

Technical Data Sheet No. 23

# REMA TIP TOP Thermopress-MTR-Rubber



<b>Available Units</b>	Ref. No. 516 1009	<b>A</b>	5 kg roll	1.0 mm
	Ref. No. 516 1170	<b>B</b>	6 kg rope rubber	ø 8 mm
	Ref. No. 516 1164	<b>B</b>	12 kg rope rubber	ø 8 mm
	Ref. No. 516 1243	<b>B</b>	0.5 kg small pack	0.8 mm
	Ref. No. 516 1250	<b>B</b>	2.5 kg roll	1.2 mm
	Ref. No. 516 1267	<b>B</b>	1 kg small pack	3.0 mm
	Ref. No. 516 1274	<b>B</b>	5 kg roll	3.0 mm
<b>Fields of Application</b>	Use REMA TIP TOP Thermopress-MTR-Rubber only in connection with a suitable vulcanizing solution, such as REMA TIP TOP Thermopress-MTR-Solution* or HR-Solution*. Observe the drying time of the coat (See manufacturer's specifications).			
	<p><b>A)</b> Cushion gum which is used for laminating (cushion backing) REMA TIP TOP repair patches prior to vulcanization in curing devices / retreading systems with operating temperatures ranging from 100 to 160 °C (212-320 °F).</p> <p>This type of cushion gum is applied:</p> <ul style="list-style-type: none"> <li>- if the innerliner has been removed,</li> <li>- if the cord is buffed slightly/ exposed,</li> <li>- if the buffed surface areas are uneven,</li> <li>- if the vulcanization is subsequently carried out in an open-steam autoclave,</li> <li>- in any case whenever EM (OTR) tyres are repaired (If combinations of repair patches have to be used for the repair of EM (OTR) cross-ply tyres according to the current PN repair chart, apply Thermopress-MTR-Rubber to all of these repair patches).</li> </ul> <p><b>B)</b> Uncured rubber compound which is used for filling skives on passenger car, light truck, truck, tractor, and EM (OTR) tyres as well as on tyres on industrial vehicles after coating with Thermopress-MTR-Solution* and before vulcanization in curing devices/retreading systems with operating temperatures ranging from 100 to 160°C (212-320°F).</p>			
<b>Application Instructions</b>	<b>A)</b> Use as a cushion gum:			
	Always keep the bonding surfaces clean.			
	Evenly coat the REMA TIP TOP repair patch and the previously buffed tyre inside with REMA TIP TOP Thermopress-MTR-Solution*.			
	Observe the drying time of the coat (See manufacturer's specifications).			
	Apply Thermopress-MTR-Rubber to the bonding layer, avoiding air entrapment and folds, then stitch the Thermopress-MTR-Rubber on over its whole surface, from the centre outwards, using the wide stitcher.			
	Remove approx. 25% of the protective foil starting from the centre, apply the patch to the tyre inside which has been coated with Thermopress-MTR-Solution* (or to the buffed and coated surface of the patch, if using combinations of OTR-PN patches).			
Then vigorously stitch the patch on over its whole surface from the centre outwards using the thin stitcher. During this operation, avoid air entrapment, and gradually remove the rest of the protective foil.				
Finally, coat exposed buffed surface areas and the edges of the patch/Thermopress-MTR-Rubber with REMA TIP TOP Innerliner Sealer*.				



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<b>Application Instructions</b>	<b>B) Use as skive filling rubber:</b>	
	Always keep the bonding surfaces clean	
	Coat the whole skive with REMA TIP TOP Thermopress-MTR-Solution*	
	Observe the relevant application instructions	
	Observe the drying time of the coat applied (See manufacturer's specifications)	
	Fill up the skive with Thermopress-MTR-Rubber, avoiding air entrapment Vigorously stitch on each layer with a thin stitcher. Press rope rubber into the skive with the use of an extruder.	
	Pre-heat rubber sheets up to 80°C (176 °F) using a rubber pre-heating plate, if necessary.	
<b>Safety Instructions</b>	Ensure a sufficient excess of the skive filling, according to the REMA TIP TOP repair instructions.	
	Do not use in curing systems in which the operating temperatures are below 100 °C [212 F].	
<b>Waiting time before putting the tyre into operation</b>	Before laminating (cushion-backing) with Thermopress-MTR-Rubber, always apply a coat of suitable vulcanizing solution to the bonding layer of the REMA TIP TOP repair patch concerned. If the operator of a (retreading) system uses system-specific materials, we recommend him/her to carry out tests on his/her own.	
	Let the repaired area cool down completely before putting the tyre back into operation.	
<b>Product Advantages</b>	Complete system adapted to REMA TIP TOP repair patches, Thermopress-MTR-Solution* and REMA TIP TOP vulcanizing machines.	
	Excellent green tack.	
	Excellent ageing stability under thermal and dynamic stress.	
	Good flow properties during vulcanization.	
	Improved adhesion for repairs which are treated in the open steam autoclave, and for long curing times (e.g. EM (OTR) tyre repair).	
	Suitable for applications with long waiting times between repair and curing (maximum 48 h).	
<b>Further Information</b>	Long "open time" (up to 3 hours) after the application of the coat.	
	Curing temperature	100 – 160 °C [212 - 320 °F]
	Shelf life	1 year
	Storage conditions	20 °C + 5 °C [68 °F + 9 °F] DIN 7716 Store in a dry and dark place
	Shore hardness	60 +/- 5 Shore A
	If Thermopress-MTR-Rubber has been stored at temperatures below 0°C, it can be made suitable for application again by pre-heating up to max. 50°C (122°F) for a short time.	
If the operator of a (retreading) system uses system-specific materials, we recommend him/her to carry out tests on his/her own.		

\*Either the trichloroethylene based or the CFC-and aromatic-free versions can be used in the respective cases depending on local restrictions and regulations.



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The above mentioned specifications are based on extensive tests and represent standard values. However, they do not contain confirmed properties. REMA TIP TOP reserve the right to carry out improvements and technical development, especially if these improvements do not change the product considerably. Guarantee claims are excluded for any minor changes which are deemed to be insignificant.

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