

PAD & 1440 ADHESIVE

POLYURETHANE STRIP & SOLVENT BORNE ADHESIVE

BOSTIK PAD is an adhesive-precoated polyurethane foam strip used with BOSTIK 1440 ADHESIVE, a solvent-borne compound based on polychloroprene synthetic rubber. The adhesive is coloured red to facilitate the application of coatings of even thickness.

BOSTIK PAD and BOSTIK 1440 ADHESIVE form an excellent fixing system for securing rigid materials to uneven surfaces. The system has the advantages of:

- * providing immediate high strength bonds to a wide variety of surfaces.
- * allowing movement in the base to be accommodated so that stress is not transmitted to the bonded material.
- * excellent ageing properties.

RECOMMENDED USE

BOSTIK PAD and 1440 ADHESIVE will bond to plaster, concrete, brickwork, blockwork, wood, fibreboard, laminated plastics (e.g. Formica) metal etc. Typical applications being the bonding of:

- * TBA Duraform and Duraglas decorative reinforced thermoplastic sheets.
- * Wall panels of fibreboard, plywood and laminated plastics.
- * Ceiling tiles of fibreboard, plaster and metal.
- * Signboards and display plaques to walls.
- * Laths and battens.
- * Small fixtures e.g. electrical fittings, brackets.

PAD SELECTION

BOSTIK PAD will support a weight of approximately 4.5 kg/cm run in either direct tension or shear. To allow for inaccuracies in fixing, a 20 x safety factor is used and practical calculations should be based on a figure of 0.23 kg/cm run. BOSTIK PAD is supplied in strips, which can be cut to 40 mm lengths for fixing small areas, such as acoustic tiles.

The actual pattern of the BOSTIK PAD is determined by the flexibility of the fixture. Where rigid panels are to be bonded, it is necessary to apply only a sufficient total length of BOSTIK PAD to support the weight of the fixture. Where flexible panels are to be bonded, sufficient strips of BOSTIK PAD should be used to give rigidity in the final assembly regardless of the weight of the panel.

BOSTIK PAD is supplied in two thicknesses, 2 mm and 4 mm. In selecting the thickness, aim to use as thin a PAD as possible consistent with the surface irregularities involved. The thinner the PAD, the firmer will be the feel of the final structure.

To accommodate local large irregularities, two layers of BOSTIK PAD bonded together with BOSTIK 1440 ADHESIVE may be used.

BONDING INSTRUCTIONS

Surface Preparation

In all cases, surfaces must be clean, dry, sound and firm. Flaking paint must be removed and distemper washed off completely. Dust, oil and other contaminants, which will impair adhesion, must be removed. Smooth surfaces such as ceramic tiles, providing they are securely bonded to the wall, should be roughened. On absorbent surfaces a priming coat of BOSTIK 1440 ADHESIVE may be necessary. This

should be allowed to dry for at least 30 minutes before applying the bonding coat. Care should also be taken to keep the BOSTIK PAD surfaces dry and to prevent contamination by dirt and grease. Handling of the BOSTIK PAD should be kept to a minimum.

APPLICATION METHODS

IMPORTANT: AT ALL TIMES WHEN THIS FIXING SYSTEM IS BEING USED THE WORK AREA MUST BE ADEQUATELY VENTILATED.

Wall Lining and Ceiling Tiles (except polystyrene)

BOSTIK PAD is applied to walls and ceilings in either vertical or horizontal lines and around edges. The distance between lines should be:

Rigid sheets - not greater than 600 mm.

Flexible sheets - between 200 and 450 mm depending on actual flexibility.

Ceiling tiles - at 400 mm centres.

1. Accurately mark the final position of boards on wall or ceiling.
- 2a. Walls - apply BOSTIK 1440 ADHESIVE by brush to the wall to coincide with the final position of the BOSTIK PAD.
- 2b. Ceilings - apply bands of BOSTIK 1440 ADHESIVE to the ceiling in positions corresponding to the board peripheries and at 400mm centres across the boards.
3. Set BOSTIK PAD into the wet adhesive and allow to dry for at least 1 hour.
4. Remove protective paper from the PAD.
5. Apply an even brush coat of BOSTIK 1440 ADHESIVE to the surface of the PAD just uncovered and to corresponding positions on the back of the boards. Allow to become touch dry (between 10 and 30 minutes).
6. Fix the boards accurately into position, leaving 4 to 6mm gaps between them, and apply firm pressure along the line of the PAD to ensure complete bonding. The boards must be carefully positioned, as once contact has been made they cannot be removed.

NOTE: BOSTIK PAD must be set in sufficiently from the board edges to allow cap and skirting mouldings to be positioned or for the joints to be sealed effectively.

Acoustic Tiles

Tiles up to a maximum size of 610 x 610 mm can be fixed using 40 mm lengths of BOSTIK PAD cut from the strips. The actual number of 40 mm strips used on each tile should be determined using the information given under PAD SELECTION. Where porous tiles are used it may be necessary to apply two coats of adhesive, allowing 15 minutes drying time between coats.

Notice Boards, Display Panels etc.

Fix BOSTIK PAD around the periphery of the board or panel and also in vertical lines spaced according to the flexibility of the board or panel. Where porous boards or panels are used, it may be necessary to apply two coats of adhesive, allowing 15 minutes drying time between coats.

PRE-FIXING BOSTIK PAD

BOSTIK PAD may be pre-fixed to tiles and panels by applying a coat of adhesive and bonding the PAD immediately into the wet adhesive. If pre-fixing is carried out, at least 1 hour must elapse between this operation and the application of load to the bond. If tiles or panels with PAD fixed to them are to be stacked, then spacers must be inserted to ensure that pressure is not applied to the PAD before the bonding operation.

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ADHESIVE COVERAGE: Approximately 4m² per litre (2m² bonded area). 1 roll of BOSTIK PAD needs approximately 1 to 1 1/2 litres of adhesive.

CLEANER: Use BOSTIK M501 CLEANER/THINNER for brush cleaning and removal of excess adhesive.

APPLICATION TEMPERATURES: Ambient temperatures during use of this fixing system should be in the range 5 to 25°C.

PRECAUTIONS: In high hygiene installations it is recommended that all joints and edges are sealed with an appropriate BOSTIK BOND-FLEX SILICONE SEALANT. Consult BOSTIK LTD. for further information on the different grades available. Although the water resistance of this fixing system is generally good, it is recommended that for exterior locations the edges of fixed units are also sealed with a suitable BOSTIK BOND-FLEX SILICONE SEALANT. In cold weather extra care must be taken to ensure the PAD does not become wet as formation of ice in the PAD will break down the foam.

TYPICAL CHARACTERISTICS

Physical Form:	Mobile liquid
Colour:	Red
Odour:	Hydrocarbon
Chemical Type:	Polychloroprene rubber/resin based solution
Solids Content:	27%
Solvent:	Mixture of toluene, ethyl acetate and light petroleum spirit
Viscosity:	3.3 Pas (33 poise)
Specific Gravity:	0.9
Flammability:	Highly flammable (dried adhesive film supports combustion)
Flash Point: (Closed Cup)	In the group -18 to -7°C
Temperature Resistance:	-40 to + 70°C
Water Resistance:	Good
Petrol, Oil and Kerosene Resistance:	Fair
Solvent Resistance:	Good to alcohols but not fully resistant to esters, ketones, aromatic and chlorinated hydrocarbons which may swell and soften the bond
Chemical Resistance:	Good to mild acids and alkalis
Adhesive Bond Strength:	0.3 MPa (40 psi) in shear and direct tension immediately on making the bond, and increasing to approximately 0.4 MPa (50 psi) after 24 hours.
PAD Resistance to Movement:	13 mm in shear, 6mm in direct tension before rupture of the PAD occurs
PAD Resistance to Pressure:	The elastic nature of the PAD accommodates applied pressure. High pressure applied for long periods, however, may result in some permanent deformation.

PACKAGING

Please refer to Customer Service Department for current package sizes.

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Date: April 2005

Information Sheet No.: B0156-12

STORAGE

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

SHELF LIFE

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

MATERIAL SAFETY DATA

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

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