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## Bostik 2405 Adhesive

### Rubber-To-Rubber Adhesive - Parts A and B

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#### DESCRIPTION

Bostik Cement 2405 is a two-part, cold curing adhesive giving a tough resilient bond. This adhesive has been especially designed for use on rubberized canvas on rescue and pleasure equipment, canoes etc. It also has a wide range of building applications and gives good adhesion to natural and synthetic rubbers, wood and metal. The adhesive is not recommended for bonding PVC based or other plastic coated fabrics.

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#### SPECIFICATION

<b>Type</b>	Synthetic rubber/resin. Two part cold curing.
<b>Colour</b>	Part A - Off white Part B - Bostik Boscodur #10 or Desmodur RE or RFE
<b>Solvent</b>	Petroleum spirit, aromatic hydrocarbon ketone.
<b>Viscosity</b>	Medium brushable solution.
<b>Cleaner</b>	Bostik Cleaner No.2 for the preparation of the surfaces. Bostik Cleaner No.2 for the removal of surplus adhesive before fully cured.
<b>Thinner</b>	Bostik Thinner No.2.
<b>Flammability</b>	Highly flammable. Flash point < 0°C

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#### PROPERTIES

<b>Location</b>	Interior or exterior
<b>Curing Times</b>	72 hours under normal temperature conditions but the strength of the adhesive bond continues to increase, reaching its maximum in 14 days. Cure rate may be accelerated by heating to about 70°C for 10 -15 hours.
<b>Drying Time</b>	15 - 20 minutes or until the adhesive film can be touched with the knuckles without any cement being transferred.
<b>Tack Life</b>	Approximately 25 - 30 minutes dependant on temperature.
<b>Pot Life</b>	Not less than 4 hours in closed containers after mixing. Do not use after 6 hours even if the mix is still liquid. Resultant bond strength will be low.
<b>Coverage</b>	4 sq. metres per litre on one surface per coat.
<b>Staining</b>	Slight staining may occur on light coloured rubber stocks. When Desmodur RE is used
<b>Characteristics</b>	the dried bond line is a dark purple colour.
<b>Water Resistance</b>	When cured, the adhesive film has good water resistance.
<b>Solvent Resistance</b>	The resistance to petrol, oil and kerosene is good. It is not resistant to esters, ketones, aromatic and chlorinated hydrocarbons, which can swell and destroy the bond.
<b>Chemical Resistance</b>	The adhesive film has good chemical resistance being virtually unaffected by 5N Sulphuric Acid and 5N Sodium Hydroxide under laboratory conditions.
<b>Humidity</b>	Adhesive film shows good resistance when exposed to 100% relative humidity at 38°C for 14 days.
<b>Paintability</b>	After full cure the adhesive is compatible with all common paint systems, but always test

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<b>Working Temp.</b>	first.
<b>Range</b>	-40°C to +90°C dependant on bond line stress, higher stress or temperature may require larger bond line area.
<b>Ageing</b>	Very good resistance to exterior exposure. Dried glue line will stain under UV to yellow / brown.
<b>Mix Ratio</b>	60-80 parts A to 1 Part B by volume when using Boscodur #10. 20 parts A to 1 part B when using Desmodur RE/RFE. This ratio is a guideline only and individual users should experiment to determine the optimum level of crosslinker for their application.

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## PREPARATION

**Important : Stir the container thoroughly before use.**

The two parts of the adhesive are mixed together thoroughly. It is most important that complete homogeneity has been obtained. This will normally require at least 1 minute mixing for a 1 litre quantity.

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**PRECAUTIONS MUST BE TAKEN TO ENSURE THAT BOSTIK 2405 ADHESIVE, DESMODUR RFE CURING AGENT AND THE MIXED UNCURED ADHESIVE ARE NOT CONTAMINATED WITH WATER OR WATER VAPOUR AS THIS CAN HAVE DETRIMENTAL EFFECTS ON BOND STRENGTH.**

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## PRECAUTIONS:

Part A, Part B and the uncured adhesive must not be contaminated with water. Because this adhesive contains non-volatile reactive 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.

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## APPLICATION

### Two Way Dry Stick:

1. Surfaces must be clean and grease free. They may be cleaned by roughing the surface with clean emery cloth and also 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 and essential for best bond strength.
2. Apply an even film of the adhesive to both surfaces by brush, roller coater, or serrated trowel. Two coats may be necessary for exceptionally porous surfaces. Commonly the first coat is used as a "primer" coat and allowed to dry overnight. Next day apply another coat and bond as normal.
3. Allow the two films to dry for 15 - 20 minutes, or until they can be touched with the knuckles without any cement being transferred.
4. Join the surfaces, taking care not to trap any air and using as much pressure as possible. In some cases when a single adhesive application to each surface may be sufficient, multicoat applications may be used in order to build up film thickness. E.g on canvas.
5. Each coat should be allowed to dry for about 40-45 minutes or up to a maximum of 16 hours, except the final one which should have 15-20 minutes.
6. For strongest 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. The metal must be freshly cleaned. Steel is best sand blasted and primed immediately.
7. The bond strength improves with ageing. Lab tests show that after 14 days the bond has peaked. This is especially true for rubber to rubber bonds.

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## STORAGE

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

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**SHELF LIFE**

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

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**PACKAGING :**

Part A - 20 litres.

Part B - 500 ml, 750 ml or 1 L dependent on crosslinker.

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**HEALTH AND SAFETY**

Fuller details on each of the products mentioned above 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](http://www.bostik.co.nz) for copies.

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**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 CHEMCALL, phone 0800 243 622.](#)**

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**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.

**VERSION** July 2011 (Harmonise with Bostik UK)

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