



Technical Data Sheet

7132K

Liquid Adhesives

Product Description

ADH 7132K is a kit containing Bostik 7132R/Boscodur 24T as a two component adhesive system specifically designed for use in the vacuum form bonding of PVC films to wood, fiberboards, and most porous substrates. Characterized by its high green strength, the system permits for edge trimming immediately after removal from the vacuum former.

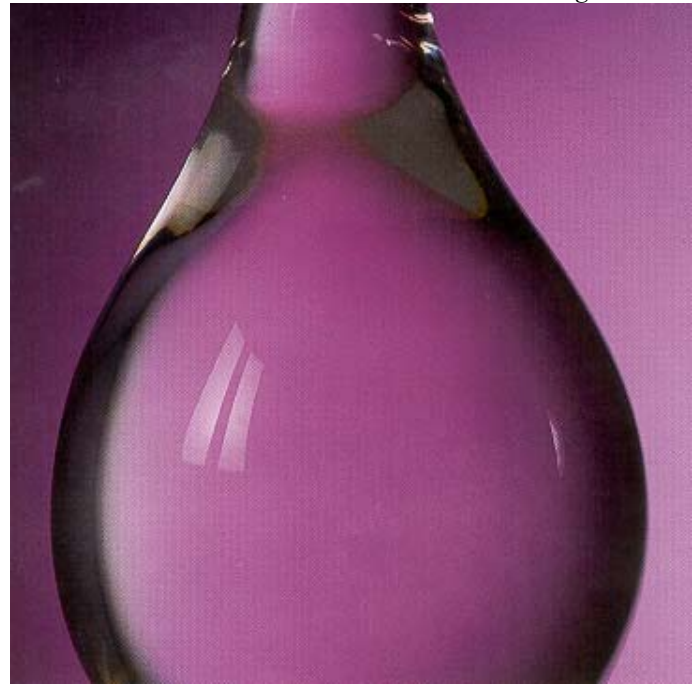
In addition to securing strong, resilient anchorage to PVC, Bostik 7132R displays inherently high adhesion to polyolefin foams, polyester films, most plastic laminating films, foils, sheet metal surfaces, and to cellulose in general. Boscodur 24T is used to ensure the development of heat and creep resistant bonds.

Product Benefits

- Wide processing window that allows for its use in many customers' varying processes
- Excellent adhesion to vinyl, particle board, polyolefin foams, and plastics
- Cures to a tough, highly heat resistant film.

Product Applications

- Aeronautic - laminating decorative films to aluminum or honeycomb sidewalls in the construction of cabin interiors
- Automotive - vacuum forming PVC film and polyolefin foam to rigid substrates in the manufacture of door panels, consoles, dashboards, and other interior trim
- Furniture - vacuum forming PVC films to particle boards in the production of decorative furniture facings
- Luggage - vacuum form construction of PVC coated luggage shells



Typical Physical Properties (not for specification use)

| | Part A (Bostik 7132R) | Part B (Boscodur 24T) |
|-------------------------|----------------------------|--------------------------|
| Appearance: | amber liquid | dark brown liquid |
| Base: | linear saturated polyester | polyisocyanate |
| % Total Solids: | 25.5% | 68% |
| Viscosity (Brookfield): | 100 cps | thin liquid |
| Density, lbs./gal.: | 7.67 | 8.76 |
| Flash Point (SCC): | 14°F (-10°C) | 29°F (-2°C) |
| Solvent System: | MEK blend | MEK |
| Mixing Ratio: | 20-24 volumes | 1 volume |

IMPORTANT NOTICE

All statements, technical information and recommendations set forth herein are based on tests which Bostik believes to be reliable. However, Bostik does not guarantee their accuracy or completeness. The buyer should conduct its own tests of this product before use to determine proper preparation technique and suitability for proposed application. Any sales of this product shall be on terms and conditions set forth on Bostik's order acknowledgement. Bostik warrants that the product conforms with Bostik written specifications, and is free from defects. BOSTIK DISCLAIMS ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. THE BUYER'S SOLE REMEDY FOR NONCOMPLIANCE WITH THIS WARRANTY SHALL BE FOR THE REPLACEMENT OF THE PRODUCT OR REFUND OF THE BUYER'S PURCHASE PRICE. IN NO CASE WILL BOSTIK BE LIABLE FOR DIRECT, CONSEQUENTIAL ECONOMIC OR OTHER DAMAGES.

Directions for Use

Equipment: direct roll, reverse roll, gravure, or any coater common to the industry. This adhesive can also be sprayed via Graco, Devilbuss, Binks, or similar units. Method: Add Part B to Part A in accordance with the mixing ratio specified above and blend to a homogenous solution (solvent dilutions, where applicable, should be made immediately after the Part B addition). Apply 100-150 gr/m² (wet) adhesive to the least porous laminating surface and evaporate the solvent by standard drying techniques. Lamination is effected by pressure at 110-212°F (41-100°C).

Storage and Handling

Pot life: 8 hrs.
Shelf life: 6 months at 55-80°F (15-27°C)

Boscodur 24T should be stored in a sealed container. Once opened it should be nitrogen purged to prevent contamination from moisture in the air.

Bostik 7132R has a shelf life of at least 6 months if stored in an unopened container. Recommended clean up is with MEK/Toluene solution.

Extremely flammable! Before using, extinguish all flames and pilot lights. Use only in well ventilated areas. During application and until vapors are gone, keep product away from heat, sparks, and flame. Avoid using spark-producing equipment such as switches, tools, appliances, etc. Keep container tightly closed when not in use. Material Safety Data Sheets on these and all Bostik products are readily available upon request.

Further Information

Please refer to MSDS for complete details.

IMPORTANT NOTICE

All statements, technical information and recommendations set forth herein are based on tests which Bostik believes to be reliable. However, Bostik does not guarantee their accuracy or completeness. The buyer should conduct its own tests of this product before use to determine proper preparation technique and suitability for proposed application. Any sales of this product shall be on terms and conditions set forth on Bostik's order acknowledgement. Bostik warrants that the product conforms with Bostik written specifications, and is free from defects. BOSTIK DISCLAIMS ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. THE BUYER'S SOLE REMEDY FOR NONCOMPLIANCE WITH THIS WARRANTY SHALL BE FOR THE REPLACEMENT OF THE PRODUCT OR REFUND OF THE BUYER'S PURCHASE PRICE. IN NO CASE WILL BOSTIK BE LIABLE FOR DIRECT, CONSEQUENTIAL ECONOMIC OR OTHER DAMAGES.