
HP SYRENE ADHESIVE

HIGH PERFORMANCE, SPRAYABLE CONTACT ADHESIVE FOR POLYSTYRENE

DESCRIPTION

Bostik High Performance Styrene Adhesive is a synthetic rubber based adhesive which has excellent green strength, flexibility, sprayability and very good temperature resistance. It is suitable for bonding polystyrene foam and a variety of other light weight materials to:

Steel, Concrete, Wood, Masonry, Hardboard, Asbestos Cement Sheet, Particle Board, Polystyrene Foam Aluminium, Insulation Batts, Galvanised Iron, Fibreglass Reinforced Plastics and a host of other surfaces used in the construction of: Prefabricated buildings, Sandwich Panels, Cool Rooms, Caravans and Mobile homes
Bostik High Performance Styrene Adhesive has been formulated for application by pressure pot spray equipment and gives a quick initial tack to assist production handling. When sprayed as directed it will not mist or fog and will give a fine web-type spray pattern. Although optimised for spray application, it is possible to roll or brush this adhesive.

PROPERTIES

Colour	Green-blue
Consistency	Medium Viscosity
Solids content	Approx 30% by weight
Base	Synthetic rubber/resin
Solvent	Hexane blend
Flash Point	-18°C. HIGHLY FLAMMABLE
Application/environment limits	Subject to type of substrate and joint configuration. The maximum heat resistance is approximately 80°C dependent on bond line stress. If the stress is high then the heat resistance will need to be de-rated accordingly.

SURFACE PREPARATION

Surfaces to be clean, dry and free from oil, grease, dust or any other contamination. Metal surfaces should be wiped with Bostik Solvent No.1.

WORKING TEMPRATURE

For best results the adhesive should be sprayed between 5°C to 35°C.

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COVERAGE

3 – 4 m²/litre both sides or 6 - 8 m²/litre on ONE surface for best performance results. Most glue failures result from applying too little adhesive. Consumption should be carefully watched to ensure correct coverage for the foam type, and the method of application. Carry out regular quality checks with each operator to ensure consistency.

APPLICATION

The adhesive can be easily sprayed through conventional hand operated or semi-automatic spraying systems.

Spray a coat of adhesive on both surfaces to be bonded using fluid pressure of 10 - 30 psi and atomisation pressure of 25 - 45 psi. The exact pressure required depends on the number of spray heads, the hose lengths etc. Hold spray gun 18 to 24 inches from surface being bonded to achieve a wet coat and uniform spray pattern. If excessive atomisation pressure is used, and the gun held too far from surface being sprayed, insufficient wetting of surface occurs, resulting in inferior bond strengths. The two surfaces to be bonded are ready if no adhesive transfers to the skin when touched lightly with the back of the hand. Hot dry summer days will reduce the drying time while wintry humid conditions will increase it. It is recommended that for very porous surfaces a light seal coat be applied and allowed to dry then spray coat as stated above.

Care must be taken to avoid entrapping solvent in the bond line. If the adhesive surface is closed while it is still wet, foam collapse may occur, particularly with very low density foam.

Where this adhesive is used for other applications than polystyrene foam assembly, it may be applied by roller or brush. In some applications, such as art lay-up, fabric to screen attachment etc., a one-way application of the adhesive onto the base is suitable with the material laid into the slightly wet adhesive.

OPEN TIME

Assemblies may be bonded within 3 to 30 minutes depending on room temperature, humidity, spray pressures and bonding pressures used.

ASSEMBLY

Position the components carefully before assembling as no adjustment is possible after contact is made. (Use dowels or paper slip sheets as spacers to position large pieces). Remove spacers and apply even pressure for example by means of press, rollers or mechanical nip rollers. Assemblies bonded in this way can be machined trimmed or finished immediately after bonding.

NOTE

It is imperative that sufficient pressure is applied to ensure fusion of the adhesive films. Bonded assemblies should be kept away from direct sunlight and heat for at least 24 hours after bonding. Surfaces incorrectly aligned can be parted using Bostik Solvent No.1 and then re-bonded as above.

CLEANING

Use only Bostik Solvent No.1 to remove excessive adhesive and to clean equipment. Any other solvent may result in subsequent polystyrene foam attack.

STORAGE

Store in cool, dry conditions out of direct sunlight below 25°C and away from naked flame or sources of heat. Keep containers closed at all times as the adhesive tends to skin and lose solvent when exposed to air.

SHELF LIFE

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

FLAMMABILITY

The adhesive is highly flammable, do not open container within 10 metres of fire or flame. Use in well ventilated areas.

PACKAGING

4 litre, 20 litre and 210 litres.

TRANSPORT

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

VERSION

Version 4.1

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