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PRODUCT BULLETIN

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VULCANIZED JOINT PROCEDURE

CEMENT MIXING INSTRUCTIONS:

Cut uncured rubber into 1/8" to 1/4" pieces.

Mix 20 parts uncured rubber to 80 parts Methyleneethylketone (MEK).

Stir until dissolved.

Note: An alternative procedure is to stir and let sit overnight. Stir again in the morning to insure proper dispersion. Do not apply excessive heat during the stirring process.

Store in a cool or refrigerated area. Shelf life before adding MEK is three months. Shelf life after mixing is one week.

VULCANIZING INSTRUCTIONS:

Step 1 – Cut gasket to length with butt-cut ends.

Step 2 – Sand joint area to roughen.

Step 3 – Wash joint area with MEK.

Step 4 – Apply thin layer of vulcanizing cement to each end of the gasket.

Step 5 – Let air dry for twenty minutes.

Step 6 – Place joint area in vulcanizing die.

Step 7 – Mold gasket for twenty minutes at 285°F.

Step 8 – Let molded gasket cool for one hour before checking the bond.

Note: Always keep joints clean. Never touch joints with hands after cleaning. Contamination and incorrect mold temperature are the chief causes of rejects. Above instructions are for Nitrile only. Consult Utex for other materials.

NOTE: Minimum cord gasket I.D. dimensions are as follows:

<u>Cross-Section</u>	<u>Min. I.D.</u>	<u>Cross-Section</u>	<u>Min. I.D.</u>
to 1/4"	3"	9/16"	7"
5/16"	4"	5/8"	8"
3/8"	5"	3/4"	8"
1/2"	6"	1"	8"