

Bostik NE486 and 2402 Adhesive Instructions

Bostik NE486 and 2402 are two part moisture curing contact adhesives.

Mixing Bostik NE486 or 2402 adhesives correctly with Bostikure 'D' hardener is important to create the strongest bond possible. A litre will cover approximately 4m².

Materials and tools:

- Bostik NE486 or 2402 adhesive
- Bostik 'D' curing agent
- Bostik M501 cleaning thinners
- Glue pot
- Mixing stick
- Short bristle brush
- Seam roller
- 60 grit sandpaper
- Mutton cloth



Health and safety

When working with solvents it is essential to work in a well ventilated environment away from sources of ignition. Gloves and eye protection should be worn at all times and care should be taken to prevent contact with skin and eyes. For further information please refer to manufacturer's material safety data sheets (MSDS) which are available on our website. (www.henshaw.co.uk/pdf/pdf81.pdf)

Storage

Adhesive and curing agent should be stored upright in its original container in a cool, dry place away from sparks, heat and open flames. For further information please refer to manufacturer's material safety data sheets (MSDS) which are available on our website. (www.henshaw.co.uk/pdf/pdf81.pdf)

Precautions must be taken to ensure the Bostik Adhesive, 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 the bond strength.

Mixing

The adhesive should be mixed up 96% Bostik adhesive to 4% Bostikure 'D' hardener (see table below). Adhesive should be mixed vigorously for at least 5 minutes.



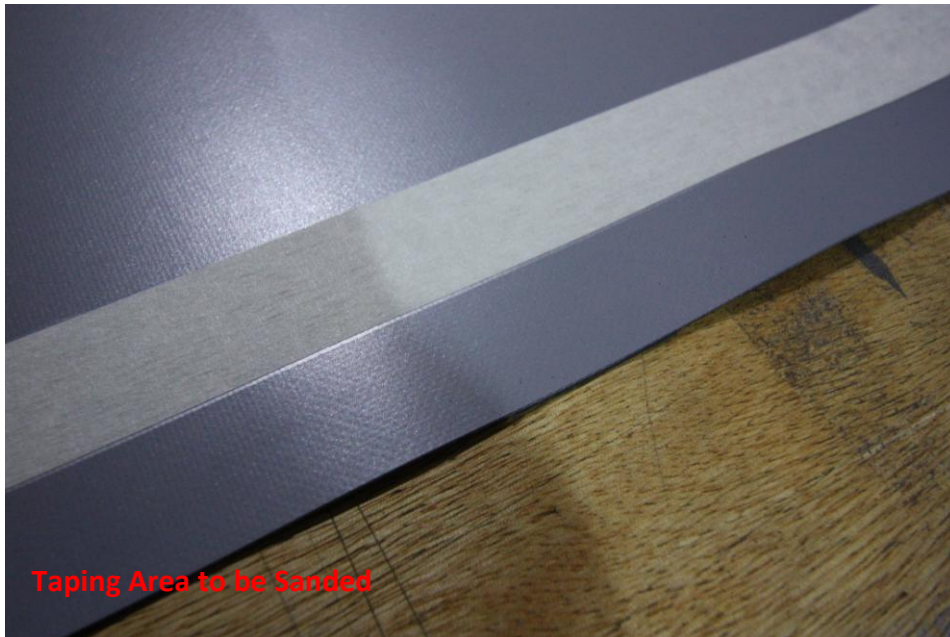
Once the adhesive is mixed the pot life is between 6 and 8 hours if kept in a closed container at temperatures around 10°C, this is reduced in high humidity.

Bostik NE486 and 2402 to Bostikure 'D' Hardener mixing ratios:

Adhesive (litres)	Bostikure 'D' Hardener (millilitres)	Total (litres)
0.24	10	0.25
0.48	20	0.5
0.96	40	1
4.8	200	5

Surface Preparation

1. Mark out the area to be bonded using pencil or chinagraph.
2. Tape around the outside of the marked lines using masking tape. Taping around the outside of the lines creates slight over-sanding to make sure the edges of the bond successfully.



3. Using sandpaper buff the surface of the hypalon inside the taped area. It is very important to buff the surface until the surface has no shiny areas at all. Make sure to buff right up to the tape lines. The hypalon will have an even matt finish when finished. When buffing the surface of the fabric take care not to sand down to the weave beneath the Hypalon surface.
4. Using the cloth and thinners wipe down the buffed area making sure to remove all debris and grease. At this point check to see that the whole surface is an even matt finish. Rebuff and re-clean any other areas.



Application

Apply a priming coat using a glue brush. Evenly spread the adhesive over the surface of the fabric taking care to cover all areas and not get any debris on the surfaces. Remove the tape immediately after application, while the adhesive is still wet. Wait for a minimum of 30 minutes for priming coat to dry (ideally 12 hours).

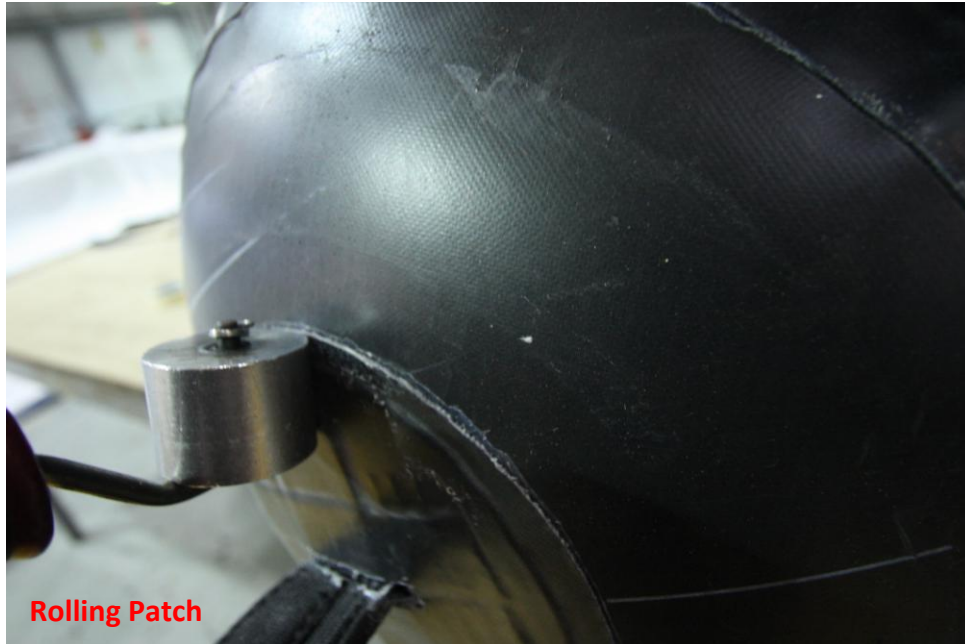


Make sure priming coat is dry it should appear shiny, showing no 'milky' and have an even opacity. Apply another even coat of adhesive to the tube and patch. When applying the adhesive spread it a few millimetres over the edges of the marked area. This excess adhesive will later be removed. Glue brushes should be cleaned thoroughly with Bostik M501 thinners or stored in thinners.

Wait for between 5 and 20 minutes for the adhesive to become ready to stick. If there are areas where the adhesive is still a milky colour then it is not ready. To test when the adhesive is ready for bonding use your knuckles to feel the surface of the glued area. Do not use fingers as they are much oilier which will adversely affect the bond. No adhesive should be transferred to your knuckles and should grip your knuckles if you try to move them across the surface. The adhesive should have an even colour across the whole surface. Once the adhesive reaches this state it is bondable for between 10 and 20 minutes.

Stick the two materials together as previously marked. There are many techniques and ways to do this depending on the shapes and materials.

Using a seam roller apply pressure across the bonded area against a hard surface. Work from the centre of the patch to the outside. Apply as much pressure as possible and make sure all areas are rolled thoroughly. If air bubbles are present use the roller to work them out to the edge. Make sure the edges with any damaged area, are rolled particularly hard. Remove excess adhesive using crepe or a drill with glue



Leave the patch for at least 12 hours, preferably 72, for the adhesive to cure before inflating. The adhesive continues to cure for 7 days. The repair can be handled after an hour.