

166 BE BE TEX ADHESIVE

NATURAL RUBBER ADHESIVE

12 April 2017

YOUR SMART ADVANTAGES

- Water based
- High solids content
- Very fast bonding properties
- High peel strength

USES

- Leather
- Cardboard
- Wood
- Fabric
- Felt
- Some synthetics
- Shoe, handbag, other leather and decorative industries

PRODUCT CHARACTERISTICS

Colour	Milky white
Viscosity	Brushable
Composition	Natural rubber
Solids content	Approx. 60%
Usage	Interior only
Application temperature	5 to 40°C
Tack time	Approx. 5 minutes
Open time	Up to 30 minutes
Full cure	Final bond strength can take up to 7 days
Thinner	Do not thin
Coverage	4 - 8m ² /L per surface, depending on surface and application method. Absorbent surfaces may need two coats.

Product codes

20 L Plastic pail 30804163

TYPICAL PERFORMANCE DATA (APPROX)

Staining	Will not stain adjacent materials. The adhesive film is pale honey when dry
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Water resistance	Excellent, but not for continuous immersion
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Service temperature*	-20 to +50°C
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* The adhesive will deteriorate if subjected to high temperatures and/or humidity on a continuous basis.

DIRECTIONS FOR USE

Read and understand the Safety Data Sheet before using this product.

SURFACE PREPARATION

Ensure all surfaces are clean and dry.

Rubber: Roughen the surface thoroughly using a clean emery cloth and dust off.

Thermoplastic Rubber (TPR): Solvent wipe using Bostik No. 3 Solvent, change cloth often.

Metal: Remove rust or oxidation layer by sanding or sand blasting. Immediately solvent wipe using Bostik No. 3 Solvent using the wipe on, wipe off technique, changing cloths regularly. Do not leave the solvent to flash off on its own without wiping off. Bonding must be carried out as soon as possible to avoid flash rust or oxidization.

Non porous substrates: Solvent wipe using Bostik No. 3 Solvent using the wipe on, wipe off technique. Abrade smooth surfaces to improve adhesion.

Severe service conditions or difficult materials may require a primer, consult Bostik for assistance.

APPLICATION

- If you have not used a contact adhesive before we recommend that you prepare a few practice pieces first to ensure that your methodology is correct.
- Materials may vary - prepare a test piece first to ensure product and process is suitable.
- Coarse fabrics may require multiple coats of adhesive for maximum peel strength.
- Stir thoroughly with a flat-bladed paddle to disperse any settled solids before use.
- It is recommended that you decant a smaller quantity of stirred adhesive into a clean metal or glass container and work from this container. This will help avoid drying of the product in the can and extend life of opened product.
- Using a brush, apply an even film of adhesive to both surfaces to be bonded.
- Coverage should be 100% of both surfaces for best adhesion. The most common cause of poor bonding is insufficient adhesive.
- On porous surfaces several coats may be required to achieve an even film on the surface. Allow previous

coats to dry sufficiently (max 24 hours) before re-coating. Applying wet on wet adhesive will cause excessive soak-in.

- The porosity of a surface may be judged by applying a droplet of water. If the water beads the substrate is not porous, if the bead soaks in the substrate is porous.
- Allow the two films to dry for about 5 minutes, or until they can be touched with the knuckles without any cement being transferred.
- Bonding must be carried out within 30 minutes of applying the adhesive.
- Carefully align the two surfaces and join together. Take care not to trap any air and use as much pressure as possible. The recommended minimum pressure required to give a good bond is 280kPa (40psi).
- The bond is immediate, and if the pieces are misaligned they cannot be separated and re-joined. Fresh adhesive will need to be applied to both surfaces and allowed to tack off before re-bonding.
- If bonding to non-absorbent surfaces allow the adhesive to dry for a longer period. This allows more drying and reduces the chance of bubbling.
- After long open times always check the initial bond strength, to ensure that the adhesive films have fully consolidated together. If the adhesive film has lost tack due to excessive open time, recoat lightly with more adhesive.

One Way Bond (for 2 absorbent surfaces)

- Follow preparation instructions as above.
- Using a brush, apply an even film of adhesive to one surface to be bonded.
- Coverage should be 100% of both surfaces for best adhesion. The most common cause of poor bonding is insufficient adhesive.
- On porous surfaces several coats may be required to achieve an even film on the surface. Allow previous coats to dry sufficiently (max 24 hours) before re-coating. Applying wet on wet adhesive will cause excessive soak-in.
- The porosity of a surface may be judged by applying a droplet of water. If the water beads the substrate is not porous, if the bead soaks in, the substrate is porous.
- Allow the two films to dry for about 5 minutes, or until they can be touched with the knuckles without any cement being transferred.
- Bonding must be carried out within 30 minutes of applying the adhesive.
- Carefully align the two surfaces and join together. Take care not to trap any air and use as much pressure as possible. The recommended minimum pressure required to give a good bond is 280kPa (40psi).
- Keep the pressure in place until the adhesive grabs or dries completely.
- Very strong bonds can be made after a few minutes.

LIMITATIONS

- Not suitable for polyethylene, polypropylene or Teflon.
- Works best with at least one absorbent substrate. Bonds will take much longer to dry with two non-absorbent substrates.

CLEANING

Water while wet, Bostik Solvent No. 2 when dry. Use Bostik Handy Wipe towels to remove adhesive from skin.

Brushes are very difficult to clean after repeated use with Bostik 166 Be Be Tex and may have to be disposable types. The dry or coagulated rubber is not easily

removed from brushes. Soaking in Bostik No. 2 Solvent may assist. Cleaning in warm soapy water IMMEDIATELY after use may also help.

STORAGE AND SHELF LIFE

Store in cool, dry conditions out of direct sunlight below 25°C. Protect from freezing and frost. Shelf life is 12 months if stored in cool, dry conditions in original, unopened containers.

DISPOSAL

Empty containers, once dry, may be disposed of via local landfill.

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

PRECAUTIONS IN USE

Complete 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 all concerned read the appropriate Safety Data Sheets. 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. Cooking oil may aid removal. Do not scrub.

Eyes: Hold open and flood gently 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.

BOSTIK HOTLINE

Smart help 0508 222 777



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