

Rubber Product Manual

Tire Mold Patterning Rubber

HKRUB series products, which are model rubbers, are two-component liquid rubber to perfectly replicate the master model designed in the process of manufacturing molds for tire manufacturing or molds for similar metal products. HKRUB series products are used by mixing the main material (Part-A) and hardener (Part-B) in an appropriate ratio. Products of various mixed viscosity and hardness are available to suit a variety of user needs. HKRUB products are very excellent with an error rate of less than 0.01% in replication accuracy, which is the most important performance of casting rubber, and can perfectly replicate tire patterns and metal product molds with a thickness of 0.2 mm or fine and complex patterns.

Product Appearance



<Part-A>



< Part-B >

- **Products**

1. Part A: HKRUB200, HKRUB300, HKRUB400
2. Part B: HKRUBK200

- **How to Use**
 - 1. To improve the physical properties of the product, stir Part A and Part B evenly for about 3 minutes before use.
 - 2. Put Part A and Part B in a clean container at an appropriate ratio (Part A 100: Part B 14) and mix evenly with a mixing machine for at least 2 minutes. Be careful about the bottom and side of the container.
 - * Mixing amount: Mix one sector with one sector.
 - * Mixing ratio: Adjustable according to product quality and work environment (Use range: 12 - 16%, Recommended mixing ratio: 14%)
 - 3. Preparation Before Use
 - ① In order to facilitate the removal of rubber and the master model, apply mold release agent to the entire surface of the master model if applicable. After application, dry using an air gun or air-dry for more than 30 minutes (Use a soft brush when applying).
 - ② Apply adhesive to improve adhesion between rubber and model case surface (Use a soft brush when applying).

- **Precautions for Storage and Mixing**
 - 1. Part A & Part B storage temperature: 25 - 30 °C (Optimal temperature for use: 23 - 25 °C)
 - 2. Wear safety equipment for workers: Wear safety shoes, protective glasses, rubber gloves, and masks before work.
 - 3. Perform stirring in a well-ventilated place.
 - 4. Use as soon as possible.

- **Hardening Conditions**
 - 1. Part A and Part B should be applied at the optimum temperature of 23 - 25 °C.
 - 2. Workroom temperature: Maintain room temperature above room temperature (20 °C or above) (Recommended temperature: 25 - 30 °C).
 - 3. Hardening time: 16 hours or more
 - 4. The hardening rate is faster at temperatures higher than the product temperature of 25 °C and slower at lower temperatures.
 - 5. Avoid using the product at temperatures below 20 °C and above 30 °C.
 - * Please comply with the usage standards.

- **Precautions for Use**
 - 1. Please familiarize yourself with the MSDS of the HKRUB Series before use.

- 2. In case of product contact with eyes: Wash with a large amount of water or saline solution for 10 - 20 minutes until no chemicals remain. Take medical attention immediately.
- 3. In case of product contact with skin: Wash with mild detergent or large amount of water for 10 - 20 minutes until no chemicals remain. Take medical attention immediately.
- 4. In case of inhalation of the product: Provide fresh air and, if necessary, perform artificial respiration. Take medical action immediately.
- 5. In case of ingestion of the product: Perform gastric lavage within 15 minutes and take medical action immediately.
- 6. Doctor's note: No specific antidote. Treat supportively according to symptoms.

- **Product Properties**

HKRUB Series products have 3 types of main material Part-A (HKRUB200, HKRUB300, HKRUB400) and 1 type of hardener Part-B (HKRUBK200) depending on the hardness after hardening. One type of hardener can be used under the same conditions in common for all main materials. The physical properties of the supplied product are shown in the following table:

Test Item		Measured Value	Test Conditions
Hardness	HKRUB200	6 - 7	TECLOCK GS-706N (TYPE A) (= KORI TYPE SA) (JIS K 6301 A)
	HKRUB300	9 - 10	
	HKRUB400	18 - 19	