

## NE486 ADHESIVE

### SOLVENT BORNE ADHESIVE

BOSTIK NE486 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 offers strong resilient bonds which exhibit good resistance to water, humidity, etc.

\*See Information Sheet No. B596.

In particular, the cured film of BOSTIK NE486 ADHESIVE has good resistance to UV exposure, with reduced discolouration. Also this adhesive has good storage stability, this being particularly relevant where high storage temperatures are encountered, such as in overseas locations.

#### RECOMMENDED USE

BOSTIK NE486 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 e.g. Formica, and is particularly useful in the construction of inflatable products such as boats, balloons etc.

The UK Ministry of Defence Quality Assurance and release document relating to BOSTIK NE486 ADHESIVE is AFS 1413.

**IMPORTANT** It is not recommended that BOSTIK NE486 ADHESIVE be used on plasticised PVC because of the possibility of plasticiser migration.

#### BONDING INSTRUCTIONS

1. Ensure that the surfaces to be bonded are clean and grease free by abrading them with clean emery cloth or by using BOSTIK M501 CLEANER/THINNER to remove surface contamination. (For metal surfaces follow a similar procedure using a product recommended by BOSTIK LTD. Customer Service Department).
2. Mix together thoroughly, for approximately 5 minutes, BOSTIK NE486 ADHESIVE and BOSTIKURE D CURING AGENT preferably in the portions 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 20 minutes or until they can just be touched with the knuckles without the 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 20 minutes.

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 BOSTIK Information Sheet No.B67. Stir this primer thoroughly and then apply by brush an even, thin coat to the prepared metal surface. Allow the primer coat to dry for at least one hour before applying BOSTIK NE486 ADHESIVE.

**PRECAUTIONS MUST BE TAKEN TO ENSURE THAT BOSTIK NE486 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 20 to 30 minutes dependent on the surfaces being bonded.

**POT LIFE:** Greater than 6 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:** 72 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 (2m<sup>2</sup> of bonded area) but can vary with material being bonded.

**CLEANER/THINNER:** Please contact BOSTIK LTD. Customer Services Department for a product suitable for cleaning metal surfaces. BOSTIK M501 CLEANER/THINNER can be used for other surfaces.

Use BOSTIK M501 CLEANER/THINNER for adhesive dilution, removal or surplus adhesive and cleaning of application tools and equipment.

#### TYPICAL CHARACTERISTICS

Physical Form:	Mobile liquid
Colour:	Off white
Odour:	Mainly Ketonic
Chemical Type:	Polychloroprene rubber/resin based solution
Solvent:	Mixture of methyl ethyl ketone, light petroleum spirit, toluene and acetone
Viscosity:	2.5 Pa s (25 poise) approximately
Solids Content:	22% Approximately
Specific Gravity:	0.9 approximately
Flammability:	Highly flammable
Flash Point:	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 hydrocarbons which may swell and soften the bond.
Dilute Acid & Alkali Resistance:	Good. Virtually unaffected by 5N sulphuric acid and 5N sodium hydroxide.
Humidity Resistance:	Good, after exposure to 100% RH at 38°C for 14 days.
Ageing:	Good but exposed adhesive film can discolour in strong sunlight

#### PACKAGING

Please refer to Customer Service Department for current package sizes.

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This Product Data Sheet covers just one of a large range of products supplied by Bostik Limited. Full information on these products and advice on application is freely available from our fully trained staff throughout the country. In addition, specialist technical advice is available from our Technical Services Department. This Product Data Sheet supersedes all previous technical information on this product, and users of it are cautioned to ensure that it is the current issue. Destroy all previous Product Data Sheets, and if any doubt, contact Bostik Limited, quoting the code number in the top right hand corner on the front of this document. This leaflet is for general guidance only and may contain inappropriate information under particular conditions of use. The company cannot accept any responsibility for loss or damage that may result from the use of this information, due to the possibility of variations of processing or working conditions and of workmanship outside our control. Users are advised to confirm the suitability of this product by their own tests.

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## **STORAGE**

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

## **SHELF LIFE**

1 year 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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