

Bostik

Issued May 2000

Information Sheet No. B0582-5
(Supersedes Sheet No. B0582-4)

3206 ADHESIVE

DESCRIPTION

BOSTIK 3206 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 3206 ADHESIVE is suitable for many industrial applications and it will bond a wide variety of surfaces including wood, canvas, leather, PVC, nylon fabric, polyurethane coated fabric, steel, *aluminium, *polyurethane rubber, PVC and polyurethane foam, polycarbonate, ABS and decorative laminated plastics.

*Metallic surfaces should first be primed with BOSTIK 9253 PRIMER. (See Information Sheet No. B96).

NOTE: To obtain enhanced properties with better resistance to high temperatures and fluids BOSTIK 3206 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 or by taking:

BOSTIK 3206

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 (and priming in the case of metallic surfaces).
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 BOSTIK M501 CLEANER/THINNER.
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 3206 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 4m² per litre (2m² per litre bonded area)

Cleaner: Use BOSTIK M501 or N (M576) CLEANER/THINNER for surface cleaning, for 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:	3 Pa s (30 poise) approximately
Solids Content:	22% approximately
Specific Gravity:	0.9 approximately
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 BOSTIKURE D).
Water Resistance:	Good
Oil, Petrol &	

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Kerosene Resistance:	Good
Staining:	Generally non-staining but on light coloured, thin PVC very slight staining may occur under extreme conditions. NOTE: Exposed adhesive film turns brown.
Bond Strength:	2.8 MPa (400psi) in shear, Formica/wood bond.

PACKAGING

Please refer to Customer Service Department for details of current pack sizes.

STORAGE

Store in a dry flameproof area between 5 and 25°C. Keep from freezing.

SHELF LIFE

1 year from date of manufacture under the above conditions of storage.

MATERIAL SAFETY DATA

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