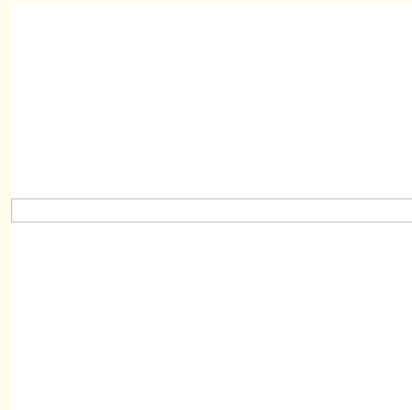


Solvent-Based Rubber-to-Metal Bonding Primer Thinkbond 11H for Multi-Layer Adhesive Vulcanization Systems

Our Product Introduction

Basic Information

- Place of Origin: Shanghai, China
- Brand Name: Thinkbond
- Certification: ISO 9001:2015
- Model Number: 11H
- Minimum Order Quantity: 20 kg
- Price: USD 12-28 / kg
- Packaging Details: 5kg/can, 20kg/pail, or customized packaging available
- Delivery Time: 7-15 working days
- Payment Terms: T/T, L/C, Western Union
- Supply Ability: 5000 kg per month



Product Specification

- Application: Primer Layer For Rubber To Metal Bonding Systems, Undercoat For Cover Cement Adhesives
- Function: Multi-layer Adhesive Primer
- Appearance: Dark Liquid
- Form: Liquid
- Compatible Cover Cements: Thinkbond 27MS And Other Cover Cement Adhesives
- Diluents: Xylene Or Compatible Solvent
- Substrate Compatibility: Steel, Aluminum, Brass, Treated Metal Surfaces
- Application Methods: Brushing, Spraying, Dipping
- Drying Time: Approximately 15-30 Minutes At 20°C
- Shelf Life: 1 Year In Closed Can Below 25°C
- Highlight: **Solvent-Based rubber adhesive primer, Rubber-to-metal bonding primer, Multi-layer adhesive vulcanization primer**

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Product Description

Thinkbond 11H is a specialized solvent-based primer engineered as the critical foundation layer in multi-coat rubber-to-metal bonding systems. In demanding applications where maximum bond strength, environmental durability, and long-term reliability are non-negotiable, a properly selected and applied primer layer makes the decisive difference between exceptional bonding performance and premature bond failure. Thinkbond 11H has been formulated to optimize the interfacial adhesion between metal substrates and cover cement adhesives such as Thinkbond 27MS, creating a chemical bridge that dramatically enhances the overall bond strength, corrosion resistance, and environmental durability of rubber-to-metal assemblies operating in challenging conditions.

The primer layer serves multiple essential functions in the bonding system that go beyond simple adhesion enhancement. Thinkbond 11H provides superior wetting and coverage of metal surfaces prepared by grit blasting, phosphating, or galvanizing treatments, ensuring complete interfacial contact between the adhesive system and substrate. It creates a corrosion-resistant barrier that protects the metal surface during storage and processing before rubber molding, and establishes a compatible chemical interface that promotes covalent bond formation with both the metal substrate and the subsequent cover cement layer during vulcanization. These combined functions make Thinkbond 11H indispensable for manufacturers producing high-performance rubber-to-metal bonded components for automotive, aerospace, industrial, and marine applications.

Key Features

- Superior Adhesion Enhancement:** Dramatically increases the bond strength and reliability of multi-layer rubber-to-metal adhesive systems by providing an optimized chemical interface between metal substrates and cover cement adhesives.
- Multi-Layer System Foundation:** Specifically designed as the primer layer in two-coat bonding systems, compatible with Thinkbond 27MS and other cover cement adhesives for maximum bonding system design flexibility.
- Corrosion-Resistant Protective Barrier:** Provides effective corrosion protection for prepared metal surfaces during the interval between surface preparation and rubber molding, preventing oxidation that can compromise bond quality.
- Excellent Surface Wetting Properties:** Achieves complete coverage and penetration of grit-blasted, phosphated, galvanized, and KTL-treated metal surfaces, ensuring no interfacial voids that could become bond failure initiation sites.
- Broad Substrate Compatibility:** Proven performance on carbon steel, stainless steel, aluminum alloys, brass, and chemically treated metal surfaces commonly used in rubber-to-metal bonded component manufacturing.
- Flexible Application Methods:** Compatible with brushing, conventional air spray, and dipping application techniques, with recommended drying times of 15-30 minutes at 20°C for efficient production workflow integration.
- Thermal Stability Under Vulcanization:** Maintains chemical integrity and bonding functionality across the full range of rubber vulcanization temperatures, ensuring consistent performance regardless of curing profile variations.

Technical Specifications

Parameter	Specification
Product Code	Thinkbond 11H
Product Type	Rubber-to-metal bonding primer
Appearance	Dark liquid
Form	Liquid
Diluents	Xylene or compatible solvent
Application Methods	Brushing, air spray, dipping
Recommended Spray Nozzle	1.0 mm at 3-4 bar air pressure
Drying Time at 20°C	Approximately 15-30 minutes
Compatible Cover Cements	Thinkbond 27MS and other cover cement adhesives
Shelf Life	1 year in closed can below 25°C

Applications

Thinkbond 11H is an essential component of high-performance rubber-to-metal bonding systems used in applications where maximum bond strength and reliability are required. Primary application scenarios include automotive engine mount and torque strut manufacturing where the primer layer ensures bond integrity under extreme dynamic loading, suspension bushing production requiring long-term environmental durability, industrial vibration isolation mount manufacturing, marine component bonding where corrosion resistance is critical, and any rubber-to-metal bonding application where a two-coat adhesive system provides measurably superior performance compared to single-coat alternatives. The primer is compatible with all standard metal surface preparation methods and should be applied within the recommended timeframe after metal surface preparation to prevent re-oxidation of the prepared surface.

Packaging & Quality Assurance

Thinkbond 11H is supplied in standard 5kg/can and 20kg/pail packaging with moisture-resistant closures. Customized packaging configurations are available for automated production line dispensing systems. Each production batch undergoes comprehensive quality testing including adhesion promotion effectiveness verification in standard two-coat bonding systems, corrosion resistance evaluation on prepared metal coupons, viscosity and application consistency testing, and compatibility verification with target cover cement adhesives. Manufactured under ISO 9001:2015 quality management standards, Thinkbond 11H delivers the consistent primer performance that manufacturers of critical rubber-to-metal bonded components require. Shanghai LoreChem Co., Ltd. offers dedicated technical support including bonding system design consultation and application process optimization services.



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