



Micron RB-048

Rubber Bonding Process (Zero Iron)

RB-048 is a Calcium Modified micro crystalline zinc phosphate compound used for bonding rubber, plastisol and paint coatings to steel in immersion tanks. A tightly bonded micro-crystalline coating is achieved. Coatings are applied over steel and subsequently used for bonding rubber, elastic, sealants, paints and other coatings.

RB-048 is an immersion (or spray) product which provides coatings of 150 up to 600 mg/ft². Premium quality performance and results are achieved with this system. Meets USG / MILITARY SPECIFICATION: TTC490 Type I.

RB-048 provides a tiny nodular phosphate crystal (less the 5 microns), which is a tightly bonded crystal which is obtained by advanced free calcium ionization, a dense coating which resists corrosion and provides the most advanced coatings AND chemistry for bonding rubber and other top coatings. NO GRAIN REFINER

Features & Benefits

- High resistance to sludging
- Low sludging (Operated on the zero iron side .2-1.0 mls). Use with accelerator #40, nitrogen activator.
- Activated for use on resistant alloys
- Micro smooth coatings, providing a functional advantage
- Meets various automotive, government and military specifications
- Coating weights are easily controlled by simple acid ratio
- Can also be used for lubrication application
- The coatings prevent galling of metal and assists in deep drawing and extruding of metals

Physical Data

| | |
|-------------------------|-------------------------|
| pH | 1 |
| Product Type | Liquid |
| Spec. Gravity | 1.526 |
| lbs./gal. | 12.73 |
| Foam, 0 = Low, 9 = High | 0 |
| Shelf-Life Years | 10 Years |
| Freeze Information | Not damaged by freezing |



Typical Processing

1. Pre-clean, Alkaline #LS-150, 8% B.V, 8 min., 170 deg. F.
2. Rinse (Or alkaline descaler #375- LS Liquid)
3. Acid Pickle, (Hydrochloric or Sulfuric) 8 min
4. Rinse
5. Preferred 2 nd Rinse
6. RB-048 Zinc, 175 deg. F., 8 Min, 25-35 points acid (re:4%) . .2-1.0 ACC.#40, Ratio 6.5-11, Accelerator Points 0.4-1.4
7. Rinse
8. Dry to touch “pre-paint option” #2010, 3-5%, 125 deg F. 30-60 sec.
9. Lubrication option: Loc-Lube #5, 8 oz./gal., 175 deg. F, 4-10 min.

Packaging

| | |
|----------------|--|
| Container Type | Poly |
| Net Units | 700 |
| Tare Wt. | 25 |
| Gross Wt. | 725 |
| DOT_Name | UN 3264, Corrosive Liquid, Acidic, inorganic, N.O.S., (Phosphoric & Nitric Acids),8, PG II |
| DOT Hazard | Corrosive |
| Tarriff ID | 2835.29 |

Use Parameters

| | |
|---------------------|-----------------|
| Concentration Range | 4 – 6% |
| Temperature Range | 170 – 190 deg F |
| Time Range | 4 – 20 min |
| Agitation | Recommended |

Waste Disposal

See local laws.

Holding Tank Materials of Construction

Acid resistant. Steel, stainless or poly.



Other Information

It is important that the OSHA DATA, "Material Safety Data Sheet" be carefully read and reviewed with the users of this product. OSHA data is required to be posted in the work area by law.

WARRANTY: HUBBARD-HALL INC. IS NOT RESPONSIBLE FOR THE MISUSE, MISAPPLICATION, OR MISHANDLING OF THIS PRODUCT. SEE THE TERMS AND CONDITIONS OF SALE ON OUR WEBSITE FOR ADDITIONAL TERMS AND CONDITIONS CONCERNING OUR PRODUCTS, INCLUDING BUT NOT LIMITED TO, LIMITATIONS AND DISCLAIMERS OF WARRANTIES AND LIABILITIES.

Our People. Your Problem Solvers.

For more information on this process,
please call us at 203.756.5521 or email: techservice@hubbardhall.com

Hubbard-Hall holds certifications for **ISO 9001:2015**, Responsible Distribution, as accredited by the **ACD** (Alliance for Chemical Distributors) and as a **Women-Owned Small Business**, as well as maintaining an association with **Omni-Chem**¹³⁶.