



technical data sheet

BOSTIK 4719

Laminating Adhesive

DESCRIPTION

Bostik 4719 is a water based adhesive designed for bonding a variety of plastic films to porous substrates. The principal use is in laminating PVC sheet and similar products to timber, hardboard, compressed fibreboard and gypsum plaster board.

RECOMMENDED USES

- Lamination of PVC foil to various board stock.

FEATURES & BENEFITS

- Single component
- Non-flammable
- Fast grab
- Strong adhesion
- Long open time
- Medium se speed

PERFORMANCE PROPERTIES

TEST	RESULT
Appearance	Viscous white liquid
Viscosity	Approx. 15,000cps
Solids Content	Approx. 62%
Specific Gravity	Approx. 1.08

PACKAGING

1000lt Shutz tanks

COVERAGE

9 to 14 m² per litre

APPLICATION INSTRUCTIONS

Surface Preparation:

Surfaces to be bonded must be clean, dry and free from dust, oil, grease, etc.

Application

- May be applied by various roller coating methods or brush applied. Abrading smooth, non-porous surfaces prior to bonding will improve the bond strength.
- Coat adhesive to one substrate at a rate that gives satisfactory adhesion. The amount required will depend on the types of substrates being used and their porosity. One substrate must be porous to allow moisture to diffuse from the bond line.

- Mate the surfaces together before the adhesive is dry and ensure that the laminate is adequately nip rolled or contacted with sufficient pressure to maximise the wetting of both surfaces.
- The dry time will depend on the amount of adhesive applied, porosity and moisture content of the substrates and drying conditions available (ie. temperature, humidity & air movement). Rapid drying is best achieved when one or both of the substrates are preheated or heated after bonding. Avoid movement in the bond line while the adhesive is setting, as the bond may be weakened.

CLEAN UP

Wet adhesive: Wash any equipment, clothing or skin with warm soapy water before adhesive is dry.

Dry adhesive: Once dry, the adhesive may be removed using hot soapy water or solvent & scrubbing. Suitable solvents include mineral turpentine, xylene, toluene, MEK or other solvents that soften the polymer. Avoid breathing solvent and beware of fire danger when using flammable solvents.

STORAGE & HANDLING

12 months shelf life when stored between 5°C - 30°C. Do not allow product to freeze. Ensure containers are well sealed when not in use.

To prevent the adhesive from skinning during use, ensure open troughs or holding reservoirs where there is little circulation are covered.

Avoid prolonged contact with mild steel, brass, copper, and galvanised steel as corrosion and destabilisation of the adhesive can occur.

SAFETY & ENVIRONMENT

Use in a well ventilated area. Wear protective gloves, glasses and clothing to prevent undue contact with skin. **Refer to Material Safety Data Sheet before using.**

Wet adhesive and washings are poisonous to the environment. Do not dispose of wet adhesive or washing water via storm water drains. Discuss with EPA and local sewerage provider of best method of disposal.

Item No	Stock Size
367745	1000 Kg

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