



## Bostik 709 Adhesive

### DESCRIPTION :

Bostik 709 is a polychloroprene solvent based adhesive of brushing viscosity. This adhesive is well established in the coach building and automotive industries as a multipurpose body trim adhesive. Bostik 709 has also proved very versatile in the shop fitting and bar fitting trades, and in the boat building, garage door, furniture and footwear industries, where it is widely used as a multipurpose adhesive. This material has excellent heat resistance and ageing properties.

It forms strong permanent contact bonds between many materials. Polyurethane foams of the polyester and polyether types, supported PVC leathercloth, leather, polyester glass fibre, EVA and rubber sheet, Rubber and TPR soling; all of which may be bonded to each other or to hardboard, chipboard, wood painted or unpainted metal. Metals are best treated with a suitable etching/primer for maximum adhesion. Rigid laminated plastics such as Formica, melamine, etc may also be fixed with these adhesives.

### PROPERTIES :

Appearance:	Honey coloured liquid
Coverage:	3-4m <sup>2</sup> / Lt
Viscosity:	Medium Brushable
Heat Resistance:	Greater than 140°C (depending on stress loading)
Flash Point:	Below 0°C
Minimum Open Time:	10 – 15 minutes
Maximum Open Time:	30 minutes
Clean-up :	Bostik Solvent #2

### APPLICATION:

1. To obtain the best possible results, the materials to be bonded should be dry, clean and free from dust, grit, loose materials, oil or grease. If using a metal pre-treatment primer, the surface must be dried prior to application of the adhesive.
2. Using a brush or scraper, apply a thin even coating of adhesive to both surfaces.
3. Allow the solvent content to evaporate before bonding the materials. On permeable materials such as leather/chipboard, bonding may be possible within a matter of 2-3 minutes of application; or non-permeable materials (e.g. Formica/metal) a minimum of 15 minutes should elapse before the surfaces are bonded.
4. Bond the surfaces by contacting then applying firm pressure.

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Where perfectly accurate pre-positioning of the components is possible, the solvents should be allowed to dry out for between 20-30 minutes before bonding. Alternatively, where a measure of slide is necessary to position the materials, or where an allowance is to be made for trimming off afterwards, the glued surfaces may be brought together some 2-3 minutes after application or whilst still wet.

Do not trap solvent between impermeable surfaces, the solvent must be allowed to escape to build any real strength.

**NOTE:**

**Due to the variable nature of PVC it is wise to carry out a small test strip before using 1222. Bostik have other adhesives such as 2402 Part A and B (used for UPVC) or Bostik Ultragrip 777 or Bostik 1768 which give guaranteed bond strengths and nil staining on difficult PVC materials.**

Any adhesive on the face of PVC should be cleaned immediately using Bostik No. 1 solvent.

**PACKAGING:**

4 litre, 20 litre

**STORAGE :**

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

**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:	3[Y]E
Packaging Group:	11

**VERSION:**

Version 1                      2<sup>nd</sup> June 2014

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