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## BOSCOPEPRENE CEMENT 2402

### PARTS A AND B

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#### DESCRIPTION

Boscoprene Cement 2402 is a two-part, cold curing adhesive giving a tough resilient bond. It has a wide range of building applications and gives good adhesion to natural and synthetic rubbers, wood, metal, and rigid PVC. Bostik 2402 is the preferred adhesive for bonding rubbers to metals. Part B is labelled as Desmodur RFE. (formerly Boscodur #2.)

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#### SPECIFICATIONS

|               |                                                                                                                                                                                                                             |
|---------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Type:         | Synthetic rubber/resin. Two part, cold curing.                                                                                                                                                                              |
| Colour:       | Part A - Off white, Part B - This may be a variety of colours ranging from red to green, but the colour variation does not affect the adhesive properties. Cured bond. Cream to yellow, depending on the exterior exposure. |
| Solvent:      | Petroleum spirit, aromatic hydrocarbon and ketone.                                                                                                                                                                          |
| Viscosity:    | Medium brushable solution                                                                                                                                                                                                   |
| Cleaner:      | Bostik Cleaner No.2.or 4 for the preparation of the surfaces. Bostik Cleaner No.2. for the removal of surplus adhesive.                                                                                                     |
| Thinner:      | Bostik No. 2 solvent                                                                                                                                                                                                        |
| Flammability: | HIGHLY FLAMMABLE. Flash point < 0°C .                                                                                                                                                                                       |

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#### PROPERTIES

|                   |                                                                                                                                                                                                                        |
|-------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Location          | Interior or exterior                                                                                                                                                                                                   |
| Curing Times:     | 72 hours under normal temperature conditions but the strength of the adhesive bond continues to increase, reaching its maximum in 5 - 7 days. Cure rate may be accelerated by heating to about 70°C for 10 - 15 hours. |
| Drying Time:      | 15 - 20 minutes or until the adhesive film can be touched with the knuckles without any cement being transferred.                                                                                                      |
| Tack Life:        | Approximately 25 - 30 minutes.                                                                                                                                                                                         |
| Pot Life:         | Not less than 4 hours in closed containers when mixed.                                                                                                                                                                 |
| Coverage          | 4 sq metres per litre on one surface.                                                                                                                                                                                  |
| Colour:           | The dried film is a dark purple or brown colour.                                                                                                                                                                       |
| Water Resistance: | When cured, the adhesive film has good water resistance.                                                                                                                                                               |

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|----------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Solvent Resistance:        | The resistance to petrol, oil and kerosene is good. It is not resistant to esters, ketones, aromatic and chlorinated hydrocarbons, which swell and destroy the bond. Fully crosslinked films have good solvent resistance.                                       |
| Chemical Resistance:       | The adhesive film has good chemical resistance, being virtually unaffected by 5N Sulphuric Acid and 5N Sodium Hydroxide under laboratory conditions.                                                                                                             |
| Humidity:                  | Adhesive film shows good resistance when exposed to 100% relative humidity at 38°C for 14 days.                                                                                                                                                                  |
| Paintability:              | The adhesive readily accepts most common paints.                                                                                                                                                                                                                 |
| Working Temperature Range: | -40°C to +90°C dependant on bond line stress.                                                                                                                                                                                                                    |
| Ageing:                    | Very good, but can discolour when exposed to exterior weathering.                                                                                                                                                                                                |
| Mix Ratio:                 | For extra high adhesion and high heat resistance: 10 parts A to 1 part B.<br>For normal conditions: 25 parts A to 1 part B. These ratios are not absolute and the above is given only as a guide, individual applications can be optimised for best performance. |

## PRREPARATION

The two parts of the adhesive are mixed together thoroughly until a uniform colour has been attained. Always mix Part A thoroughly before use.

## STORAGE

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

## TRANSPORT

| <b>Part A</b>         |           | <b>Part B</b>         |               |
|-----------------------|-----------|-----------------------|---------------|
| Proper Shipping Name: | ADHESIVES | Proper Shipping name: | Ethyl Acetate |
| Hazard Class:         | 3         | Hazard Class:         | 3             |
| UN Number:            | 1133      | UN Number :           | 1173          |
| Hazchem Code:         | 3[Y]E     | Hazchem Code :        | 3[Y]E         |
| Packaging Group: 11   |           | Packing Group :       | II            |

## APPLICATION

### **Two Way Dry Stick:**

- Surface must be clean and grease free. They may be cleaned by roughing the surface with clean emery cloth or by using Bostik No 2 Cleaner 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 material. For maximum adhesion to rubber, roughing is preferable to solvent. Solvent wiping is recommended to remove dust and oils.
- Apply an even film of the adhesive to both surfaces by brush roller coater, serrated trowel or spraying. Two coats may be necessary for exceptionally porous surfaces.
- Allow the two films to dry for 15 - 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.

- (e) In some cases when a single adhesive application to each surface may be sufficient, multi-coat applications may be used in order to build up film thickness. Each coat should be allowed to dry for about 40 - 45 minutes, except the final one which should have 15 - 20 minutes.
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## **APPLICATION TECHNIQUE**

For the optimum adhesion to metal, Bostik 17 Primer should be used. It must be stirred thoroughly prior to the application of a thin brush coat to the prepared metal surfaces. Allow the primer coat to dry for one hour before applying adhesive coating.

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## **PRECAUTION**

1. Precautions must be taken to ensure that Part A, Part B and the uncured adhesive are not contaminated with water.
  2. Since this product uses an isocyanate, care should be taken to ensure that Part B does not contact the eyes and skin. In cases of eye contamination give prolonged irrigation with water, and seek medical attention. In cases of skin contamination wash off with soap and water.
  3. Check the SDS available from Bostik's web site ([www.bostik.co.nz](http://www.bostik.co.nz))
  4. The bond strength can take up to 1 week or longer to reach maximum strength.
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## **PACKAGING**

Litres, 4 litres and 20 litres. Appropriate size container of Part B (Desmodur RFE.)1 litre

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## **SHELF LIFE**

Shelf Life - 12 months in original unopened containers.

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## **VERSION**

Version 4.1

5<sup>th</sup> August 2011