Technical Data Sheet
23/09/2013

Quality ISO 9001

TRIPLE 5 BSR
LAMINATING ADHESIVE

DESCRIPTION

Bostik Triple 5 BSR adhesive is a high quality, high strength laminating adhesive, which can be applied by brush, spray or roller. It features high immediate bond strength and heat resistant bonds after full curing.

Bostik Triple 5 BSR is a versatile adhesive and may be used to give high quality bonds to most common building substrates and general laminating operations, such as plywood, galvanized and other metal sheets, wood veneer, PVC flooring, internal bracing and honey comb stuffing, plaster board etc. It is ideally suited for bonding decorative laminates such as Formica, Laminex etc. to particle board surfaces. When post forming laminates, use Bostik 1456 adhesive for high immediate heat resistance.

CAUTION

Bostik Triple 5 BSR Adhesive contains solvents and is highly flammable. All naked flames must be extinguished before starting work. The work area must be well ventilated. If working in enclosed areas where the ventilation is limited, an activated carbon mask, suitable for solvent should be worn.

PROPERTIES

Type:	Neoprene contact
Solvent:	Hydrocarbon / ketone
Flash point:	Below 0°C
Solids content:	Approx. 20 %
Colour:	Red
Viscosity:	Sprayable grade, but due to high solids content may also be brushed or rolled.
Temperature range:	-20°C to 150°C dependant on bond line stress.
Bonding range:	10 - 60 minutes dependant on temperature and substrates bonded (contact) or up to 24 hours (heat reactivated).
Coverage:	2 - 5 m^2/L of bonded area dependant on surface porosity and application method.
Clean up:	Bostik Solvent No. 2 for application equipment.

Wellington Site (Factory & Admin) **19 Eastern Hutt Road, Wingate, Lower Hutt** Ph ++64 4 567 5119 Fax ++64 4 567 5412
Auckland Site **148 Pavilion Drive, Airpark II, Auckland Airport** Ph ++64 9 257 5847 Fax ++64 9 257 3588
www.bostik.co.nz

NOTE

Due to the variable nature of PVC flooring materials it is wise to carry out a small test strip before using Triple 5 BSR. Bostik have other adhesives such as Bostik Ultragrip 777 and others which give guaranteed bond strengths on difficult PVC materials. These adhesives do not soften or stain when used with PVC even under adverse conditions. If in doubt please contact Bostik. Any adhesive on the face of PVC should be cleaned immediately using Bostik No. 3 Solvent.

COMMON CAUSES OF BOND FAILURE

Edge Lifting:
- Insufficient adhesive
- Bonding too soon
- Insufficient pressure
- Exposure to direct sunlight before 72 hours curing time.

Bubble in centre of laminate:
- Bonding too soon trapping solvent
- Edges were rolled first instead of rolling from centre outwards
- Insufficient adhesive or inconsistent spray pattern.

Shiny area over entire adhesive surface
- Insufficient pressure
- Blushing.

Dull areas on substrate
- Coating too thin on highly absorbent surfaces.

Adhesive stringy when delaminating
- Insufficient drying time, therefore bonding too soon.

Small circular unbonded areas
- Operator testing with fingers instead of knuckles.

If the temperature is low, blushing may occur on the adhesive surface unless you take precautions. Blushing can be entirely eliminated by the installation of a hot spray unit or by modifying the air flow in the workplace.

APPLICATION

Preparation:
All surfaces to be bonded must be clean and dry, free of grease, oils, dust or other contamination. For optimum bond strength, wipe non-porous surfaces with a solvent such as Bostik Solvent No 3. Shake or stir the adhesive well before use.

Thinning:
Thinning may be done sparingly to compensate for evaporative losses or to optimise spraying. Use Bostik Solvent No. 2.

Application:
Normal air operated spray equipment gives best results. With airless spray guns the tips and fan widths will require more experimentation to suit all applications. The adhesive should be at room temperature for best sprayability.

Spray an even coat with particular care at the edges to both surfaces to be bonded. It is MOST IMPORTANT to apply sufficient adhesive at this stage for best properties later.

Porous substrates may require a second coat of adhesive. A generous film of adhesive should remain visible on the surface after drying. The first coat must be dry before recoating, allow 10 minutes or more.

Allow the sprayed surfaces to become dry to the touch before carefully lining the two up and bringing the coated surfaces together using as much pressure as possible. Nip rollers properly set should give a minimum pressure of 280 KPa (40 psi). Most laminating failures occur due to lack of combining pressure or lack of adhesive. (See Common Causes of Bond Failure above).

Proper substrate alignment is necessary. If they are misplaced at this stage they cannot be re-bonded without re-spraying. Care is necessary. The bond is immediate and strong.

To heat reactivate, the surfaces must be allowed to fully dry as the wet or tacky adhesive is highly flammable. Apply heat using a heat gun or purpose designed machinery, the optimum surface temperature is 90° C. The heat activated surface will retain its tackiness for about 10 minutes.

To reactivate with solvent, wipe the surfaces lightly with Bostik Solvent No. 2.

PACKAGING

4 litre, 20 litre, 210 litre.

HEALTH & SAFETY

Fuller details on each of the products mentioned are available on the product Safety Data Sheets. To ensure no harm is caused to persons using Bostik products, it is recommended that the appropriate Safety Data Sheets are read by all concerned. Visit www.bostik.co.nz for copies.

FIRST AID
Swallowed Do not induce vomiting, give a glass of water and contact a doctor immediately.

Skin Remove contaminated clothing, wash with warm soapy water. Do not scrub.

Inhaled Remove person to fresh air. Get medical advice if breathing becomes difficult. If inhaled to excess, remove from contaminated area – apply artificial respiration if not breathing.

Eyes Hold open and flood with water for at least 15 minutes. Get medical advice.

For emergency information contact the National Poisons Information Centre, phone 0800 764 766 (0800 POISON) or CHEMCALL, phone 0800 243 622.

SHELF LIFE

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

DISPOSAL

If spilt, absorb with clay, sand or earth. Collect and seal in properly labelled metal containers. Dispose of according to local authority regulations. Do not dispose of down drains or into local waterways.

VERSION

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