resistance (-20 deg C + 300 deg C). The following properties were determined using Test Methods indicated below. They are provided solely as Technical information and do not constitute a product specification.

Substrate	:	Bright mild steel back plate / fabricated clutch plates / All grades of Al.die casted / Zn alloy etc. Friction Material - Green Staged Biscuits (for various types see results)
Pretreatment	:	Substrate - Degrease / shotblast and degrease. Optional : Chromatize compatible
Preparation	:	Brush Apply / Roller coat / Spray adhesive on to the steel Plate.
Drying	:	Overnight at ambient or 70 deg. C 20 minutes
Curing	:	Integral Hot Mounting : 150 deg. C for 5-7 mins. at 350-650 KSC Pressure. Pack & Back : 650 KSC Pressure / 220 - 240 deg. C bake. Clamp & Cure : 11 KSM pressure / 180 - 220 deg.C / 30 - 60 minutes
Test	:	Shear Stress at 25 deg.C / 200 deg.C and 300 deg.C ( ISO 6312/ SAEJ 840).

Typical failure Stress (KSC) for at Temp. ----->

25C	200C	300C
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Asbestos Type	70	50	65
Non-Asbestos Organic	60	45	55
Non-Asbestos Metallic	65	50	60

All tests resulted in shear within the friction material (Type : 7 as per SAEJ 840).

**SHELF LIFE : 6 months @ temp. 30-40deg.C**

### Packaging

**VINYLOK- C** is available in 5, 10 and 25 liter containers.

## **INDIAN FRICTION MATERIAL ENGG. CO.**

C-41 Sector B-2, Tronica City Industrial Area , UPSIDC  
Loni , Ghaziabad - 201103 (UP) India. Ph-09582180826  
e-mail : fricmart1@gmail.com : www.fricmart.com