

## PRODUCT DATA

Date: June 2010

Information Sheet No.: B1996-04

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# BOSTIK 3206E

## GENERAL PURPOSE ADHESIVE

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**BOSTIK 3206E ADHESIVE** is a solvent-borne, polyurethane based adhesive for general purpose use. It has the advantages of:

- \*Cleanliness of use
- \*Toughness of bond
- \*Excellent adhesion to both plasticised and unplasticised PVC

### RECOMMENDED USE

**BOSTIK 3206E ADHESIVE** 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 ADHESIVE** may be used in conjunction with **BOSTIKURE D\*** as a two part, cold curing adhesive system. (\*See Information Sheet No. B596)

When so used 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.

### BONDING INSTRUCTIONS

1. Thoroughly clean and dry both surfaces, abrading where applicable.
2. Apply an even film of adhesive to both surfaces with a brush or serrated trowel. The latter is ideal for covering large areas, but if spray application is preferred the adhesive should be diluted with an equal volume of **CLEANER 1**
3. 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.
4. 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 sticks, heat or solvent activation. In all cases, however, preliminary tests must be carried out to determine suitability.

Coverage:                      Approximately 4m<sup>2</sup> per litre (2m<sup>2</sup> per litre bonded area)

Cleaner: Use **CLEANER 1** for surface cleaning, the removal of surplus adhesive and for cleaning application equipment.

## TYPICAL CHARACTERISTICS

Physical Form:	Semi-viscous liquid
Colour:	Clear, slightly amber
Odour:	Predominantly ketone
Chemical Type:	Polyurethane/resin based solution
Solvent:	Mixture of acetone, toluene and methyl ethyl ketone
Viscosity:	Approx. 3000 mPas (30 poise)
Solids Content:	Approx. 22%
Specific Gravity:	Approx. 0.9
Flammability:	Highly flammable
Flash Point (Closed Cup):	In the group -18 to -7°C
Temperature Resistance:	-20 to +80°C (-20 to +100°C when cured with <b>BOSTIKURE D</b> ).
Water Resistance:	Good
Oil, Petrol & Kerosene Resistance:	Good
Staining:	Generally non-staining but on light coloured, thin PVC very slight staining may occur under extreme conditions. <b>NOTE:</b> Exposed adhesive film turns brown.

## PACKAGING

Please refer to Customer Service Department for current package 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 when stored closed in original packaging under the above conditions.

## MATERIAL SAFETY DATA

For further information refer to the relevant Health and Safety Data Sheet.

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