

DUROSHEET BFM



DESCRIPTION

Durosheets BFM is a premium quality, high solids, sprayable contact adhesive, featuring high heat resistance, good sprayability, early green strength coupled with a good working tack life.

Durosheets BFM gives strong adhesion to a wide range of materials including decorative plastic laminates timber and timber composites, many natural and synthetic rubbers, cementitious composites, ferrous and non ferrous metals and polyurethane foam.

Specifically designed for easy spraying without cob webbing, especially where automatic spraying equipment is employed, Durosheets BFM is suitable for use with all current post forming equipment designed for use with contact cements. (heated bar or infra red bank heaters).

Durosheets BFM is also used in boat and automotive interior applications where laminating or upholstery trimming work is required.

FEATURES & BENEFITS

- n-hexane solvent safe
- Quick drying
- High heat resistance (100°C)
- High early green strength

COVERAGE

Up to 10m² per litre on one surface.

TECHNICAL DATA

Type	Polychloroprene rubber/resin
Colour	2700 – Red 2701 – Clear
Open Time	Approx. 30 mins @ 20°C
Water Resistance	Good but not for continuous immersion
Solids Content	Approx. 18%
Viscosity	10-15 mins @ 20°C
Solvent Resistance	Good to oil and petrol but will not withstand immersion.
Service Temperature Range	-40°C to +100°C These figures are quoted for guidance only. The suitability for your requirements should first be checked.
Combustibility of dry film	Does not support combustions

APPLICATION

Ensure adequate Tests are conducted before using commercially.

MIX THOROUGHLY BEFORE USE.



SURFACE PREPARATION

Surfaces must be clean, dry and free from oil, dust and other foreign materials.

Clean unpainted metals and rubbers with Cleaner/Thinner before applying adhesive.

Rubbers should be primed with Durotech Primer before applying adhesive.

Clean painted and plastic surfaces with isopropanol before applying adhesive.

Polypropylene surfaces MUST be primed using Durotech Primer before applying adhesive.

APPLICATION INSTRUCTIONS

Durosheets BFM is designed for application by spray using suction feed or pressure pot equipment. Apply an even coating of adhesive to both surfaces, covering at least 80% on each surface. Edges to be post-formed MUST have 100% coverage. Highly porous or absorbent surfaces may require two coats.

Allow the first coat to tack off before applying the next. Allow the adhesive to dry for approximately 10-15 minutes (depending on atmospheric conditions) or until the surface can be touched without any adhesive transfer.

Align surfaces then join by applying even and firm pressure, avoiding air entrapment. For large flat areas the use of nip or hand rollers are recommended.

A minimum pressure of 280kPa (40psi) is required to give optimum bond strength. Hand pressure is not sufficient! Bonding of materials should occur within 20 minutes of adhesive application for optimum bond strength – if left longer, a light spray coat to both surfaces should be re-applied to reactivate the adhesive.

HEADLINERS:

To successfully laminate a new fabric to a headliner, using Durotech Adhesive, several factors MUST be attended to:

1. Sufficient adhesive must be applied to BOTH surfaces. In general, this means a minimum of 80% coverage on both the fabric and the headliner. In deep drawn areas, such as hand holds, sunvisors etc., a heavier coating (100%) is required at least on the headliner side.

2. The adhesive should be applied in several coats to avoid excessive soak into the fabric which will result in 'dimpling' of the fabric and a starved glue line (resulting in a poor bond). Allow the adhesive to dry for at least 10 minutes between coats and before assembly.

3. Durotech Adhesive requires pressure to make a strong bond. HAND PRESSURE IS NOT SUFFICIENT! A minimum combining pressure of 40psi (276kPa) is required. This is best achieved using a press - not practical for the re-trim market. A good alternative is a hand roller as used by the cabinet making industry.

4. It is VERY important not to introduce any stretch into the fabric during assembly. ie. DO NOT stretch the fabric over the headliner then press it down.

5. The fabric should be laid onto the shell starting from the centre, and gently laying it out. The fabric should be hand laid into deep drawn areas WITHOUT stretching it. Sufficient pressure should then be applied as in point 3, paying particular attention to deep drawn areas. A good technique is as follows:

- a. Fold the fabric in half, length wise, adhesive side out.
- b. With a person holding each end, lower the fabric until it touches the centre line of the headliner.
- c. Slowly lower the fabric onto the shell, ensuring that it is not stretched and smoothing it into place as you go.
- d. Gently feed the fabric into any deep drawn areas so as to minimise fabric stretch. DO NOT bridge over areas such as hand holds and push the fabric into them. This will result in failure!
- e. Once the fabric is fully laid over and into the headliner, apply pressure via a press or hand roller to ensure good contact.
- f. Allow the adhesive to cure for at least seven days before exposing to elevated temperatures.

LIMITATIONS

- Do not use on copper or highly reactive metals
- Do not use on expanded polystyrene foam
- Not suitable for polyethylene or polypropylene plastic
- Unsuitable for unbacked PVC, Leather or Vinyl's. May cause staining on light coloured PVC/Vinyl stocks.
- Do not use Anchor Weld 2700 (red) to bond leather, vinyl or fabric. The red colour of the adhesive may bleed into the substrate.

CLEANUP

Use Durotech Cleaner/Thinner to clean up equipment and excessive adhesive.

STORAGE & SHELF LIFE

Store in a cool, dry place, out of direct sunlight and away from all sources of ignition. Storage areas must be well ventilated and comply with Local, State and Federal regulations. For maximum shelf life, store between 5° and 20°C. Shelf life is up to 12 months when stored in original, unopened containers, under the above

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