

TRIPLE 5 BSR

Laminating Adhesive

DESCRIPTION

Bostik Triple 5 BSR adhesive is a high quality, high strength laminating adhesive, which can be applied by Brush, Roller or Spray. It features a high immediate bond strength and a heat resistant bond results after full curing.

Bostik Triple 5 BSR is a versatile adhesive and may be used to give high quality bonds to most common building substrates and general laminating operations, such as plywood, galvanized and other metal sheets, wood veneer, PVC flooring, internal bracing and honey comb stuffing, Gib-board etc. It is ideally suited for bonding decorative laminates such as Formica, Laminex etc to particle board surfaces. When post forming laminates, use Bostik 1456 adhesive for high immediate heat resistance.

PROPERTIES

Type:	Neoprene contact
Solvent:	Hydrocarbon / ketone
Flash point:	Below 0 °C
Solids content:	Approx. 20 %
Colour:	Red
Viscosity:	Sprayable grade, but due to high solids content may also be brushed or rolled.
Temperature range:	-20 °C to 150 °C dependant on bond line stress
Bonding range:	10 - 60 minutes dependant on temperature and substrates bonded (contact) or up to 24 hours (heat activate)
Coverage:	2 - 5 m ² /L of bonded area dependant on surface porosity and application method.
Type:	Neoprene contact

APPLICATION

If the adhesive is left standing for a long period before use,

mix well to disperse the pigment evenly. This enables accurate gauging of the coverage rate and evenness.

Normal air operated spray and airless equipment gives best results, but with airless spray guns the tips and fan widths will require more experimentation to suit all applications.

Spray an even coat with particular care at the edges to both surfaces to be bonded. It is **MOST IMPORTANT** to apply sufficient adhesive at this stage for best properties later.

Allow the sprayed surfaces to become dry to the touch before carefully lining the two up and bringing the coated surfaces together using as much pressure as possible. Nip rollers properly set should give a minimum pressure of 280 KPa (40 psi). Most laminating failures occur due to lack of combining pressure or lack of adhesive. (See Common Causes of Bond Failure below).

Proper substrate alignment is necessary. If they are misplaced at this stage they cannot be re-bonded without re-spraying. Care is necessary. The bond is immediate and strong.

To heat activate, the surfaces must be allowed to dry before applying heat using a heat gun or purpose designed machinery. The optimum surface temperature is 90 ° C. The heat activated surface will retain its tackiness for about 10 minutes.

NOTE

Due to the variable nature of PVC flooring materials it is wise to carry out a small test strip before using Triple 5 BSR. Bostik have other adhesives such as Bostik 1659, Bostik Ultragrip 777 and others which give guaranteed bond strengths on difficult PVC materials. These adhesives

Wellington Site (Factory & Admin)
Auckland Site
Christchurch Site

19 Eastern Hutt Road, Wingate, Lower Hutt
148 Pavillion Drive, Airpark II, Auckland Airport
65 Brisbane Street, Sydenham, Christchurch

Ph ++64 4 567 5119 Fax ++64 4 567 5412
Ph ++64 9 257 5847 Fax ++64 9 257 3588
Ph ++64 3 366 2583 Fax ++64 3 366 2582

www.bostik.co.nz

The recommendations given on this document are intended for the assistance of users and are of a general nature. They are based on our experience and judgement but because of the conditions under which, and the materials with which our products are used are beyond our control, our recommendations must not be regarded as amounting to any legal warranty or as involving any liability on us.

do not soften or stain when used with PVC even under adverse conditions. If in doubt please contact Bostik.

Any adhesive on the face of PVC should be cleaned immediately using Bostik No. 1 Solvent.

COMMON CAUSES OF BOND FAILURE

Edge Lifting:

- Insufficient adhesive
- Bonding too soon
- Insufficient pressure
- Exposure to direct sunlight before 72 hours curing time.

Bubble in centre of laminate:

- Bonding too soon trapping solvent
- Edges were rolled first instead of rolling from centre outwards
- Insufficient adhesive or inconsistent spray pattern.

Shiny area over entire adhesive surface

- Insufficient pressure
- Blushing.

Dull areas on substrate

- Coating too thin on highly absorbent surfaces.

Adhesive stringy when delaminating

- Insufficient drying time, therefore bonding too soon.

Small circular unbonded areas

- Operator testing with fingers instead of knuckles.

If the temperature is low, blushing may occur on the adhesive surface unless you take precautions. Blushing can be entirely eliminated by the installation of a hot spray unit or by modifying the air flow in the workplace.

PACKAGING

4 litre, 20 litre, 210 litre.

STORAGE

Store in cool, dry conditions out of direct sunlight below 25° C and away from naked flame or sources of heat.

SHELF LIFE

12 months if stored in cool, dry conditions in original, unopened containers.

HEALTH AND SAFETY

Fuller 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 the appropriate Safety Data Sheets are read by all concerned. Visit www.bostik.co.nz for copies.

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 CHEMICALL, phone 0800 243 622.

DISPOSAL

If spilt, absorb with clay, sand or earth. Collect and seal in properly labelled metal containers. Dispose of according to local authority regulations. Do not dispose of down drains or into local waterways.

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