

# BOSTIK

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Information Sheet No. B654/3  
(supersedes Sheet No. B654/2)

## 6035 ADHESIVE

### DESCRIPTION

BOSTIK 6035 ADHESIVE is a free flowing, solvent-borne formulation based on polychloroprene rubber.

### MATERIALS BONDED/APPLICATIONS

BOSTIK 6035 ADHESIVE is used in the manufacture and repair of footwear for bonding leather or fabric uppers to leather, resin rubber, microcellular and some composition rubber outsoles.

### BONDING INSTRUCTIONS

Usually the surfaces to be bonded should first be roughened.

Apply BOSTIK 6035 ADHESIVE to the prepared surfaces either by hand brushing or by use of a suitable machine. Allow the adhesive to dry.

Heat one of the adhesive coated surfaces to approximately 80°C and then unite it with the other mating surface and apply pressure. Using this heat activated bonding technique adhesive coated uppers can be left for a maximum of 3 days and adhesive coated soles a maximum of 21 days before bonding is carried out.

Alternatively bonds can be made by pressure alone in which case the time between adhesive application and bonding should be between 20 minutes and 3 hours at normal room temperatures.

CLEANER: Use BOSTIK M501 CLEANER/THINNER for cleaning application equipment.

### TYPICAL ADHESIVE CHARACTERISTICS

Physical Form:	Semi-viscous liquid
Colour:	Cream
Odour:	"Sweet"
Chemical Type:	Polychloroprene rubber/resin based solution
Solvent:	Mixture of light petroleum spirit, methyl ethyl ketone and toluene
Viscosity:	5 Pa s (50 poise) approximately
Solids Content:	26% approximately

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Every endeavour has been made to ensure that the information given herein is true and reliable but it is given only for the guidance of our customers. The Company cannot accept any responsibility for loss or damage that may result from the use of the information, due to the possibility of variations of processing or working conditions and of workmanship outside our control. Users are advised to confirm the suitability of this product by their own tests.

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**BOSTIK**

Specific Gravity:	0.9 approximately
Flammability:	Highly flammable
Flash Point: (closed cup)	In the group -18 to -7°C

#### PACKAGING

Please refer to Customer Service Department for details of current pack sizes.

#### SUBSTANCE IDENTIFICATION NUMBER

UN 1133 (Packing Group 2).

#### STORAGE & TRANSPORTATION

Store in a dry flameproof area between 5 and 25°C.  
Subject to The Petroleum (Mixtures) Order 1929.

#### SHELF LIFE

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

#### MATERIAL SAFETY DATA

Hazardous		<u>Wt. %</u>
Ingredients:	Light petroleum spirit*	More than 25
	Methyl ethyl ketone	More than 25
	Toluene	11 to 25

\*Suppliers recommended TLV: 400ppm,  
n-hexane content approx. 3%

Boiling Point: (range)	63 to 110°C
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Auto-ignition Temperature:	Greater than 200°C
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Flammable Limits: (by volume)	LEL approx. 0.6% UEL approx. 11.5%
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Volatiles: (by weight)	Approx. 74%
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Solubility in Water:	Slightly miscible
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Material Stability:	Stable in unopened containers at recommended storage temperatures
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For detailed safety and handling advice refer to BASA booklet "SAFE HANDLING OF ADHESIVES AND SEALANTS IN INDUSTRY" with particular reference to the section headed "Solvent-borne adhesives, sealants, primers, thinners and cleaners".