PRODUCT DATA

FM 1696
ISO 9001

**Date: October 2005** **Information Sheet No.: B0061-14**

# 1782 (CLEAR) ADHESIVE

## GENERAL PURPOSE ADHESIVE

BOSTIK 1782 (CLEAR) ADHESIVE is a general purpose adhesive, the dried film of which is virtually colourless and non-staining. BOSTIK 1782 (CLEAR) ADHESIVE is of medium viscosity and provides a strong bond which has good chemical and temperature resistance and excellent ageing properties.

### RECOMMENDED USE

BOSTIK 1782 (CLEAR) ADHESIVE has many industrial uses and is particularly suitable for bonding leather, metals, wood, canvas, PVC and other plastics. It is widely used in the manufacture of toys, leather goods, furniture, upholstery, jewellery, many kinds of plastic-ware, etc.

The UK Ministry of Defence quality assurance and release document relating to BOSTIK 1782 (CLEAR) ADHESIVE is AFS 265D.

**NOTE:** To obtain enhanced bond properties with better resistance to high temperatures, oil, petrol and kerosene (see later) BOSTIK 1782 (CLEAR) ADHESIVE may be used in conjunction with BOSTIKURE D CURING AGENT* as a two part, cold curing adhesive system.
* See Information Sheet No.B596.

When so used the mix ratio by weight is 100 parts of adhesive to 6 parts of BOSTIKURE D or by taking:

| **BOSTIKURE 1782 (CLEAR)** | **BOSTIKURE D** |
|---|---|
| 1 litre tin | D40 bottle |
| 5 litre tin | D200 bottle |

The pot life of the mixed adhesive in a closed container is approximately 8 hours at normal room temperatures.

### BONDING INSTRUCTIONS

SURFACE PREPARATION

Surfaces must be dry, clean and grease free. If they are non-porous, smooth or glossy, they may be cleaned by abrading the surface with clean emery cloth or by using CLEANER 7

Rubber surfaces should be abraded, as the use of solvents for cleaning these does not give entirely satisfactory results.

Thick plastic sheets should be abraded. Porous surfaces may not need cleaning, but must be dry, grease free and firm.

APPLICATION TECHNIQUES

**Brush** - The adhesive must be applied evenly to the surface being coated.

**Gun Extrusion** - The adhesive can be extruded through the BOSTIK NO. 6A PRESSURE VALVE used in conjunction with a suitable pressure container. This BOSTIK extrusion valve can be fitted with either brush heads or nozzles.

**Spraying** - Dilute with CLEANER 7 or CLEANER 6 for application by suitable spray equipment.

This equipment must be thoroughly cleaned at the end of the day.



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**Roller Coating** - BOSTIK 1782 (CLEAR) ADHESIVE can be used in some roller coaters, but in general it is necessary to dilute with CLEANER 7 or CLEANER 6.

**Knife Blade Spreader** - BOSTIK 1782 (CLEAR) ADHESIVE can be used as supplied in certain types of knife blade spreaders.

**COVERAGE:** Approximately 2.8$m^2$ per litre (1.4$m^2$ per litre, bonded area) but can vary with material being bonded.

**CLEANER:** Use CLEANER 7 for the preparation of surfaces before adhesive application, for the removal of surplus adhesive and for the cleaning of application equipment.

BONDING METHODS

Five bonding methods may be used:

1. Two way dry stick.
2. One way wet stick.
3. One way semi-wet stick.
4. Heat activation.
5. Solvent activation.

**1. Two way dry stick**

Apply an even film of the adhesive to both surfaces by one of the techniques detailed under "Application Techniques".

Allow the two films to dry for 5 to 10 minutes or until they can be touched with the knuckles without any adhesive being transferred.

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

On some porous surfaces, a single application may be insufficient and a multi-coat application technique may then be used.

Intermediate coats should be allowed to dry for about 30 minutes, but the final coat should have the normal 5 to 10 minutes drying time.

**2. One way wet stick**

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 the two way dry stick, maximum bond strength being attained in 3 to 7 days. This technique can only be used where one or both surfaces to be joined are porous.

**3. One way semi-wet stick**

For use with very thin plastic sheeting that is curled by the action of the adhesive. Apply the adhesive to the surface to which the sheet will be bonded and allow to dry for approximately 4 minutes. The plastic sheeting is then rolled on to the semi-wet surface, using as much pressure as possible.

**4. Heat Activation**

Apply the adhesive to both surfaces and allow to dry completely. The coated surfaces may be left for several days providing they are kept clean and dry.

Either heat both surfaces to 100$^oC$ and bond together immediately under pressure or place the joined surfaces in a heated press at 100$^oC$ for 1 to 2 minutes.

**5. Solvent Activation**

Apply the adhesive to both surfaces and allow to dry completely. The coated surfaces may be left for several days providing they are kept clean and dry.

Activate both surfaces by brushing or spraying with CLEANER 7.



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Allow approximately 30 seconds for solvent evaporation and then bond under pressure.

## TYPICAL CHARACTERISTICS

| | |
|---|---|
| Physical Form: | Mobile liquid |
| Colour: | Colourless |
| Odour: | Ketonic |
| Chemical Type: | Nitrile rubber/resin based solution |
| Solvent: | Mixture of acetone and butanone. |
| Viscosity: | Approximately 10 Pa s (100 poise), (in tins)<br>Approximately 3.3 Pa s (33 poise), (in tubes) |
| Solids Content: | Approximately 30% (in tins)<br>Approximately 25% (in tubes) |
| Specific Gravity: | Approximately 0.9 |
| Flammability: | Highly flammable |
| Flash Point: | In the group -18 to -7$^{o}$C (closed cup) |
| Temperature Resistance: | -40 to +80$^{o}$C (-40 to +100$^{o}$C when cured with BOSTIKURE D). |
| Water Resistance: | Good |
| Oil, Petrol & Kerosene Resistance: | Good, but will not withstand prolonged immersion. (Very good when cured with BOSTIKURE D). |
| Solvent Resistance: | Good to intermittent contact with alcohols. Not resistant to ketones and esters. |
| Dilute Acid & Alkali Resistance: | Good |

## PACKAGING

Please refer to Customer Service Department for current package sizes.

## STORAGE

Store in a dry flameproof area between 5 and 25$^{o}$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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