



# BOSTIK 3206E

## SOLVENT BASED ADHESIVE

### KEY FEATURES

- Cleanliness of use
- Produces tough bonds
- Excellent adhesion to both plasticised and un-plasticised PVC

### DESCRIPTION

**Bostik 3206E** is a solvent-borne, polyurethane based adhesive for general purpose use.

### RECOMMENDED USE

**Bostik 3206E** is suitable for many industrial applications and will bond a wide variety of surfaces including wood, canvas, leather, PVC, nylon fabric, polyurethane coated fabric, polyurethane rubber, PVC and polyurethane foam, polycarbonate, ABS and decorative laminated plastics.

**NOTE:** To obtain enhanced properties with better resistance to high temperatures and fluids **Bostik 3206E** may be used in conjunction with **Bostikure D** as a two part, cold curing adhesive system

### IMPORTANT

Before embarking on any work involving **Bostik 3206E** the safety data sheet should be carefully studied by those carrying out the work.

### BSI STANDARDS



### METHOD OF USE

#### SURFACE PREPARATION

- Thoroughly clean and dry both surfaces, abrading where applicable.

#### ADHESIVE PREPARATION

When using as a two part system with **Bostikure D** the mix ratio is 100 parts of adhesive to 6 parts of **Bostikure D** (by weight) or by taking:

**Bostik 3206E**  
1 litre tin  
5 litre tin

**Bostikure D**  
D40 bottle  
D200 bottle

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

### APPLICATION & BONDING

- Apply an even film of adhesive to both surfaces with a brush or serrated trowel. The latter is ideal for covering large areas, if spray application is preferred the adhesive should be diluted with an equal volume of **Cleaner 1**
- Allow the two films to dry for approximately 5 to 10 minutes. This range should be checked if possible with the particular material to be bonded. With thin adhesive films, which are created by very absorbent surfaces or merely brushing out thinly, it is advisable to allow the first coat to dry for at least 20 minutes, apply a second coat and leave 5 to 15 minutes before bonding.
- Bring the two coated surfaces together using sufficient pressure to ensure intimate contact.

**NOTE:** Polyurethane adhesives of the **Bostik 3206E** type do not have the same aggressive tack property as that of polychloroprene contact adhesives. Bond open times are accordingly shorter and greater pressures are required when the bonds are made.

**N.B.** In certain cases it may be possible to use other bonding techniques such as one way wet or semi-wet stick, heat or solvent activation. In all cases, however, preliminary tests must be carried out to determine suitability.

### TYPICAL CHARACTERISTICS

|                                          |                                                                                 |
|------------------------------------------|---------------------------------------------------------------------------------|
| Physical form                            | Semi viscous liquid                                                             |
| Colour                                   | Clear, slightly amber                                                           |
| Chemical type                            | Polyurethane/resin based solution                                               |
| Odour                                    | Predominantly ketone                                                            |
| Solvent                                  | Mixture of ketones & toluene                                                    |
| Flammability                             | Highly flammable                                                                |
| Flash Point (closed cup)                 | In the group – 18 to -7°C                                                       |
| Viscosity, Brookfield RVT, 20rpm at 25°C | [mPa.s] Approx. 3000                                                            |
| Total solids content                     | [%] Approx. 22                                                                  |
| Relative density                         | Approx. 0.9                                                                     |
| Coverage                                 | Approximately 4m <sup>2</sup> per litre (2m <sup>2</sup> per litre bonded area) |
| Temperature resistance                   | -20 to +80°C (-20 to +100°C when cured with <b>Bostikure D</b> )                |
| Water resistance                         | Good                                                                            |

|                                              |                                                                                                                                                                 |
|----------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Oil, petrol &amp; kerosene resistance</b> | Good                                                                                                                                                            |
| <b>Staining</b>                              | Generally non-staining but on light coloured, thin PVC very slight staining may occur under extreme conditions.<br><b>NB</b> Exposed adhesive film turns brown. |
| <b>Cleaner</b>                               | Use <b>Cleaner 1</b> for surface cleaning, the removal of surplus adhesive and for cleaning application equipment                                               |

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## PACKAGING

Please refer to Customer Service Department for current pack sizes.

## STORAGE

Store in a cool well ventilated place in the temperature range 10 – 30°C. Treat as flammable/combustible – Keep away from oxides, heat and flames.

## SHELF LIFE

At least 12 months from date of manufacture, closed in original packaging under the above conditions of storage.

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## SMART HELP

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