

**ADBOND TRANSPORT 4530 SERIES**  
**FLEXIBLE ADHESIVE****DESCRIPTION**

ADBOND TRANSPORT 4530 SERIES is a one-component adhesive that cures to a durable elastic rubber in contact with ambient humidity. Due to its rheological and non-sagging characteristics, it can be applied above the head and on vertical and horizontal surfaces. ADBOND TRANSPORT 4530 SERIES adheres aluminum, painted aluminum, painted steel, galvanized steel, composite, Poly-Cor™ AP, painted Poly-Cor™ AP, wood, and certain plastic

**ADBOND TRANSPORT 4530 SERIES CAN NOT BE PAINTED.**

ADBOND TRANSPORT SERIES 4530 is used for internal and external bonding on transport vehicles including trailers, truck boxes, buses, trains, boats, automobiles, and recreational vehicles. It does not give off any unpleasant odor during vulcanization and will not oxidize the metal (discoloration of copper-based metals may occur when sealed tightly). Due to its curing system in contact with moisture, the depth and thickness of the bead should not exceed 13 mm (1/2 "), otherwise the adhesive cannot cure completely. For applications with a bead depth of more than 13 mm (1/2 "), we recommend two components adhesive. When completely cured, ADBOND TRANSPORT 4530 SERIES is resistant to permanent temperatures of -40°C to 232°C (-40°F to 450°F) and intermittent temperatures of -51°C to 260°C (-60°F to 500°F).

**SPECIFICATIONS**

- Meets ASTM C920, type S, NS grade, class 50, use NT, G, A, O.
- Meets American Federal Specifications TT-S-1543A, class A and TT-S-00230C, class A, type II

**LIMITATIONS**

- Not designed for permanent immersion joints
- Where the adhesive is encapsulated and does not have access to ambient humidity
- In contact with strongly acidic or alkaline products
- Not recommended for joint less than 1/4 " or 6 mm. (width and depth)

**PHYSICAL PROPERTIES**

Uncured @ 23°C (73°F) 50% r.h	
Appearance	Pasty
Color	Black (4533) and Aluminum (4539) Special colors upon request
Density	1.29 g/ml
V.O.C.	44.5 g/L (3.9%)
Extrusion rate (50 psi/diameter 5mm)	75 – 300 g/min
Tack free time (ASTM C679)	25 – 30 minutes at 23°C (73°F) 50% r.h.
Rheological properties (ASTM C639)	No sagging

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Cured @ 23°C (73°F) 50% r.h	
Hardness (shore A) (ASTM D2240)	30
Elongation at break (ASTM D412)	925%
Maximum Tensile strength (ASTM D412)	185 psi
Tensile strength at 100% elongation (ASTM D412)	55 psi
Tensile adhesion strength at 25% elongation (ATSM C1135)	42 psi
Tensile adhesion strength at 50% elongation (ASTM C1135)	57 psi
Maximum elongation (ASTM C1135)	245%
Maximum tensile adhesion strength (ASTM C1135)	95 psi
Lap shear strength (ASTM D1002)	
Aluminum (etched)	107 psi
Galvanized steel	111 psi
Peel strength (ASTM C794)	22 lb/in
Movement capability (ASTM C719)	± 50%
Staining and color change (ASTM C510)	None

### APPLICATION

- Bonding of trailer, recreational vehicles, or truck box walls
- Bonding of decorative elements or interior finishes
- Bonding and sealing between the hull and deck of boats

### SURFACE PREPARATION

Surface must be free of dust, oil, grease, frost, or any other contaminant. Use ADSEAL CLEANER 6003 to clean all surfaces. Let it evaporate 20 minutes before ADBOND TRANSPORT 4530 SERIES application. In some cases, the ADBOND TRANSPORT SERIES 4530 may require the use of a primer. For the complete procedure and the type of primer to use, consult our [ADBOND PRIMER Guide](#). Consult your technical representative for more information.

### METHOD OF USE

ADBOND TRANSPORT 4530 SERIES should be applied in a continuous operation with a conventional manual, electric or pneumatic applicator (do not exceed 45 psi for a cartridge). ADBOND TRANSPORT 4530 SERIES can be applied at temperatures as low as -20°F (-29°C). Uncured adhesive can be clean with a solvent such as mineral spirit. Bead surface contact should be at least 1/4".

### APPLICATION TEMPERATURE (MOVEMENT DURING CURING)

Adhesives from the ADBOND product line can be applied throughout the year, even in winter, unlike organic adhesives such as polyurethanes, thermoplastics, or any solvent-based adhesives. Never apply adhesive in weather conditions where condensation or precipitation exists such as rainfall, freezing rain, snow, or intense fog. Make sure the surface is free of frost. The temperature of the adhesive must be the same as the

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substrates. Avoid applying a warm adhesive to a cold surface. The lower the temperature, the longer the adhesive will take to cure.

**PACKAGING**

- 600ml sausage
- Drum

**STORAGE**

Store the adhesive in closed original packaging. Store in dry premises at a temperature lower than 25°C (77°F). Expiration date is indicated on each container. Storage beyond the date specified on the container does not necessarily mean that the product is no longer usable. In this case however, the properties required for the intended use must be checked for quality insurance reasons. Contact our technical service.

**CAUTION**

Always consult SDS (Safety Data Sheet) before using the product. Apply usual hygienic rules. Always test the product on your application before use. For industrial use only. For more information, please contact your technical representative.

**IMPORTANT****READ CAREFULLY**

The information and recommendations contained herein are derived from our research and information from other reliable sources. This data applies only to our products and not when used with other products. We believe in the reliability of our information. However, no guarantee is offered to that effect. It is the responsibility of the buyer to verify this data according to their own operating conditions to ensure that they conform to the purpose for which the product is intended, even before using it.

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