



BOSTIK 2405

PART A OF 2 PART CONTACT ADHESIVE

23 May 2017

YOUR SMART ADVANTAGES

- Good water resistance
- Resistant to oil, petrol and kerosene
- High bond strength
- Good heat and humidity resistance
- Flexible

USES

- Rubberised (including Hypalon) canvas on rescue and pleasure craft
- Natural and synthetic rubber adhesive
- Rubber to wood
- Rubber to metal (with Primer 17)
- Some rigid PVC's*

PRODUCT CHARACTERISTICS

Colour	Natural
Viscosity	Brushable
Composition	Neoprene solvent based adhesive
Application temperature	5 to 30°C
Tack time	5 – 10 minutes
Mixed pot life	4 to 6 hours
Open time	15 to 20 minutes
Curing time before service	72 Hours
Full cure	High strength after 24 hours, final bond strength can take up to 7 days
Thinner	Bostik No.2 Solvent. Do not exceed 10% thinner addition
Coverage	4 – 6m ² /L per surface, depending on surface and application method. Absorbent surfaces may need two coats.

Product codes

2405 (Part A)	
500ml metal tin/10 per	30606338

carton	
4L metal tin/ 2 per carton	30606339
20L metal pail	30804107
210L metal drum	30804315

Desmodur RFE (Part B)

50ml aluminium bottle	30604139
750g aluminium bottle	30804298

TYPICAL PERFORMANCE DATA (APPROX)

Staining	Some staining may occur on light coloured stock
Peel strength (7 days)	5kg/25mm minimum
Peel strength at 60°C	2kg /25mm minimum
Chemical resistance	Good chemical resistance to acids and alkali
Solvent resistance	Resistant to oil, petrol and kerosene. Not resistant to esters, ketones, aromatic and chlorinated hydrocarbons
Working temperature	-40 to +90°C
Maximum temperature*	150°C
Mixing ratio	5 to 10% of Part B

* The adhesive will deteriorate if subjected to high temperatures and/or humidity on a continuous basis.

DIRECTIONS FOR USE

Highly flammable liquid and vapour. Read and understand the Safety Data Sheet before using this product.
It is recommended that this product is fully evaluated as suitable for the application methods to be employed and for suitability of performance both initially and for the expected life of your product under the condition it is expected to withstand.
The mixing ratios are guidelines. It is recommended that testing be carried out to determine the quantity of Desmodur RFE required for your specific application.
For rubberized craft 10% Desmodur RFE is recommended.

Precautions must be taken to ensure that Bostik 2405, Desmodur RFE and the mixed uncured adhesive are not

contaminated with water or water vapour, as this can have detrimental effects on bond strength.

SURFACE PREPARATION

Ensure all surfaces are clean and dry.

Rubber: Roughen the surface using a clean emery cloth. Solvent wipe is not recommended as this may affect adhesion due to penetration of the solvent into the rubber. Bocosol S may be used as a primer for vulcanized and thermoplastic rubbers.

Metal: Sand blast and immediately solvent wipe using Bostik No. 3 Solvent using the wipe on, wipe off technique. After wiping well, prime immediately with well mixed Bostik 17 Primer. Allow the primer coat to dry for one hour or overnight before applying adhesive. Non porous substrates: Solvent wipe using Bostik No. 3 Solvent using the wipe on, wipe off technique. Abrade smooth surfaces to improve adhesion.

APPLICATION

- If you have not used a contact adhesive before we recommend that you prepare a few practice pieces first to ensure that your methodology is correct.
- Materials may vary – prepare a test piece first to ensure product and process is suitable.
- In cold or damp conditions, cooling by solvent evaporation may cause water vapour to condense onto the adhesive film. Keep adhesive and components in a warm area and carry out all safety precautions involved with working with flammable liquids.
- Stir the Bostik 2405 until completely homogenous before decanting, and prior to further use
- Measure out the required quantity of Bostik 2405 into a clean container. Measure out the required quantity of Desmodur RFE and add to the Bostik 2405. Mix well to ensure a homogeneous solution.
- Mix up no more adhesive than can be used within 6 hours.
- Decant smaller quantities for working with, and seal the remainder of the mixed product to protect from moisture and solvent evaporation.
- Apply an even film of mixture to both surfaces by brush, roller coater or serrated trowel
- On porous surfaces a second coat may be required to achieve an even film on the surface. Allow each coat to dry 1 to 8 hours.
- The porosity of a surface may be judged by applying a droplet of water. If the water beads the substrate is not porous, if the bead soaks in the substrate is porous.
- Allow the two films to dry for about 15 minutes, or until they can be touched with the knuckles without any cement being transferred.
- Bonding must be carried out within 20 minutes of applying the adhesive.
- Carefully align the two surfaces, and join together. Take care not to trap any air and use as much pressure as possible. The recommended minimum pressure required to give a good bond is 280kPa (40psi).
- The bond is immediate, and if the pieces are misaligned they cannot be separated and re-joined. Fresh adhesive will need to be applied to both surfaces and allowed to tack off before re-bonding.
- If bonding to non-absorbent surfaces allow the adhesive to dry for a longer period. This allows more solvent evaporation and reduce chances of bubbling after bonding due to entrapped solvent.
- Do not use mixed product that is older than 6 hours.

Remove lid and allow to harden before disposal.

LIMITATIONS

- Not suitable for polyethylene, polypropylene or Teflon,
- Not suitable for plasticised PVC, contact Bostik for information on alternative options.
- Desmodur RFE is sensitive to moisture. After decanting, wipe bottle lip clean and close immediately. If contaminated with moisture it will harden in the bottle.
- Do not use on copper or brass
- Do not use on expanded Polystyrene foam

CLEANING

Bostik No. 2 Solvent or Mineral Turpentine
Use Bostik Handy Wipe towels to remove adhesive from skin.

STORAGE AND SHELF LIFE

Store in cool, dry conditions out of direct sunlight below 25°C and away from naked flame or sources of heat. Store according to Dangerous Goods regulations. Shelf life is 12 months if stored in cool, dry conditions in original, unopened containers.

DISPOSAL

Empty containers, once dry, may be disposed of via local landfill.

If spilt, beware of flammable vapours. Absorb product with clay, sand or earth. Collect in properly labelled metal containers. Dispose of according to local authority regulations. Do not dispose of down drains or into waterways. Fully dried material is not hazardous.

PRECAUTIONS IN USE

Complete details on each of the products mentioned are available on the product Safety Data Sheets. To ensure no harm is caused to persons using Bostik products, it is recommended that all concerned read the appropriate Safety Data Sheets. Visit www.bostik.co.nz for copies.

HIGHLY FLAMMABLE – KEEP AWAY FROM HEAT, SPARKS AND OPEN FLAME
KEEP OUT OF REACH OF CHILDREN
KEEP CLOSED WHEN NOT IN USE
AVOID CONTACT WITH EYES AND SKIN

FIRST AID

Swallowed: Do not induce vomiting, give a glass of water and contact a doctor immediately.

Skin: Remove contaminated clothing, wash with warm soapy water. Do not scrub.

Inhaled: Remove person to fresh air. Get medical advice if breathing becomes difficult. If inhaled to excess, remove from contaminated area – apply artificial respiration if not breathing.

Eyes: Hold open and flood with water for at least 15 minutes. Get medical advice.

For emergency information contact the National Poisons Information Centre, phone 0800 764 766 (0800 POISON) or CHEMCALL, phone 0800 243 622.

BOSTIK HOTLINE

Smart help 0508 222 777



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