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# 2402 ADHESIVE

## POLYCHLOROPRENE ADHESIVE

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BOSTIK 2402 ADHESIVE is a solvent-borne formulation based on polychloroprene rubber. It is used in conjunction with BOSTIKURE D CURING AGENT\* as a TWO PART, cold curing adhesive system which has a wide range of industrial applications. It gives strong resilient bonds which exhibit good resistance to water, heat, humidity, etc.

\* See Information Sheet No. B596.

### RECOMMENDED USE

BOSTIK 2402 ADHESIVE will bond natural, polychloroprene, nitrile, butyl, Hypalon and polyurethane rubber surfaces, rigid PVC, wood, metal, leather, etc. It can be used as a heat-resistant adhesive for decorative laminated plastics, and is particularly useful in the construction of inflatable products such as boats, balloons, etc.

BOSTIK 2402 ADHESIVE is approved, in conjunction with BOSTIK 9252 PRIMER, under the UK Ministry of Defence Specification DTD900/4679A for bonding synthetic rubber de-icer shoes to aircraft propeller blades and for use in the manufacture and repair of aircrew and survival clothing and of inflatable equipment. For these and other appropriate general purpose applications the quality assurance and release document approved by the UK Ministry of Defence is AFS 1179B.

**IMPORTANT:** It is not recommended that BOSTIK 2402 ADHESIVE be used on plasticised PVC because of the possibility of plasticiser migration.

### BONDING INSTRUCTIONS

1. The surfaces to be bonded must be dry, clean and grease-free. To ensure correct surface preparation remove any grease present by wiping with a clean cloth wetted with BOSTIK CLEANER/THINNER M501. Then abrade the surface with clean emery cloth and remove the ensuing dust by wiping with another clean cloth moistened with BOSTIK CLEANER/THINNER M501. (On metal surfaces follow a similar procedure using a Cleaner/Thinner recommended by BOSTIK FINDLEY LTD. Customer Service Department.

When bonding certain materials, such as wood and decorative laminates, it is not normally necessary to abrade them but they must be dry, clean and grease-free. If necessary remove any surface contamination with BOSTIK CLEANER/THINNER M501.

2. Mix together thoroughly, for approximately 5 minutes, BOSTIK 2402 ADHESIVE and BOSTIKURE D CURING AGENT, preferably in the proportions as supplied or by taking (by weight) 100 parts of the adhesive and 6 parts of the curing agent.
3. Apply an even coat of the mixed adhesive to both mating surfaces by brush, roller coater or serrated trowel.
4. Allow the adhesive coats to dry for 5 to 15 minutes or until they can just be touched with the knuckles without any adhesive being transferred.

**NOTE:** Two thin coats are preferable for maximum adhesion. The first coat should be allowed to dry for approximately 20 to 30 minutes before applying the final coat and allowing this to dry for 5 to 15 minutes.

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5. Join the surfaces, taking care not to trap any air, using as much pressure as possible. Components may be handled within minutes of being bonded.

For the strongest adhesion to metal use BOSTIK 9252 PRIMER, full details of which are given in Information Sheet No.B67. Stir this primer thoroughly and then apply by brush an even, thin coat to the prepared metal surfaces. Allow the primer coat to dry for at least one hour before applying BOSTIK 2402 ADHESIVE.

PRECAUTIONS MUST BE TAKEN TO ENSURE THAT BOSTIK 2402 ADHESIVE, BOSTIKURE D CURING AGENT AND THE MIXED UNCURED ADHESIVE ARE NOT CONTAMINATED WITH WATER OR WATER VAPOUR, AS THIS COULD HAVE A DETRIMENTAL EFFECT ON BOND STRENGTHS.

Tack Life:	Approximately 10 to 20 minutes dependent on the surfaces being bonded.
Pot Life:	6 to 8 hours in a closed container, but shorter in open containers due to solvent evaporation. Also the pot life decreases with age of the adhesive.
Curing Time:	48 hours under normal ambient temperature conditions but the strength of the adhesive bond continues to increase, reaching its maximum within 7 days. Cure rate may be accelerated by heating e.g. 2 hours at approximately 70°C.
Coverage:	Approximately 4m <sup>2</sup> per litre but can vary with material being bonded. (2m <sup>2</sup> bonded area).
Cleaner/Thinner:	Please contact BOSTIK FINDLEY LTD Customer Services Department for a product suitable for cleaning metal surfaces. BOSTIK CLEANER/THINNER M501 is suitable for other surfaces.  Use BOSTIK CLEANER/THINNER M501 for adhesive dilution, removal of surplus adhesive and cleaning of application tools and equipment.

### TYPICAL CHARACTERISTICS

Physical Form:	Semi-viscous liquid
Colour:	Off white
Odour:	Sweet
Chemical Type:	Polychloroprene rubber/resin based solution
Solvent:	Mixture of toluene, light petroleum spirit, acetone and butanone
Viscosity:	Approximately 2.5 Pa s (25 poise) at 25°C
Solids Content:	Approximately 25%
Specific Gravity:	Approximately 0.9
Flammability:	Highly flammable
Flash Point (Closed Cup)	In the group -18 to -7°C
Temperature Resistance:	From -40 to +90°C but will withstand higher temperatures for short periods.
Water Resistance:	Good
Oil, Petrol & Kerosene Resistance:	Fair – good.
Solvent Resistance:	Not resistant to esters, ketones, aromatic and chlorinated hydrocarbons which may swell and soften the bond.
Acid & Alkali Resistance:	Good. Virtually unaffected by 5N sulphuric acid and 5N sodium hydroxide

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Humidity Resistance: Good, after exposure to 100% RH at 38°C for 14 days  
Ageing: Good but exposed adhesive film will darken.

### PACKAGING

BOSTIK 2402: (Tin) Please refer to Customer Service Department for details of current  
BOSTIKURE D: (Bottle) package sizes.

### STORAGE

Store in a dry flameproof area between 5 and 25°C.

### SHELF LIFE

9 months from date of manufacture, under the above conditions of storage.

### MATERIAL SAFETY DATA

For further information refer to the relevant Health and Safety Data Sheet.

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