



BOSTIK TRIPLE 5 BSR ADHESIVE

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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 Class 3 A
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 sq. metres per litre of bonded area dependant on surface porosity and application method.

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.

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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.

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 777 and others which give guaranteed bond strengths on difficult PVC materials. These adhesives 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:

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.
- 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 adhesive 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 unbonded areas
 - a. 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 :

Class 3A flammable goods. Must be stored in a cool well ventilated store meeting the minimum requirements.

SHELF LIFE :

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

TRANSPORT :

Proper Shipping Name:	ADHESIVES
Hazard Class:	3
UN Number:	1133
Hazchem Code:	2[Y]E
Packaging Group:	11

VERSION:

Version 1 21 August 1998

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