

输送带冷硫化粘接解决方案

XN300 高强度橡胶粘接剂用户手册

Cold vulcanization bonding solution for conveyor belts
XN300 High Strength Rubber Adhesive User Manual

- ▣ 输送带接头冷粘
- ▣ 橡胶衬板粘接
- ▣ 输送带修补条粘接
- ▣ 输送机滚筒与橡胶板粘接
- ▣ Cold adhesion of conveyor belt joints
- ▣ Adhesive bonding of rubber lining plate
- ▣ Adhesive bonding of conveyor belt repair strip
- ▣ Adhesive bonding between conveyor drum and rubber sheet



小新 大不同 Little Change. Big Difference

胶小新XN300 高强度橡胶粘接剂是一种高强度、快固型氯丁胶粘剂，由A、B双组份组成，A为树脂、B为固化剂，A：B重量比为25：1。本品具有低粘度、快固化（强度提升快）、初粘力大、阻燃、高强度等特点，适用于橡胶与橡胶粘接、橡胶与金属粘接、橡胶与织物粘接、织物间粘接等，是输送带接头冷粘、输送机滚筒与橡胶板粘接、橡胶衬板粘接等的理想粘接剂。

规格：10组/箱；1040g/套（A树脂，1000g/罐；B固化剂，40g/瓶）

Jiaoxiaoxin XN300 high-strength rubber adhesive is a high-strength, fast curing chloroprene adhesive composed of two components: A and B. A is the resin, B is the curing agent, and the weight ratio of A to B is 25:1. This product has the characteristics of low viscosity, fast curing (fast strength improvement), high initial adhesion, flame retardancy, high strength, etc. It is suitable for rubber to rubber bonding, rubber to metal bonding, rubber to fabric bonding, fabric to fabric bonding, etc. It is an ideal adhesive for cold bonding of conveyor belt joints, adhesive bonding between conveyor drum and rubber sheet, rubber lining bonding, etc.

Specification: 10 sets/box; 1040g/set (resin A, 1000g/can; curing agent B, 40g/bottle)



技术特点：

- 1、粘度低，更易涂刷、薄刷且更容易渗透润湿粘接面，增强粘接力；
- 2、适用于80℃以下工况，安全阻燃，井上、井下作业均适用；
- 3、初粘力大，橡胶粘接时可快速定位。

Technical features:

1. Low viscosity, easier to apply and thin brush, and easier to penetrate and wet the bonding surface, enhancing adhesive strength.
2. Suitable for working conditions below 80 °C, safe and flame-retardant, suitable for both above and below ground operations.
3. High initial adhesion, quick positioning during rubber bonding.



使用方法及注意事项 Usage and precautions

第1步——表面处理

将粘接面打磨粗糙并清理干净，确保表面无油污、水等；

Step 1- Surface Treatment

Polish the bonding surface rough and clean it thoroughly, ensuring that the surface is free of oil, water, etc.

第二步——调配胶液

将A、B组份按25:1的比例混合并搅拌均匀；

注意：调配好的胶液需在2小时内用完。

Step 2- Prepare the glue solution

Mix components A and B in a ratio of 25:1 and stir evenly.

Attention: The prepared adhesive solution should be used up within 2 hours.

第三步——涂刷胶液

将胶液均匀涂刷于待粘接表面（涂刷很深薄的一层即可）。待第一遍涂刷的胶液晾干后（晾置时间不少于30分钟，可用碘钨灯适当烘烤），涂刷第二遍胶液。

注意：若在冬季低温环境下，第一遍涂胶后需用热风枪或碘钨灯适当加热。

Step 3- Apply adhesive solution

Apply the adhesive evenly to the surface to be bonded (apply a very deep and thin layer). After the first coat of adhesive has dried (with a drying time of no less than 30 minutes, and can be dried appropriately with an iodine tungsten lamp), apply the second coat of adhesive.

Attention: If it is in a low-temperature environment in winter, it is necessary to heat it appropriately with a hot air gun or iodine tungsten lamp after the first coat of glue.

第四步——粘接

待第二遍涂刷的胶液晾至不粘手且有轻微粘力感时，将粘接面对齐贴合，反复锤击排除中间空气，使粘接面紧密贴合。

注意：第二遍涂胶后晾晒时间10分钟左右（不同环境、温度时间有所变化），注意不要在湿态或过干的时候粘接。冬季低温工况下可轻微加热。

Step 4- Bonding

When the adhesive solution for the second coat is not sticky to the hand and has a slight adhesive feeling, apply the adhesive surface to the adhesive and repeatedly hammer it to remove any air in the middle, so that the adhesive surface is tightly adhered.

Attention: After the second coat of glue, let it air dry for about 10 minutes (the time may vary depending on the environment and temperature). Be careful not to stick it when it is wet or too dry. Mild heating is possible under low temperature conditions in winter.

第五步——固化

粘接72小时后可达到较高的粘接强度但不是最大强度，延长固化时间强度还会进一步提高直至达到最大强度。

Step 5- Curing

After 72 hours of bonding, a high bonding strength can be achieved, but it is not the maximum strength. Extending the curing time will further increase the strength until it reaches the maximum strength.

注意事项：

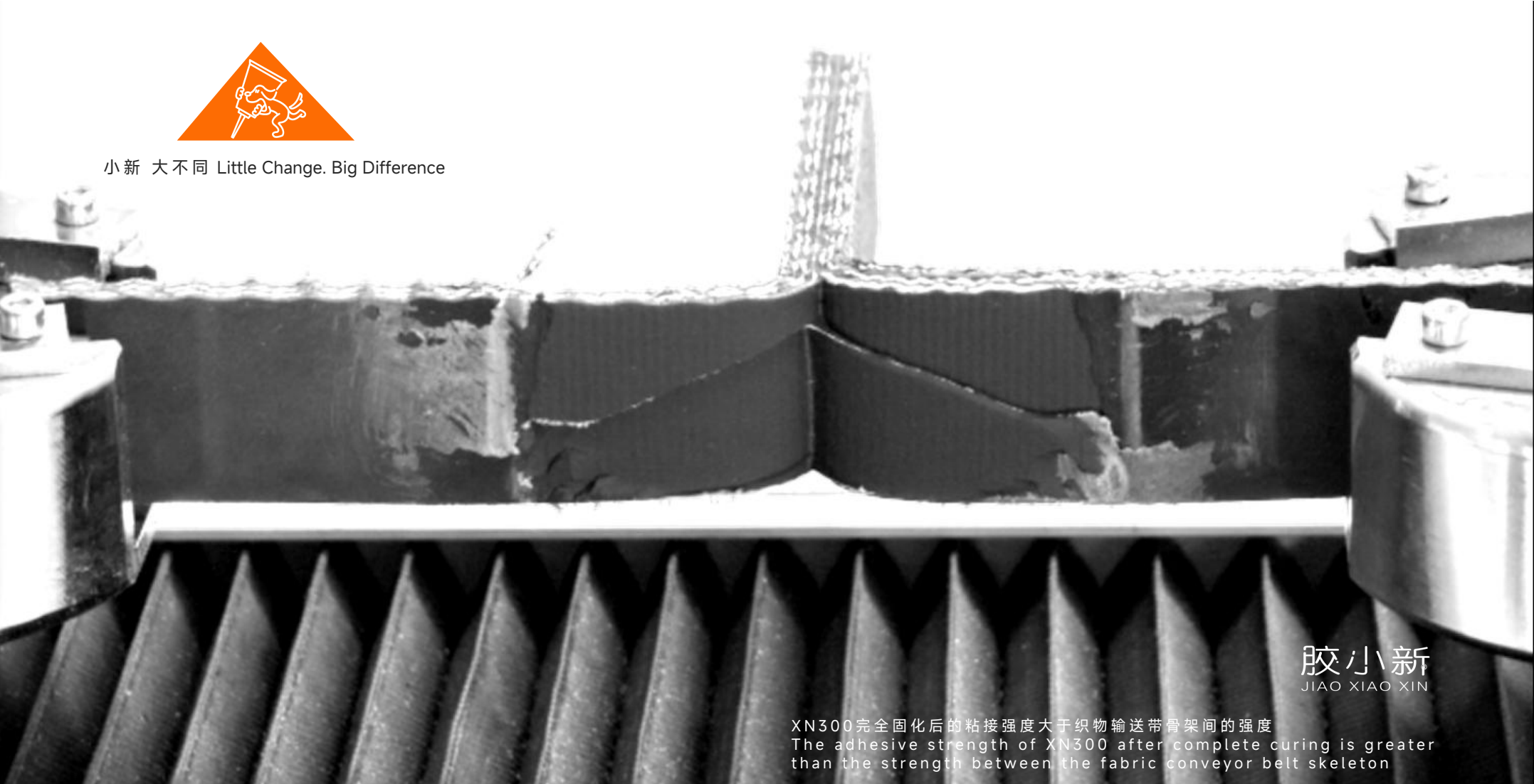
- 1、确保粘接表面无水、油污等；
- 2、本品仅用于80℃以下工况；
- 3、施工环境温度不得低于15℃，湿度不高于90%；
- 4、若在低温环境下施工，需要延长固化时间并采取必要的加热措施；
- 5、本品含挥发性溶剂，请确保施工场所通风。

Matters needing attention:

1. Ensure that the bonding surface is free of water, oil stains, etc;
2. This product is only used for working conditions below 80 °C;
3. The construction environment temperature shall not be lower than 15 °C, and the humidity shall not exceed 90%;
4. If construction is carried out in a low-temperature environment, it is necessary to extend the curing time and take necessary heating measures;
5. This product contains volatile solvents, please ensure ventilation in the construction site.



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胶小新
JIAO XIAO XIN

XN300完全固化后的粘接强度大于织物输送带骨架间的强度
The adhesive strength of XN300 after complete curing is greater than the strength between the fabric conveyor belt skeleton

联系方式：

〈注意〉

本手册所列数据信息为实验室测试结果，不能保证在其它环境下也有相同结果。
Attention The data information listed in this manual is laboratory test results and cannot guarantee the same results in other environments.

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生产：山东三新新材料科技有限公司

地址：山东省潍坊市昌乐朱刘化工产业园309国道南92号

电话：0536-7101316

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