



**Bostik 2402**  
permanently bonds  
Hypalon inflatable boats.

**Rubber and Plastic Adhesives** are formulated with a range of open times, viscosity and color for a variety of application methods including brush, spray or roll coating.

**Contact Adhesives** meet a wide range of application requirements. With two different types — solvent-based and water-based — they feature long open time, high heat resistance, good initial grab and tenacious bonding to a variety of substrates. Available in spray or brush grades, these versatile cements excel at foam fabrication, bonding counter tops, veneer, decorative trim, paneling and other applications where long-lasting, reliable adhesion is required.

**Water-Based Adhesives.** In addition to organic solvent-based adhesives Bostik supplies various polymer types as aqueous systems. These are categorized as polymer and copolymer emulsion systems, rubber latex, acrylic and urethane.

## Liquid Adhesives

### Rubber and Plastic Adhesives

PRODUCT	BASE	COLOR	VISCOSITY	SOLVENT	SOLIDS
1095M	Neoprene	Tan	750 cps	Toluene	25%
4035	Nitrile rubber	Red	7,000-10,000 cps	MEK	35%
4045	Nitrile rubber	Amber	2,200 cps	Hydrocarbon	26%
4145	Nitrile rubber	Clear	12,750 cps	MEK	31%
4490	Nitrile rubber	Brown	200-450 cps	MEK	22%

### Contact Adhesives

PRODUCT	BASE	COLOR	VISCOSITY	SOLVENT	SOLIDS
1096M	Neoprene rubber	Amber	900 cps	Toluene	23-25%
1125	Neoprene rubber	Light tan	800 cps	Toluene	21%
1142M	Neoprene rubber	Amber	300 cps	Hydrocarbon	23%
1177	Neoprene rubber	Tan	1,200 cps	Toluene	23%
1515N	Compounded neoprene	Pea green	300-500 cps	Hydrocarbon	18%
1531	Compounded neoprene	Tan	180 cps	Hydrocarbon	15%

### Water-Based Adhesives

PRODUCT	BASE	COLOR	VISCOSITY	SOLVENT	SOLIDS
8160	EVA emulsion	White	6,000 cps	Water	62%
8769	Acrylic	Clear	300-800 cps	Water	65%
8900	Synthetic rubber	White	1,100-1,600 cps	Water	55-57%
20-600	Mod. natural latex	Light yellow	800-1,000 cps	Water	57-61%
20-800	Mod. natural latex	Off white	800-1,000 cps	Water	57-61%
30-395	Mod. synthetic resin	Cream	200-400 cps	Water	57%
30-395B	Mod. synthetic resin	Cream	200-400 cps	Water	57%



# Liquid Adhesives



**FOR BEST RESULTS,  
APPLY LIQUID ADHESIVES  
TO ROOM-TEMPERATURE  
SUBSTRATES.**



*Bostik liquid adhesive 4045 permanently bonds vinyl non-skid strips.*

APPLICATION	DENSITY WT./GAL.	FEATURES
Brush	7.12	Two-part system. Good adhesion to neoprene, urethane and PVC with primer only. Use as seam sealer.
Brush	7.5	Meets MIL-C-4003. Fuel resistant. Fast drying. Very flexible.
Brush, roller	7.3	High initial bond strength. Good flexibility. Fast drying.
Brush	7.3	Heavy bodied. Non-staining. Dries clear and flexible. Meets BMS 5-14 and 5-30.
Spray, brush, roller	6.9	Fast drying. Excellent adhesion to rigid plastics. Excellent heat resistance.

APPLICATION	DENSITY WT./GAL.	FEATURES
Brush, roller	7.3	High green strength & heat resistance. Heat reactivatable. Bonds a wide range of substrates.
Brush	7.3	Meets MIL-A-5540. Polychloroprene under classes 1, 2, 3, 4 and 5.
Spray, brush, roller	6.9	Meets MMM-A-121. Excellent heat and water resistance. Bonds to wide range of substrates. Flexible application methods.
Brush, roller	7.3	High strength, good tack. Good to excellent resistance to heat, moisture and aging.
Brush, roller	6.8	Excellent general purpose adhesive. Excellent heat and humidity resistance. High initial and ultimate strength.
Spray	6.8	Excellent heat, humidity and static stress resistance. High initial strength. Long "open tack".

APPLICATION	DENSITY WT./GAL.	FEATURES
Brush, roll coated	9.19	Contact adhesive for polyethylene foam, rubber foam, urethane foam to themselves or to rigid surfaces.
Spray, roller, brush	8.7	Pressure sensitive adhesive. Aggressive tack. Good green strength. Good shear strength.
Brush, bar coater	8.9	Adheres to wide variety of surfaces such as PVC, saran, polystyrene, paper, wood, cotton cloth and others.
Spray	9.2-10.0	Foam combining contact adhesive. One-component, fast tack, good heat resistance. Bonds foam to foam, fabric and wood.
Spray	9.3-10.0	Foam combining contact adhesive. Lower cost version of 20-600. Faster tack.
Spray	9.8-11.5	Foam combining contact adhesive. Two-component. Bonds foam to foam, fabric and wood. Aggressive grab, good heat resistance, quicker set.
Spray	9.8-11.5	Foam combining contact adhesive. Modified version of 30-395. Faster grab or green strength.





*Bostik 7432 Cyanoacrylate is ideal for bonding rubber or plastic.*



**B**ostik Cyanoacrylate and Epoxy Adhesives are the choice for forming permanent bonds to a variety of substrates, including high-performance engineered materials. Available in one- or two-part systems, these products offer the user a range of cure times and performance characteristics for a variety of critical applications.

**Cyanoacrylate Adhesives** are available in "general purpose" and "high performance" formulations. These single-component adhesives offer set times from "instant" to four minutes. Solvent-free cyanoacrylate adhesives yield strong, durable bonds in metal, plastics, rubber, ceramics and glass applications.

## CYANOACRYLATES Mil Spec Summary

Meets Mil Spec A-46050-C Type II

- Class 1 - 7430, 7431
- Class 2 - 7432, 7433, 7532, 7533
- Class 3 - 7434, 7435
- Class 4 - 7535

**Epoxy Adhesives** are typically used for the excellent temperature and chemical resistance and bond strength. Bostik 7500 Series two-part epoxy adhesives have both structural and potting capabilities and offer a range of properties for a variety of applications. They work in one-to-one mix ratios to form structural bonds in wood, plastics, ceramics, masonry, rubber and much more.

**Bostik 7500 Epoxy Applicator Gun** eliminates measuring and mixing. Designed for use with the Bostik 2 oz. dual-barrel syringe. With the squeeze of a trigger, resin and hardener are precisely metered out, pre-mixed and dispensed with virtual "pinpoint" accuracy.

## BOSTIK ENGINEERING ADHESIVES ARE THE PERMANENT BONDING SOLUTION FOR:

- Rubber O-rings
- Plastic to metal
- Fiber name plates
- Ceramic pottery
- Soft wood and cork
- Potting electronic circuitry
- Golf club head-to-shaft assembly
- Open-cell foam to rigid vinyl



# Engineering Adhesives



**DID YOU KNOW STORING  
CYANOACRYLATES IN A  
REFRIGERATOR EXTENDS  
THE SHELF LIFE?**



*Bostik cyanoacrylates are especially suited for "pinpoint" application of adhesive in hard-to-reach areas.*



*Bostik epoxy adhesives are formulated for permanent bonding where performance and reliability are critical.*

## Engineering Adhesives

### General Performance Cyanoacrylates

PRODUCT	DESIGNATION	VISCOSITY	CURE* TIME	GAP FILL	TEMP. RANGE	TENSILE PSI	IMPACT FT.LBS./IN.	TYPICAL APPLICATIONS
7430	General Purpose Fast Cure	40-50 cps	2-3 sec.	.004"	-100°F to 180°F	4,700	7-10	For bonding metal to dissimilar substrates.
7431	Penetrating Instant Cure	2-5 cps	1-2 sec.	.002"	-100°F to 180°F	4,000	3-5	For bonding parts after positioning or adjusting.
7432	Rubber and Plastic	90-110 cps	3-5 sec.	.005"	-100°F to 180°F	4,000	3-5	For O-rings, rubber to metal and most plastics.
7433	Wood and Fiber Med-Long Cure	275-325 cps	7-10 sec.	.006"	-100°F to 180°F	4,000	4-6	For hardwood, fiber name plates, paper.
7434	Porous Surfaces Long Cure	1,400- 1,600 cps	10-25 sec.	.010"	-100°F to 180°F	4,000	4-6	For ceramics, pottery, name plates, paper, open cell foam, leather.
7435	Maximum Gap Fill	2,300- 2,700 cps	25-45 sec.	.020"	-100°F to 180°F	4,000	4-6	Allows for part alignment, uneven surfaces, very porous parts.

### High Performance Cyanoacrylates

PRODUCT	DESIGNATION	VISCOSITY	CURE* TIME	GAP FILL	TEMP. RANGE	TENSILE PSI	IMPACT FT.LBS./IN.	TYPICAL APPLICATIONS
7530	Plastics and Performance	2-5 cps	2-3 sec.	.004"	-114°F to 200°F	4,400	4-8	Maximum strength for bonding plastics and elastomers, nylon, PVC, ABS.
7531	High Clarity	100-200 cps	3-5 sec.	.006"	-65°F to 175°F	3,000	3-5	High clarity, low vapor, low odor, excellent moisture resistance.
7532	Critical Surfaces	90-110 cps	3-5 sec.	.006"	-114°F to 180°F	4,000	3-5	For acidic and contaminated surfaces, soft wood, cork, cardboard, plastic.
7533	High Temperature	90-110 cps	3-5 sec.	.006"	-114°F to 300°F	3,500	10-15	For temp. to 300°F constant, 400°F intermittent. For automotive, electronic and industrial applications.
7534	High Peel	400-800 cps	8-15 sec.	.012"	-114°F to 212°F	2,900	5-10	For bonding dissimilar materials. High peel strength, excellent elongation.
7535	Severe Service	4,800- 5,200	2-4 min.	.025"	-114°F to 260°F	3,200	20-25	Good impact, peel, high temperature and gap filling properties. For porous surfaces.

\*Cure time is related to bond thickness. These values are typical but are dependent on bond line. Note: All Bostik cyanoacrylates are non-corrosive to copper.

### Epoxies

PRODUCT	DESIGNATION	POT LIFE (per 2 oz.)	CURE TIME	HARDNESS (Shore D)	SHEAR. PSI	IMPACT, IZOD FT.LBS./IN.	TEMP. RANGE	MIXED VISCOSITY @ 68°F
7522 Clear	High Performance	90 mins.	48-72 hrs.	75	2,800	1.0	-60°F to 210°F	10,000 cps
7538 Green	General Purpose	30 mins.	24 hrs.	80	3,000	0.5	-60°F to 210°F	50,000 cps
7575 Grey/Clear	5-Minute Curing	5-7 mins.	1 hr.	75	2,800	1.0	-60°F to 185°F	14,000 cps