

Description

Bostik Cement 2405 is a two-part, cold curing adhesive giving a tough, resilient bond. This adhesive has been especially designed for use on rubberized canvas on rescue and pleasure equipment, canoes etc. It also has a wide range of building applications and gives good adhesion to natural and synthetic rubbers, wood and metal. The adhesive is not recommended for bonding PVC based or other plastic coated fabrics.

Recommended Uses

- Rubber and Hypalon inflatables
- Conveyor belting
- Bonding rubber to steel.



Application Instructions

PREPARATION

Important : Stir the container thoroughly before use.

The two parts of the adhesive are mixed together thoroughly. It is most important that complete homogeneity has been obtained. This will normally require at least 1 minute mixing for a 1 litre quantity.

APPLICATION

Two Way Dry Stick:

1. Surfaces must be clean and grease free. They may be cleaned by roughing the surface with clean emery cloth and also by using Acetone to remove surface contamination. Solvent cleaning should not be adopted for those surfaces where the bond strength is likely to be affected adversely by the penetration of the solvent into the material. For maximum adhesion to rubber, roughing is preferable to solvent and essential for best bond strength.
2. Apply an even film of the adhesive to both surfaces by brush, roller coater, or serrated trowel. Two coats may be necessary for exceptionally porous surfaces. Commonly the first coat is used a "primer" coat and allowed to dry overnight. Next day apply another coat and bond as normal.
3. Allow the two films to dry for 15 - 20 minutes, or until they can be touched with the knuckles without any cement being transferred.

4. Join the surfaces, taking care not to trap any air and using as much pressure as possible. In some cases when a single adhesive application to each surface may be sufficient, multicoat applications may be used in order to build up film thickness. E.g on canvas.
5. Each coat should be allowed to dry for about 40-45 minutes or up to a maximum of 16 hours, except the final one which should have 15-20 minutes.
6. The bond strength improves with ageing. Lab tests show that after 14 days the bond has peaked. This is especially true for rubber to rubber bonds.

Properties

Location	Interior or exterior
Curing Times	72 hours under normal temperature conditions but the strength of the adhesive bond continues to increase, reaching its maximum in 14 days. Cure rate may be accelerated by heating to about 70°C for 10 -15 hours.
Drying Time	15 - 20 minutes or until the adhesive film can be touched with the knuckles without any cement being transferred.
Tack Life	Approximately 25 - 30 minutes dependant on temperature.
Pot Life	Not less than 4 hours in closed containers after mixing. Do not use after 6 hours even if the mix is still liquid. Resultant bond strength will be low.
Coverage	4 sq. metres per litre on one surface per coat.
Staining	Slight staining may occur on light coloured rubber stocks. When Bostik 9101 is used the dried bond line is a dark purple colour.
Water Resistance	When cured, the adhesive film has good water resistance.
Solvent Resistance	The resistance to petrol, oil and kerosene is good. It is not resistant to esters, ketones, aromatic and chlorinated hydrocarbons, which can swell and destroy the bond.
Chemical Resistance	The adhesive film has good chemical resistance being virtually unaffected by 5N Sulphuric Acid and 5N Sodium Hydroxide under laboratory conditions.
Humidity	Adhesive film shows good resistance when exposed to 100% relative humidity at 38°C for 14 days.
Paintability	After full cure the adhesive is compatible with all common paint systems, but always test
Working Temp.	-40°C to +90°C dependant on bond line stress, higher stress or temperature may require larger bond line area.
Ageing	Very good resistance to exterior exposure. Dried glue line will stain under UV to yellow / brown.
Mix Ratio	15-20 parts A to 1 part B by volume when using Bostik 9101 Curing Agent or Bostik 9105 Curing Agent. This ratio is a guideline only and individual users should experiment to determine the optimum level of crosslinker for their application.

Clean Up

Use Anchor-Weld™ 901 Cleaner/Thinner to clean up equipment and excessive adhesive.

Storage & Shelf Life

Store in a cool, dry place, out of direct sunlight and away from all sources of ignition. Storage areas must be well ventilated and comply with Local, State and Federal regulations. For maximum shelf life, store between 5° and 25°C.

Shelf life is up to 12 months when stored in original, unopened containers, under the above conditions.

Packaging

4lt can

Product Details

Item Number	Size
382760	2 x 4lt

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BOSTIK AUSTRALIA PTY LTD**

Head Office Bostik Australia Pty Ltd, 51-71 High Street, Thomastown Vic 3074
A.B.N. 79 003 893 838
Phone: (03) 9279 9333 Fax: (03) 9261 4744
Phone Industrial: Toll free 1300 560 799



Quality
ISO 9001
SAI GLOBAL
Quality endorsed ISO9001 (Thomastown site)
TS16949 (Automotive).

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