

Use Instructions for Bostik Triple 5 BSR

Laminating and General Purpose Adhesive

Stock Code ADB555N

Application:

- If the adhesive is left standing for a long period before use, mix well to disperse the pigment evenly. This enables accurate gauging of the coverage rate and evenness.
- Normal air operated spray and airless equipment gives best results, but with airless spray guns the tips and fan widths will require more experimentation to suit all applications.
- 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.
- 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 below).
- 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 activate, the surfaces must be allowed to dry before applying 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.

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 1659, 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 before using Bostik N°1 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:

- Coated too thin on highly absorbent surfaces.

Adhesive stringy when delaminating:

- Insufficient drying time, therefore bonding too soon.

Small circular un-bonded 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 workspace.

Storage:

Store in cool, dry conditions out of direct sunlight, below 25°C and away from naked flame or sources of heat.

Shelf Life:

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

Health and Safety:

Full details are on each product's respective 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:

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

- **Swallowed:** Do not induce vomiting, give 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.

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.