

technical data sheet

BOSTIK 2402 ADHESIVE

2-PART COLD CURING ADHESIVE

PRODUCT

Bostik 2402 is high performance, two-component, cold curing solvent-based adhesive. It is specifically designed for adhering a variety of rubber-based surfaces as well as rigid and semi rigid surfaces.

DESCRIPTION

Bostik 2402 Adhesive is primarily a two part, cold curing solvent adhesive based on polychloroprene rubber giving a tough, resilient bond. It has a wide range of industrial applications and gives good adhesion to most rubber surfaces such as natural, neoprene, butyl, hypalon, polyurethane and nitrile as well as wood, ferrous metals, laminated plastics and rigid PVC. (Refer to preparation section for Primer recommendations). **Bostik 2402** has high heat resistance and exhibits good resistance to water, humidity etc. when used in conjunction with **9101** (part B) curing agent.

NOTE: Bostik 9101 Curing Agent is a coloured product. **Bostik 9105** can be used if a clear version is required.

RECOMMENDED USES

Bostik 2402 adhesive system has major applications in the Rubber Lining Industry, bonding inflatable products as well as industrial conveyor belting.

FEATURES

- Tough bond strength
- High temperature resistance
- Good water resistance
- Suitable for exterior application

TYPICAL TECHNICAL DATA:

Type:	Solvent based synthetic rubber/resin 2 part cold curing
Colour:	2402 Adhesive part A -Cream / Buff
	9101 Curing Agent part B -Purple/Brown Cured bond-Pale Brown, darkens with age
Viscosity:	2500-3200 cps @ 25°C (BTM V001)
Solids:	25-28% w/w (BTM N001)
S.G.:	Approx. 0.90 (BTM D002)

PERFORMANCE PROPERTIES

- **Water Resistance:**
The dried adhesive film has very good water resistance.
- **Temperature Resistance:**
Shear adhesion failure temperatures of up to 150°C (120°C without curing agent **9101**) have been measured using a method based on Australian Standards. These results are used solely for comparison purposes. If temperature is the only factor that may affect the bond, then **Bostik 2402**

system has a continuous service temperature resistance from -40°C to +90°C for periods of up to one year. After this period it is recommended that the bond be inspected to determine the suitability of extending the service life.

- **Chemical Resistance:**

The chemical resistance to petrol, oil and kerosene is good (except continuous immersion). The adhesive is virtually unaffected by 20% solution sulphuric acid or 20% solution caustic soda when tested under laboratory conditions. Since other chemicals are often involved consult Bostik for specific situations.

NOTE: For any requirements outside of the above mentioned situations will need specific verification by Bostik P.A.T.S. (Pretested Adhesive To Substrate) Program and/or your own proving process.

PACKAGING

2402 available in 500ml, 4L, 20L and 200L containers. **9101** Curing Agent is supplied to suit 500ml, 4L and 200L of **2402** (pre measured) doses

ANCILLARY MATERIALS

Bostik 9252	Metal/Plastics Primer
Bostik 9300 part A+B	Rubber Primer
Bostik 9913	Cleaning Solvent/ Thinner and Adhesive Activator
Bostik 9101	Curing Agent

COVERAGE:

Approximately 4m² per litre on one surface.

PREPARATION

Surfaces must be clean and grease free. They may be cleaned by abrading the surface with clean emery cloth or by using **Bostik 9913 Solvent** to remove surface contamination. Solvent cleaning should not be adopted for those surfaces where the bond strength is likely to be affected adversely by the penetration of the solvent into the materials. For maximum adhesion, abrading is preferable to solvent cleaning. Some rubbers (particularly natural) require priming with **Bostik 9300 Primer** prior to application of **Bostik 2402 adhesive**. Test strips should be made up and tested to ensure the best bond possible will be obtained. For the strongest adhesion to metal, and some plastics **Bostik 9252 Primer** must be used. Stir the primers thoroughly prior to the application of a medium brush coat to the prepared metal surfaces. Allow the primer coat to dry for at least one hour before applying adhesive.

APPLICATION

Three alternative methods may be used:

1. Two Way Dry Stick
2. Solvent Activation
3. One Way Wet Stick

(Higher bond strength is achieved by methods 1 or 2.)

MIXING

Add approximately 4% w/w **Bostik 9101 Curing Agent into 2402 Adhesive** and stir in thoroughly for at least 2 minutes.

NOTE: Precaution must be taken to ensure that **Bostik 2402**, Curing Agent **9101**, and uncured mixed adhesive are not contaminated with water or water vapour as this could have a detrimental effect on bond strength and pot life.

Pot life at end of mixing day is 6 - 8 hours at 25°C. (Shorter times above 25°C). Keep lid on container when not in use to minimize solvent loss which will reduce pot life.

BONDING

NOTE: **Bostik 2402** should not be used during abnormal atmospheric conditions:

- A) If ambient temperature falls below 10°C, a moisture film may form on the adhesive surface. Should this situation occur, no further bonding should be carried out until temperature has risen.
- B) If ambient temperature rises above 35°C the open time for the bonding operation will be shortened dramatically and the resulting bond strength will be affected.
- C) On days of high humidity (above 70% RH), bonding operations should be watched closely for fall off in initial "grab" qualities of the adhesive films. Should any lack of grab be evident the bonding operations should cease until normal conditions prevail.

1. Two Way Dry Stick

Apply an even film of the mixed adhesive to both surfaces by brush, roller coater, serrated scraper or spraying.

In some cases a single adhesive application to each surface may not be sufficient (e.g. porous surfaces) then multicoat applications may be needed to build up film thickness. In this case, each coat should be allowed to dry for about 40-45 minutes except the final one which should have 10 - 20 minutes. It is always advisable to build up film thickness with a number of thin coats rather than a single heavy coat.

Allow the 2 films to dry for 10-20 minutes, or until they can be touched with the knuckles without any cement being transferred.

Join the surfaces, taking care not to trap any air and using as much pressure as possible.

2. Solvent Activation

Apply adhesive as per Two Way Dry Stick, generally in 2 thin coats allowing at least 45 minutes between coats. (This allows maximum solvent evaporation).

Allow 1 - 2 hours for adhesive film to dry out.

Wipe one surface gently with a cotton cloth lightly soaked in **Bostik 9913** and bring together with as much pressure as possible, only working ahead as far as practical to maintain surface tack.

3. One Way Wet Stick

At least one surface must be porous, apply the adhesive to one surface only and bond immediately, using as much pressure as possible. This will give a lower initial bond strength than a Two Way Dry Stick and bond strength will develop slowly, taking approx. 5-7 days to reach maximum.

SPRAYING

Bostik 2402 may be sprayed by diluting two parts of adhesive with one part of Bostik 9913 Solvent (by volume) when spraying using C.I.G. Arnold 410550 Spray Gun with 411368 Fluid Tip Kit and 413435 Air Cap Binks-Bullows 230 Spray Gun with 446 Fluid Nozzle and 66SD Aircap. Spraying equipment must be thoroughly cleaned at each day end to ensue satisfactory and uninterrupted working. Atomising air line pressure 275-475 kPa (40-70 p.s.i.) Fluid pressure 92-183 kPa (10-20 p.s.i.)

ACCELERATED CURING

Bostik 2402 adhesive (Part A+B) usually requires up to 7 days to fully cure through. The curing process may be accelerated by placing bonded article in +70°C for 2 hours.

PRECAUTION

It is not recommended that **Bostik 2402** Adhesive be used on plasticised PVC because of the possibility of plasticiser migration. **Bostik 2402** Adhesive should not be used in contact with brass, copper alloys, solutions or materials (e.g. some fabrics) that contain copper compounds which may migrate into the adhesive. **Bostik 2402** is not resistant to esters, ketones, aromatics or chlorinated hydrocarbons as these may swell and destroy the bond if left in continuous contact.

P.A.T.S (Pretested Adhesion To Substrate) Programme

Bostik offer a service in which a program has been established to eliminate potential field problems by pre-testing Bostik adhesives with samples of building materials to which the adhesive will be applied. This service is available on large projects where pre-application testing will aid in determining the proper surface preparation method to achieve optimum adhesion. Consult a Bostik representative for further information.

HEALTH AND SAFETY

- Gloves and protective goggles should be worn during application and use.
- Avoid contact with skin, eyes and avoid breathing in vapour.
- Wear protective gloves when mixing or using
- If poisoning occurs, contact a doctor or Poisons Information Centre.
- If swallowed, do not induce vomiting. Give a glass of water.
- If skin contact occurs, remove contaminated clothing and wash skin thoroughly for a minimum of 15 minutes and see a doctor.
- For more detailed information refer to Material Safety Data Sheet.

CLEAN-UP

Clean up and thin with Bostik 9913 solvent only.

STORAGE/SHELF LIFE

Store away from heat sources and under cover. The solvent vapours are highly flammable. A minimum shelf life of 24 months from date of manufacture if stored under cover below 30°C.

FIRE

This product is highly flammable.

BOSTIK 2402 ADHESIVE

ITEM NO.	STOCK SIZE
044210	BOSTIK 2402 ADHESIVE 500ML
044237	BOSTIK 2402 ADHESIVE 4L
044245	BOSTIK 2402 ADHESIVE 20L
221414	BOSTIK 2402 ADHESIVE 200L

The representations and recommendations regarding the products are based on tests which we believe to be reliable. However, no guarantee of their accuracy can be made because of the great range of field conditions and variations encountered in raw materials, manufacturing equipment and methods. Thus, the products are sold with a limited warranty only, and on the condition that purchasers will make their own tests to determine the suitability of the product for their particular purposes. Under no circumstances will Bostik Findley Australia Pty Ltd be liable to anyone except for replacement of the products or refund of the purchase price.

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**BOSTIK FINDLEY
AUSTRALIA PTY LTD**
Phone: +61-3-9279 9333
Fax: +61-3-9279 9240

SYDNEY
Phone: 02 8825 3488
Fax: 02 8825 3411

**BOSTIK FINDLEY
NZ LIMITED**
Phone: +64-4-567 5119
Fax: +64-4-567-5412

ADELAIDE
Phone: 08 8244 0511
Fax: 08 8244 0522

FOR FURTHER INFORMATION

**BOSTIK FINDLEY
SINGAPORE PTE LTD**
Phone: +65-863 4088
Fax: +65-863 4077

PERTH
Phone: 08 9331 7666
Fax: 08 9331 7677

**BOSTIK FINDLEY
(MALAYSIA) SDN BHD**
Phone: +606 764 3246
Fax: +606 764 3248

BRISBANE
Phone: 07 3265 2377
Fax: 07 3265 5421

(ABN 79 003 893 838)

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