



Non-Flammable Pangofol

All-Purpose Bonding Cement



- Non-flammable Pangofol two-part, cold bonding cement is oil resistant and excellent for rubber belt splicing, fabrication, and installing belt repair strips and diamond repairs. Pangofol is also recommended for bonding rubber to metal, concrete, wood, fiberglass, fabric, and other substrates.
- Non-flammable Pangofol is recommended when work must be completed underground or near any source of ignition.
- Original formula non-flammable Pangofol has a proven record, spanning decades in the industry. Non-flammable Pangofol requires 60cc of 968 Activator per quart or a 16:1 mixture ratio by weight.
- The working temperature range of the product once cured is 10°F (-23°C) to 185°F (85°C). Pangofol cures to a usable bond in 4 to 6 hours. Full cure is in 24 hours at 70°F (21°C).
- Non-flammable Pangofol is available in quart (Cat. No. 992/QT), gallon (992/GAL), 5 gallon (992/5GAL) and 55 gallon (992/55GAL) containers.



Always work in a well ventilated area. When using non-flammable Pangofol #992 a respirator is strongly recommended!

PANGOFOL/ACTIVATOR MIXTURE RATIOS

MIXTURE RATIOS BY VOLUME

Pangofol Container Size	Activator (968F)
8 OZ	15cc
PINT (16 OZ)	30cc
QUART (32 OZ)	60cc
GALLON	(4) 60cc
5 GALLON	(20) 60cc
55 GALLON	(220) 60cc

MIXTURE RATIOS BY WEIGHT

Non-flammable Pangofol #992 15.5 parts : 1 part Activator #968F
CFC-free Pangofol #992F or #993F 11.5 parts : 1 part Activator #968F

P.O. Box 486, Johnstown, Ohio 43031 USA
 Customer Service: 1-800-705-2206 or 1-740-967-9015 Fax: 740-967-1039
 Web: www.pangindustrial.com



Pangofol

All-Purpose Bonding Cements



CFC-FREE PANGOFOL CHLOROPRENE CEMENT (Black)

Catalog Number	Quantity	Case Quantity
992F/QT	1.65 LBS (0.75 Kg)	10
992F/GAL	6.6 LBS (3 Kg)	4
992F/5GAL	33 LBS (15 Kg)	N/A
992F/55GAL	400 LBS (182 Kg)	N/A



CFC-FREE PANGOFOL CHLOROPRENE CEMENT (White)

Catalog Number	Quantity	Case Quantity
993F/QT	1.65 LBS (0.75 Kg)	10
993F/GAL	6.6 LBS (3 Kg)	4
993F/5GAL	33 LBS (15 Kg)	N/A
993F/55GAL	400 LBS (182 Kg)	N/A



NON-FLAMMABLE PANGOFOL CHLOROPRENE CEMENT (Black)

Catalog Number	Quantity	Case Quantity
992/QT	2.2 LBS (1 Kg)	10
992/GAL	11 LBS (5 Kg)	4
992/5GAL	55 LBS (25 Kg)	N/A
992/55GAL	628 LBS (290 Kg)	N/A



ACTIVATOR

Catalog Number	Quantity	Case Quantity
968F/15cc	15cc	12
968F/30cc	30cc	12
968F/60cc	60cc	12

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For Best Results, Use These Products with Pangofol



960/QT

PANG METAL PRIMER

Metal primer is designed to give excellent cold bond adhesion of rubber-to-metal or rubber-to-concrete when used in conjunction with Pangofol Black or Pangofol White. Used to prime all metal or concrete substrates before applying adhesives. SHAKE WELL BEFORE EACH USE.

Catalog Number	Quantity	Case Quantity
960/QT	1 Quart (.95L)	10
960/GAL	1 Gallon (3.8L)	4



816F/QT



816F/11OZ

BUFOL RUBBER CLEANER

Bufsol is a CFC-free rubber cleaning solvent. Recommended for cleaning rubber and metal before applying primers or bonding cements.

Catalog Number	Quantity	Case Quantity
816F/QT	1 Quart (.95L)	12
816F/GAL	1 Gallon (3.8L)	4
816F/11OZ	11 oz (311 g) Aerosol Can	12

Recommended Tools

Catalog Number	Description
966	Hand Held Soft Brass Brush
810	Hand Wire Brush/Scraper
810S	Replacement Brush for 810
S2022	1½" x 4" 36 Grit Contour Wheel
S2023	1½" x 4" 60 Grit Contour Wheel
T34	Rubber Mallet
946W	TradesMarker
S923	Safety Glasses
SLP6550	3,500 RPM Air Buffer
939	2" x ¼" Stitcher
S990	Rapid Action Air Hammer
S992	½" (15mm) Diameter Head for S990



Pangofol Instructions for Use

DESCRIPTION

Pangofol is a chloroprene based two-part cold vulcanizing adhesive that is available in both non-flammable and CFC-free formulas. Pangofol is oil and chemical resistant and will bond to most rubber compounds such as Butyl, EPDM, neoprene, natural rubber, and SBR blends as well as fabrics such as nylon and polyester. Pangofol will also bond fiberglass. When used with PANG Primer, Pangofol is an excellent adhesive for bonding rubber to metal and concrete.

Pangofol White cement is available in a CFC-free formula that is FDA compliant for approved applications.

COVERAGE

Pangofol will cover approximately 30 square feet (2.76 square meters) per quart (945ml) per single coat.

TEMPERATURE RANGE FOR APPLICATION

It is recommended to apply Pangofol in temperatures between 40°F (4.4°C) and 100°F (38°C). Temperatures below 40°F (4.4°C) will dramatically increase drying time. High humidity above 50% will also greatly increase dry time. Pangofol cures to a useable state in 4 to 6 hours at 72°F (22°C).

WORKING TEMPERATURE RANGE

The working temperature range for Pangofol once it is cured is -10°F (-23°C) to 185°F (85°C).

SHELF LIFE

The shelf life of Pangofol is 1 year from the date of manufacture in the sealed container. All cements and solvents should be stored in a cool, dark and dry environment.



AVAILABLE CONTAINER SIZES

Non-Flammable Pangofol is available in 1-quart (2.2 pounds/1kg), 1-gallon (11 pounds/ 5kg), 5-gallon (55 pounds/25kg) and 55-gallon (638 pounds/290kg) containers. Used with 968F Activator, Non-Flammable Pangofol requires 60cc of Activator per quart of Pangofol or 16 parts of Pangofol to 1 part of Activator by weight.

Always work in a well ventilated area. When using non-flammable Pangofol #992 a respirator is strongly recommended!

(Note: The weight of the solvent used in CFC-free Pangofol is much lighter than the solvent used in Non-Flammable Pangofol, the volumes in each can are the same.)

CFC-Free Pangofol is also available in 1-quart (1.65 pounds/.75kg), 1-gallon (6.6 pounds/3kg), 5-gallon (33 pounds/15kg) and 55-gallon (400 pounds/182kg) containers. Used with 968F Activator, CFC-free Pangofol requires 60cc per quart or 11.5 parts by weight of Pangofol to 1 part of Activator by weight.



Pangofol Instructions for Use

TYPES OF APPLICATION

Pangofol cold bonding adhesive can be used for the bonding of cleats, V-guides and edge walls (white or black) as well as belt splicing and fabrication including rubber to metal bonding. Rubber to concrete or metal bonding in applications such as pulley lagging requires the use of Pang Primer on the metal before applying Pangofol. Pangofol will also bond fiberglass, natural rubber, SBR and neoprene.

PROCEDURES

1. Outline the area to be prepared on the belt surface.
2. Buff the outlined area using a medium grit rasp or heavy wire-brush on a low rpm-buffing tool (maximum 5,000 rpm) to achieve an RMA #3 or #4 buffed texture for heavy cover materials. When preparing a light covered material, use a fine grit rasp or soft wire brush to an RMA #2 buffed texture. When preparing a metal surface, use a surface grinder and an appropriate grinding wheel, or sandblast, to achieve an even surface.
3. If the cleat, V-guide or edge walls are not pre-buffed, buff the base with medium grit rasp or cup. Avoid excessive gouging.
4. Brush off loose debris, and then clean with Bufsol and a clean lint free cloth. Allow Bufsol to dry thoroughly before applying cold bonding cement.
5. If applying lagging material or any rubber product to metal or concrete apply an even coat of PANG Primer (Cat. No. 960/QT or 960/GAL) to the metal or concrete and allow to dry thoroughly before applying Pangofol.
6. Stir or shake the can of Pangofol thoroughly before use. Mix thoroughly with the Activator at a mixture of 11.5 Pangofol to 1 part of Activator by weight for the CFC-free formula and 16 parts of Pangofol to 1 part of Activator for the non-flammable formula. The mixture is usable for 2 to 4 hours in a covered can.
7. Apply a uniform coat of the Pangofol/Activator mixture to both surfaces with a brush and allow to dry thoroughly. It is recommended to use a 1/4" to 3/8" nap roller to apply Pangofol to assure an even application.
8. Apply a second coat of the mixture to both surfaces. Allow the mixture to dry to a usable tack. If the product over dries, apply a light coat.
9. Join the cemented surfaces and stitch or use an air hammer or rubber mallet from the center out to the edges to join the surfaces. Avoid trapping air between the two surfaces.
10. When applying cleats, V-guides or edge wall, hammer with a mallet or air hammer, then stitch down. The belt can be placed back into service in 6 hours.