



2402 ADHESIVE

SOLVENT BASED ADHESIVE

KEY FEATURES

- Good heat, water & humidity resistance
- Suitable for bonding many substrates (excluding flexible PVC)
- Approved by the UK Ministry of Defence

DESCRIPTION

Bostik 2402 is a solvent borne formulation based on polychloroprene rubber. It is used in conjunction with **Bostikure D curing agent** as a two part, cold curing adhesive system which has a wide range of industrial applications. It exhibits good storage stability and offers strong resilient bonds which exhibit good resistance to water, heat, humidity, etc.

RECOMMENDED USE

Bostik 2402 will bond natural, polychloroprene, nitrile, butyl, Hypalon and polyurethane rubber surfaces, rigid PVC, wood, metal, leather, etc. It can be used as a heat resistant adhesive for decorative laminated plastics and is particularly useful in the construction of inflatable products such as boats, balloons etc.

Bostik 2402 is approved, in conjunction with **BOSTIK 9252 PRIMER**, under the UK Ministry of Defence Specification DTD900/4679A for bonding synthetic rubber de-icer shoes to aircraft propeller blades and for use in the manufacture and repair of aircrew and survival clothing and of inflatable equipment. For these and other appropriate general purpose applications the quality assurance and release document approved by the UK Ministry of Defence is AFS 1179B.

IMPORTANT It is not recommended that **Bostik 2402** be used on plasticised PVC because of the possibility of plasticiser migration.

IMPORTANT

Before embarking on any work involving **Bostik 2402** the safety data sheet should be carefully studied by those carrying out the work.

BSI STANDARDS



FM1696
BS EN ISO 9001:2000



EMS 53282
ISO 14001

METHOD OF USE

SURFACE PREPARATION

- Ensure the surfaces to be bonded are clean and grease free by cleaning with **Bostik M501 cleaner**, abrading with a clean emery cloth then cleaning again with **Bostik M501 cleaner** to remove surface dust.
- When bonding certain materials, such as wood and decorative laminates, it is not normally necessary to abrade them but they must be dry, clean and grease free. If necessary remove any surface contamination with **BOSTIK CLEANER/THINNER M501**.

ADHESIVE PREPARATION

- Stir the **Bostik 2402** thoroughly for a few minutes, to ensure any ingredients which may have settled in storage are thoroughly redispersed. Ensure there is no solid sediment on the bottom of the container before proceeding.
- Mix together thoroughly, for approximately 5 minutes, **Bostik 2402** and **Bostikure D curing agent** preferably in the portions as supplied or by taking (by weight) 100 parts of the adhesive and 6 parts of the curing agent.

APPLICATION & BONDING

- Apply an even coat of the mixed adhesive to both mating surfaces by brush, roller coater or serrated spreader.
- Allow the adhesive coats to dry for 10 to 20 minutes or until they can just be touched with the knuckles without the adhesive being transferred.
- **NOTE:** Two thin coats of adhesive are preferable for maximum adhesion. The first coat should be allowed to dry for approximately 20 to 30 minutes before applying the final coat and allowing this to dry for 10 to 20 minutes.
- Join the surfaces, taking care not to trap any air, using as much pressure as possible. Components may be handled within minutes of being bonded.
- For the strongest adhesion to metal use **Bostik 9252 primer**, full details of which are given in TDS 01232. Stir the primer thoroughly and then brush apply an even, thin coat to the prepared metal surface. Allow the primer coat to dry for at least one hour before applying **Bostik 2402**.

PRECAUTIONS MUST BE TAKEN TO ENSURE THAT BOSTIK 2402, BOSTIKURE D CURING AGENT AND THE MIXED UNCURED ADHESIVE ARE NOT CONTAMINATED WITH WATER OR WATER VAPOUR AS THIS COULD HAVE A DETRIMENTAL EFFECT ON BOND STRENGTHS.

TYPICAL CHARACTERISTICS

Physical form	Mobile Liquid
Colour	Off white
Chemical type	Polychloroprene rubber/resin solution
Solvent	Mixture of ketones, light petroleum spirit & toluene
Flammability	Highly Flammable
Viscosity Brookfield RVT, 20rpm at 25°C [P]	Approx. 25
Total solids content [%]	Approx. 22
Relative density	Approx. 0.90
Tack life	Approx. 20 to 30 mins dependent on the surfaces being bonded.
Curing time	48 hours under normal ambient temperature conditions but the strength of the adhesive bond continues to increase, reaching its maximum within 7 days. Cure rate may be accelerated by heating e.g. 2 hours at approximately 70°C.
Pot life	6-8 hours in a closed container, shorter due to solvent evaporation in open containers. Pot life decreases with the age of the adhesive
Coverage	Approx. 4m ² per litre (2m ² of bonded area) but can vary with material being bonded
Temperature resistance	-40 to +90°C but will withstand higher temperatures for short periods
Water resistance	Good
Humidity resistance	Good, after exposure to 100% RH at 38°C for 14 days.
Oil, petrol & kerosene resistance	Fair - Good
Solvent resistance	Not resistant to esters, ketones or aromatic hydrocarbons which may swell and soften the bond
Dilute acid & alkali resistance	Good. Virtually unaffected by 5N sulphuric acid and 5N sodium hydroxide.
Ageing	Good but exposed adhesive film will darken
Cleaner/Thinner	Bostik M501 cleaner can be used for cleaning most surfaces but may attack painted surfaces. Bostik M501 cleaner may also be used for adhesive dilution, removal of surplus adhesive and cleaning of application tools and equipment.

PACKAGING

For current pack sizes please contact the Customer Service Department.

STORAGE

Store in a cool, dry, well ventilated flame proof area in the temperature range 5 - 25°C.

SHELF LIFE

At least 12 months from date of manufacture stored closed in original containers under the above conditions.

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SMART HELP

Please contact your local representative

