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## 1456 ADHESIVE

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### DESCRIPTION

Bostik 1456 adhesive is formulated for bonding decorative laminates such as Formica, Laminex etc to particle board surfaces. It features a high immediate bond strength when heat activated for post forming of roll edge bench tops. A high heat resistant bond results after full curing.

Bostik 1456 is a versatile adhesive and may also be used to give high quality bonds to most common building substrates such as plywood, galvanized and other metal sheets, wood veneer, internal bracing and honey comb stuffing, Gib-board etc.

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### PROPERTIES

Type :	Polychloroprene contact
Solvent:	Hydrocarbon / ketone
Flash point:	Below 0°C Class 3 A HIGHLY FLAMMABLE
Colour:	Red
Viscosity:	Sprayable grade, but due to high solids content may also be brushed or sprayed.
Temperature range:	-20°C to 190°C dependant on bond line stress
Bonding range:	10 - 30 minutes (contact) or up to 24 hours (heat activate)
Coverage:	3 - 5 sq. metres per litre of <b>bonded area</b> dependant on surface porosity.

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### TRANSPORT

Proper Shipping Name:	ADHESIVES
Hazard Class:	3
UN Number:	1133
Hazchem Code:	3[Y]E
Packaging Group:	11

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**Auckland Site**

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*This datasheet is for the general help of users. It is provided in good faith. The data is current and accurate to the best of our knowledge. Differing materials, substrates, environments, site conditions, and product storage, handling and application may affect results. Users should carry out tests to decide the product's suitability for purpose. This data sheet and the properties of the product may change without notice. Users, suppliers and retailers should check that the data sheets they have are the latest. To the maximum extent permitted by law, Bostik disclaims all warranties in relation to manufacture and use of the product. Bostik is not liable for representations made by users, suppliers or retailers about the product. Bostik is not liable for any loss or damage resulting from incorrect, careless, or negligent use or storage of the product, including use of out of date product. Any liability arising from use of the product is limited to the replacement or purchase price of the product. Bostik does not exclude rights and remedies that cannot be excluded by legislation, for example under the Consumer Guarantees Act 1993. Sale of the product by Bostik is subject to the Bostik New Zealand Limited Conditions and Terms of Sale. For more information on Bostik, products, and conditions of use and sale visit [www.bostik.co.nz](http://www.bostik.co.nz)*

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## 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 equipment gives best results, but airless spray guns will give acceptable spray patterns, however the gun tips and pressures 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, and the laminate must be rolled into place during this tacky stage and clamped temporarily until the glue line cools to room temperature.

### COMMON CAUSES OF BOND FAILURE :

	Symptoms	Possible Causes
1	Edge lifting	a. Insufficient adhesive. b. Bonding too soon. c. Insufficient pressure. d. Exposure to direct sunlight before 72 hours curing time.
	Symptoms	Possible Causes
2	Bubble in centre of laminate	a. Bonding too soon trapping solvent. b. Edges were rolled first instead of rolling from centre outwards. c. Insufficient adhesive or inconsistent spray pattern.
3	Shiny area over entire surface	a. Insufficient pressure. b. Blushing.
4	Dull areas on substrate	a. Coating too thin on highly absorbent surfaces.
5	Adhesive stringy when delaminating	a. Insufficient drying time, therefore bonding too soon.
6	Small circular un-bonded areas	a. Operator testing with fingers instead of knuckles.

If the temperature is low, you could experience blushing unless you take precautions. Blushing can be entirely eliminated by the installation of a hot spray unit.

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## STORAGE

Must be stored in a cool well ventilated store meeting the minimum requirements for Class 3 storage

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## PACKAGING

4 litre, 20 litre, 210 litre

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## **SHELF LIFE**

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

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## **VERSION**

Version 4.1

5<sup>th</sup> August 2011