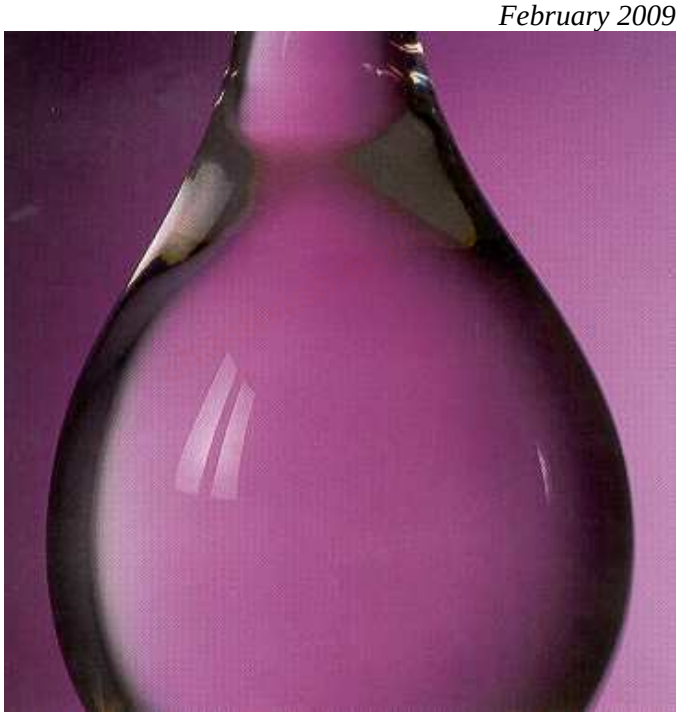
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Technical Data Sheet

1685MC

Liquid Adhesives



Product Description

Bostik adhesive 1685MC is a chloroprene rubber solvent based adhesive that shows excellent bonding characteristics when bonding polyurethane foam and abrasive grit, rubber to metal, wood to itself, leather and many other materials. It has been used to bond cellulose sponge to metal in the manufacturing of mops. It provides excellent adhesions of cured and uncured Neoprene® and butyl membranes to concrete, wood and metal.

Superior adhesion to metal can be obtained by priming with Bostik Adhesive Primer 1007M (see separate data sheet on Bostik Adhesive Primer 1007M).

Properties of 1685M in Container

Type:	Chloroprene rubber solvent based adhesive
Viscosity:	5,500-6,000 cps
(12 RPM Brookfield LVF Spindle #3 @ 25°C)	
Solids:	29-31%
Color:	Tan
Odor:	Aromatic
Flash Point (closed cup):	-8
Cleaner:	Toluene
Specific Gravity:	0.91
Shelf Life:	Stable at least 9 months when tightly closed containers are stored in a dry and cool place.
Coverage:	30 - 40 sq. ft. per liter depending on substrates

Properties of Dried Adhesive Film

Color:	Yellow-translucent
Odor:	Odorless
Flammability:	Burns very slowly
General:	Flexible film with good resistance to hot or cold water detergents.
Weathering:	Excellent
Chemical Resistance:	Excellent to cold and boiling water, detergents and aliphatic oils.

Directions for Use

Read MSDS Before Use.

Surfaces to be bonded should be clean, dry and free from grease, oil or other lubricants. Roughing of metal or smooth surfaces with a wire brush or sandpaper is recommended. Clean with toluene or MEK after roughing.

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Adhesive Application & Assembly Methods

Bostik Adhesive 1685MC may be applied by brush, paint roller or notched trowel.

1. One-Way Wet Stick Method

This method should be used only when both substrates are porous or when one of the substrates is porous and is not attacked by the solvents of the adhesive.

Apply 1685MC onto the substrates with either paintbrush, roller or notched trowel. Place the other substrate on top either immediately or within 10 minutes and apply appropriate pressure.

2. Two Way Dry Stick Method

This method should be used when both substrates are nonporous or when the best possible bond is desired. Apply adhesive on both surfaces wait for a period between 15 - 60 minutes. (This depends on temperature, humidity and amount of adhesive applied.) Bring the two surfaces together and apply sufficient pressure to intimately coalesce the adhesive films.

3. Two-Way Activation Method

This is the most flexible and the best method of all.

Apply Bostik 1685MC on both surfaces and let the adhesive dry from 1 hour and up to one week. At the time of bonding solvent activate one or both surfaces with Xylene or toluene and bond the substrates either immediately or within 5 minutes.

In cases where the above methods are found to be impractical such as in bonding Neoprene vapor membranes to concrete roofs. A less ideal method but still satisfactory is the following.

Before adhesive application it must be ascertained that new concrete has been cured for at least 30 days.

Apply Bostik 1685MC with a V notched trowel having the following or similar dimensions:

Distance between V notches: 6mm
Height of notch: 2 mm
Width of notch: 2 mm

Spread Bostik 1685MC with the above trowel onto large section of the concrete roof. (Usually the width of the neoprene membrane.)

Bostik 1685MC when applied on to the concrete roof with the trowel will immediately flow out to cover the distance between notches, thus creating a uniform and homogenous film.

Where the Neoprene membrane is to be bonded to asphalt coated polyurethane foam use the same bonding method as for concrete roofs. The only difference being the solvent activator, instead of Xylene use Methyl Ethyl Ketone.

Precautionary Data

This product is extremely flammable. Vapors may cause flash fires. Keep away from fires, sparks are sources of heat. Extinguish all flames and pilot lights, turn off electric motors, stoves or heaters, or any source of ignition during use and until all vapors have been dispersed. Do not smoke. Close containers after use. Wait until the adhesive film dries, usually it takes between 1 to 2 hours. This will depend on atmospheric conditions of temperature and humidity. The bonding process can commence either as soon as the adhesive film has dried or at any time up to 24 hours. Once the adhesive film has thoroughly dried, operators or the assemblers who install the membrane can step onto the dried film if they find it necessary to facilitate the operation.

Place the roll of Neoprene membrane at one end of the structure and before unwinding the roll, refresh the surface of the dried adhesive film with Xylene. This can be done by dipping a large paint rush or a push broom into Xylene and pass it over the dried adhesive film. Immediately after or within 5 minutes start to unwind the Neoprene membrane roll onto the solvent activated area while applying pressure with a heavy metal or rubber roller. Solvent activates sufficient area at one time that can be bonded within 5 minutes. Repeat this operation until the entire roof is covered with the membrane.

Further Information

Please refer to MSDS for complete details.

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