



L7132K

TWO PART SOLVENT BASED THERMOSET ADHESIVE KIT

KEY FEATURES

- Vacuum/pressure bonding
- Low surface energy adhesion
- Meets BMS 5-127G Type III Class 2 & 3 product specification for the aerospace industry

DESCRIPTION

Bostik's L7132K is a kit containing L7132R and Boscodur 24T as a two component adhesive system specifically designed for use in the vacuum form bonding of PVC films to wood, fiberboards, and most porous substrates. Characterized by its high green strength, the system permits for edge trimming immediately after removal from the vacuum former.

In addition to securing strong, resilient anchorage to PVC, L7132R displays inherently high adhesion to polyolefin foams, polyester films, most plastic laminating films, foils, sheet metal surfaces, and to cellulose in general. Boscodur 24T is used to ensure the development of heat and creep resistant bonds.

BENEFITS

- Wide processing window that allows for use in a variety of application processes
- Excellent adhesion to vinyl, particle board, polyolefin foams, and plastics
- Cures to a tough, highly heat resistant film

BASIC USES

- Aerospace applications to laminate decorative films to aluminum or honeycomb sidewalls in the construction of cabin interiors
- Automotive applications to vacuum form PVC film and polyolefin foam to rigid substrates in the manufacturing of door panels, consoles, dashboards, and other interior trim
- Vacuum forming PVC films to particle boards in the production of decorative furniture facings
- Vacuum form construction of PVC coated luggage shells



DECORATIVE LAMINATE BONDING

CONTACT ADHESIVE

TYPICAL PHYSICAL PROPERTIES

Description	L7132R	Boscodur 24T
Appearance	Opaque Liquid	Dark Brown Liquid
Base	Linear Saturated Polyester	Polyisocyanate
Solvent System	MEK blend	MEK
% Total Solids	25.5%	68%
Density @ 25°C	7.67 lb/gal (0.919 g/cm ³)	8.76 lb/gal (1.05 g/cm ³)
Viscosity (Brookfield)	100 cP	Thin Liquid
Flash Point (SCC)	14°F (-10°C)	29°F (-2°C)
Mixing Ratio	16 volumes	1 volume

DIRECTIONS FOR USE

Adhesive can be applied via direct roll, reverse roll, gravure, or any coater common to the industry. This adhesive can also be sprayed.

Boscodur 24T should be added to L7132R in accordance with the mixing ratio specified above and blended to a homogenous solution (solvent dilutions, where applicable, should be made immediately after the Boscodur 24T addition). Apply 100-150 g/m² (wet) adhesive to the least porous laminating surface and evaporate the solvent by standard drying techniques. Mate the secondary substrate under pressure at 110-212°F (41-100°C).

To cure the part, the adhesive should be held at a minimum of 190°F (88°C) for at least 4 minutes. Vacuum pressure should be held at a minimum of 15 in Hg (51 kPa), 20 in HG (68 kPa) is preferred.

PACKAGING

L7132K is available in one gallon kits. Each kit contains a gallon can of L7132R and a half pint can of Boscodur 24T.

SHELF LIFE

The shelf life of L7132K is nine months when stored at 55-80°F (15-27°C) in unopened factory sealed containers. Once the two-part system is blended, it has a pot life of eight hours.

STORAGE AND HANDLING

Boscodur 24T should be stored in a sealed container. Once opened it should be nitrogen purged to prevent contamination from moisture in the air. L7132R has a shelf life of at least 6 months if stored in an unopened container. Recommended clean up is with a MEK/toluene solution. Do not freeze.

HEALTH AND SAFETY PRECAUTIONS

L7132K is an extremely flammable system. Before using, extinguish all flames and pilot lights. Use only in well ventilated areas. During application and until vapors are gone, keep product away from heat, sparks, and flame. Avoid using spark-producing equipment such as switches, tools, appliances, etc. Keep container tightly closed when not in use.

Refer to the product SDS for complete details.

LIMITED WARRANTY

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