



Technical Data Sheet

7132R

Boscodur 4

Product Description

Bostik 7132R/Boscodur 4 is 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.

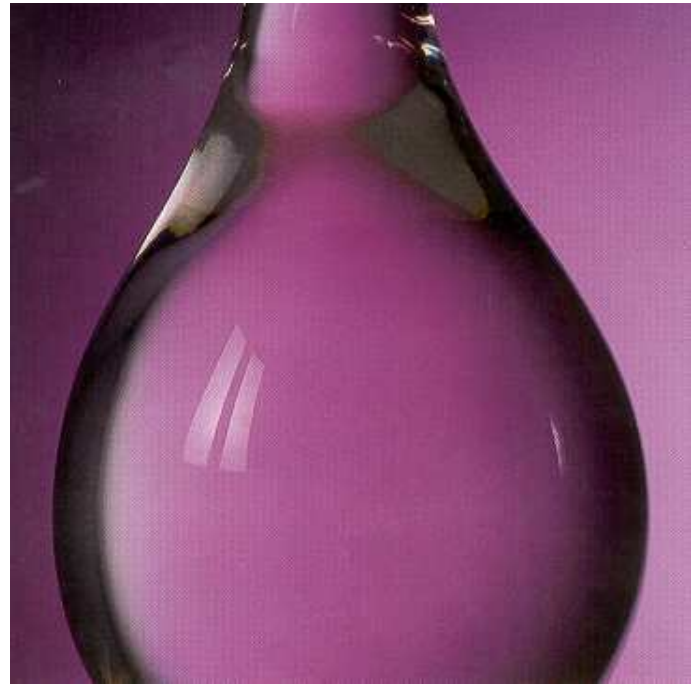
In addition to securing strong, resilient anchorage to PVC, Bostik 7132R displays inherently high adhesion to polyolefin foams, polyester films, most plastic laminating films, foils, sheet metal surfaces, and to cellulose in general. Boscodur 4 is used to ensure the development of heat and creep resistant bonds.

Product Benefits

- Wide processing window that allows for its use in many customers' varying processes
- Excellent adhesion to vinyl, particle board, polyolefin foams, and plastics
- Cures to a tough, highly heat resistant film.
- Excellent edge folding capability.

Product Applications

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



Typical Physical Properties (not for specification use)

	Part A (Bostik 7132R)	Part B (Boscodur 4)
Appearance:	amber liquid	brown liquid
Base:	linear saturated polyester	polyisocyanate
% Total Solids:	25.5	68
Viscosity, cps: (Brookfield LVF#1/60/25°C)	100	thin liquid
Density, lbs./gal.:	7.67	8.76
Flash Point (SCC):	14°F (-10°C)	29°F (-2°C)
Solvent System:	MEK blend	MEK
Mixing Ratio:	20-24 volumes	1 volume

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Directions for Use

Spray Application

Mix part A and B in accordance with specified blend ratios. Apply via direct roll, gravure, spray (Devilbuss, Graco) to the least porous surface. Make sure all surfaces are clean and dry. Apply 100-150 gr/M² wet adhesive and dry at 80°C for one minute (until dry). Then vacuum laminate at 110-210°F for approx. 20 seconds or more to obtain bond. Immediate strong bonds are made however full cure may take up to 72 hours or 1 week to be formed.

Lamination Application

Equipment: direct roll, reverse roll, gravure, or any coater common to the industry. This adhesive can also be sprayed via Graco, Devilbuss, Binks, or similar units.

Method: Add Part B to Part A in accordance with the mixing ratio specified above and blend to a homogenous solution (solvent dilutions, where applicable, should be made immediately after the Part B addition). Apply sufficient wet adhesive to deposit 2 to 4 pounds/ream to the least porous laminating surface and evaporate the solvent by standard drying techniques. Lamination is effected by pressure at 110-212°F (41-100°C).

Storage and Handling

Pot Life:	8 hrs.
Shelf Life:	6 months at 55-80°F (15-27°C)
Cleanup:	MEK, toluene

Boscodur 4 should be stored in a sealed container. Once opened it should be nitrogen purged to prevent contamination from moisture in the air.

Extremely flammable! 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. Material Safety Data Sheets on these and all Bostik products are readily available upon request.

Further Information

Please refer to MSDS for complete details.

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