Bostik NE486

SOLVENT BORNE ADHESIVE

ADVANTAGE

- Excellent green strength
- High temperature resistance
- Excellent moisture resistance

Product

Bostik NE486 Adhesive is a solvent borne formulation based on polychloroprene rubber. It is used in conjunction with Bostikure D curing agent as a two part, cold curing adhesive system which has a wide range of industrial applications. It offers strong resilient bonds which exhibit good resistance to water, humidity, etc.
In particular, the cured film of Bostik NE486 Adhesive has good resistance to UV exposure, with reduced discolouration. Also this adhesive has good storage stability, this being particularly relevant where high storage temperatures are encountered, such as in overseas locations.

Recommended use

Bostik NE486 Adhesive will bond natural polychloroprene, nitile, butyl, Hypalon and polyurethane rubber surfaces, rigid PVC, wood, metal, leather, etc. It can be used as a heat resistant adhesive for decorative laminated plastics e.g. Formica, and is particularly useful in the construction of inflatable products such as boats, balloons etc.
The UK Ministry of Defence Quality Assurance and release document relating to Bostik NE486 Adhesive is AFS 1413.
IMPORTANT: It is not recommended that Bostik NE486 Adhesive be used on plasticised PVC because of the possibility of plasticiser migration.

Bonding instructions

- Ensure that the surfaces to be bonded are clean and grease free by abrading then with clean emery cloth or by using Bostik M501 Cleaner/Thinner to remove surface contamination. (For metal surfaces follow a similar procedure using a product recommended by Bostik Customer Service Department).
- Mix together thoroughly, for approximately 5 minutes, Bostik NE486 Adhesive and Bostikure D curing agent preferably in the portions as supplied or by taking (by weight) 100 parts of the adhesive and 6 parts of the curing agent.
- Apply an even coat of the mixed adhesive to both mating surfaces by brush, roller coater or serrated trowel.
- Allow the adhesive coats to dry for 5 to 20 minutes or until they can just be touched with the knuckles without the adhesive being transferred.
- **NOTE**: Two thin coats are preferable for maximum adhesion. The first coat should be allowed to dry for approximately 20 to 30 minutes before applying the final coat and allowing this to dry for 5 to 20 minutes.
- Join the surfaces, taking care not to trap any air, using as much pressure as possible. Components may be handled within minutes of being bonded. For the strongest adhesion to metal use Bostik 9252 Primer, full details of which are given in Bostik information sheet No.B67. Stir this primer thoroughly and then apply by brush an even, thin coat to the prepared metal surface. Allow the primer coat to dry for at least one hour before applying Bostik NE486 Adhesive.

PRECUATIONS MUST BE TAKEN TO ENSURE THAT BOSTIK NE486 ADHESIVE, BOSTIKURE D CURING AGENT AND THE MIXED UNCURED ADHESIVE ARE NOT CONTAMINTED WITH WATER OR WATER VAPOUR AS THIS COULD HAVE A DETRIMENTAL EFFECR ON BOND STRENGHTS.

Tack life: Approximately 20 to 30 minutes dependent on the surfaces being bonded.
Pot life: Greater than 6 hours in a closed container, but shorter in open containers due to solvent evaporation. Also the pot life decreases with age of the adhesive.
Curing time: 72 hours under normal ambient temperature conditions but the strength of the adhesive bond continues to increase, reaching its maximum within 7 days. Vure rate may be accelerated by heating e.g. 2 hours at approximately +70°C.
Coverage: Approximately 4m² per litre (2m² of bonded area) but can vary with material being bonded.
Cleaner/thinner: Please contact Bostik Customer Service Department for a product suitable for cleaning metal surfaces. Bostik M501 Cleaner/Thinner can be used for other surfaces.
Use Bostik M501 Cleaner/Thinner for adhesive dilution, removal or surplus adhesive and cleaning of application tools and equipment.

PACKAGING
Please refer to Customer Service Department for current package sizes.

STORAGE
Store in a dry, flameproof area between +5°C 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 Material Safety Data Sheet.

Typical characteristics	
Physical Form	Mobile liquid
Colour	Off white
Odour	Mainly Ketonic
Chemical type	Polychloroprene rubber/resin based solution
Solvent	Mixture of methyl ethyl ketone, light petroleum spirit, toluene and acetone
Viscosity	2.5 Pa s (25 poise) approximately
Solids Content	22% Approximately
Specific Gravity	0.9 Approximately
Flammability	Highly flammable
Flash Point	In the group -18°C to -7°C
Temperature	From -40°C to +90°C but will withstand higher temperatures for short periods
Resistance	
Water Resistance	Good
Oil, Petrol & Kerosene Resistance	Fair - Good
Solvent Resistance	Not resistant to esters, ketones, aromatic hydrocarbons which may swell and soften the bond.
Dilute Acid & Alkali	Good. Virtually unaffected by 5N sulphuric acid and 5N sodium hydroxide
Resistance:	
Humidity Resistance:	Good, after exposure to 100% RH at +38°C for 14 days.
Ageing:	Good, but exposed adhesive film can discolour in strong sunlight.

BOSTIK HOTLINE

Smart help **+ 31 (0) 73 6 244 244**
+ 32 (0) 9 255 17 17

Bostik BV
De Voerman 8
5215 MH 's-Hertogenbosch
T: + 31 (0)73 6244244
infoNL@bostik.com
www.bostik.nl

Bostik GmbH
An der Bundesstraße Nr. 16
D - 33829
Borgholzhausen
www.bostik.de

Bostik SA
253, avenue du Président
Wilson, 93211 La Plaine
Saint-Denis Cedex France
www.bostik.com

Bostik Ltd.
Common road
ST16 3EH
Stafford
www.bostik.co.uk

NL-2016/11/07