



UNIGRIP 999 HR

HEAT RESISTANT HIGH STRENGTH PVC ADHESIVE

7 May 2014

YOUR SMART ADVANTAGES

- Outstanding heat resistance
- High strength
- Excellent creep resistance
- Very good plasticizer resistance
- Low staining
- Excellent UV resistance
- Good brushability
- Use as 1 part or 2 part depending on performance requirements

USES

- Common shoe industry materials
- PVC inflatable boats*
- PVC truck sidings
- PVC inflatable goods
- PVC bonding where high moisture resistance is required*

PRODUCT CHARACTERISTICS

Colour	Clear
Viscosity	Brushable liquid
Composition	1 or 2 part contact adhesive
Application temperature	5 to 30°C
Product codes	
1L metal can/4 per carton	30605147
4L metal can/2 per carton	30605144
20L metal can	30804166
Desmodur RFE 50mL bottle	30604139
Desmodur RFE 750g bottle	30804298

TYPICAL PERFORMANCE DATA (approx.)

180° Peel test	Greater than 10Kg/25mm
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* 2 Part adhesive system required

DIRECTIONS FOR USE

Read and understand the Material Safety Data Sheet before using this product.
Bostik Unigrip 999 HR has proven to give adhesion to a wide variety of substrates, sometimes with the use of a primer. The information herein is given as a guide. Always carry out testing to ensure suitability of the product and process for the given application.

SURFACE PREPARATION

All surfaces to be bonded must be clean, dry and free of contamination.

LEATHER: Roughen to remove as much of the grain layer as possible. No primer required.

MICROCELLULAR EVA: Roughen or split if there is a surface skin. Apply EVA/6 Primer following instructions on primer Technical Data Sheet.

CREPE RUBBER: As received or wipe with Bostik No.3 Solvent. Apply Boscosol S Primer following instructions on the primer Technical Data Sheet.

OTHER RUBBER: Roughen the surface. Apply Boscosol S Primer following instructions on the primer Technical Data Sheet.

POLYURETHANE: Roughen the surface or double wipe with Bostik No.4 Solvent, waiting 10 minutes between wipes.

Change the cloth regularly. If improved adhesion is required apply Boscosol S Primer following instructions on the primer Technical Data Sheet.

POLYURETHANE COATED FABRIC: Remove the polyurethane coating using a soft wire or nylon brush ensuring that the roughened area lies just within the feather edge. No primer required.

PVC AND PVC/RUBBER BLENDS: Roughen the surface if possible, otherwise carefully wipe the lasted margin with Bostik No.4 Solvent, taking care to remove any lacquer on the PVC surface. Change cloth regularly. No primer required.

RESIN AND MICROCELL RUBBERS: Roughen the surface. Apply Boscosol S Primer following instructions on the primer Technical Data Sheet.

THERMOPLASTIC RUBBER: Wipe with Bostik No.3 Solvent. Change cloth regularly. Apply Boscosol S Primer following instructions on the primer Technical Data Sheet.

APPLICATION

1 PART ADHESIVE FOR SHOE INDUSTRY AND GENERAL ADHESION

- Stir well before use.
- Apply an even film of the adhesive to both surfaces by brush or roller-coater. On leather it may be necessary to apply two coats if the leather has an open structure. Allow the first coat to dry for at least 45 minutes before applying the second coat.
- Allow the films to dry for about 5 to 20 minutes, or until they can be touched with the knuckles without any adhesive being transferred. If the adhesive is left too long and a skin is formed, it must then be heat activated.
- Join the surfaces, taking care not to trap any air and using as much pressure as possible.
- The product may be heat activated to affect a bond. The maximum open time for heat re-activation is 7 days. For leather a minimum temperature of 90°C is required, which may mean a double period of

BOSTIK UNIGRIP 999 HR

APPLICATION (Continued)

activation if a flash activator is being used.

2 PART ADHESIVE FOR PVC BOAT, PVC SIDINGS AND HIGH PERFORMANCE APPLICATIONS

- When Unigrip 999 HR is used with Desmodur RFE it provides greatly increased adhesion and heat and water resistance.
- Stir well before use.
- Mix only enough adhesive as can be used within a couple of hours. Pot life is affected by temperature and will vary according to local conditions.
- Mix 100 parts by weight Unigrip 999 HR with 8 parts by weight Desmodur RFE (Roughly 70ml Desmodur RFE to 1 Litre Unigrip 999HR).
- Mix thoroughly to form a uniform solution. Avoid excessive air entrapment.
- Apply an even film of the adhesive to both surfaces by brush or roller-coater.
- Allow the films to dry for about 5 to 20 minutes, or until they can be touched with the knuckles without any adhesive being transferred. If the adhesive is left too long and a skin is formed, it must then be heat activated.
- Join the surfaces, taking care not to trap any air and using as much pressure as possible.
- The product may be heat activated to affect a bond. The maximum open time for heat re-activation is 7 days.
- As the product nears the end of its pot life the viscosity increases rapidly and will become difficult to apply. Discard unused product at this stage.

LIMITATIONS

- Bostik Unigrip 999 HR must be used with Desmodur RFE for PVC pleasure crafts. Routine inspection must be carried out and repairs effected as soon signs of delamination are noticed.
- Pot life is governed by a number of factors and will vary from day to day. Once the viscosity increases rapidly and it becomes difficult to apply, discard unused product. Do not thin mixed product which has thickened.
- Two coats may be required on absorbent surfaces. Allow the first coat to dry for a minimum of 45 minutes before applying the second coat.
- When preparing surfaces by solvent cleaning, it is essential to change the cloths frequently to avoid re-depositing silicone or plasticizer on the cleaned areas.
- Open time is dependent on local conditions. Check coated pieces frequently to avoid skinning of the adhesive. This will trap solvent and may lead to adhesion failure soon after bonding. Once a skin has formed heat re-activation is necessary.
- If experiencing adhesive failure when bonding greasy leather, the addition of Desmodur RFE may help improve adhesion. Limiting open time to 3 days may also benefit adhesion to leather.

CLEANING

Clean up using Bostik No.4 Solvent.

Clean hands using Bostik Handy Towel, then wash with soap and water.

Dried adhesive is best removed by scraping or sanding.

STORAGE AND SHELF LIFE

Store in a cool dry place below 25°C and out of direct sunlight. Shelf life is 12 months from the date of manufacture when stored as directed. Keep containers closed when not in use.

DISPOSAL

Dry, empty containers may be disposed via local landfill. If spilt, absorb with clay, sand or earth. Collect and seal in properly labeled metal container. Dispose of according to local authority regulations. Do not dispose of down drains or into local waterways.

PRECAUTIONS IN USE

Complete details on each of the products mentioned are available on the product Safety Data Sheets. To ensure no harm is caused to persons using Bostik products, it is recommended that all concerned read the appropriate Safety Data Sheets. Visit www.bostik.co.nz for copies.

HIGHLY FLAMMABLE – KEEP AWAY FROM HEAT, SPARKS AND OPEN FLAME
KEEP OUT OF REACH OF CHILDREN
KEEP CLOSED WHEN NOT IN USE

FIRST AID

Swallowed: Do not induce vomiting, give a glass of water and contact a doctor immediately.

Skin: Remove contaminated clothing, wash with warm soapy water. Do not scrub.

Inhaled: Remove person to fresh air. Get medical advice if breathing becomes difficult. If inhaled to excess, remove from contaminated area – apply artificial respiration if not breathing.

Eyes: Hold open and flood with water for at least 15 minutes. Get medical advice.

For emergency information contact the National Poisons Information Centre, phone 0800 764 766 (0800 POISON) or CHEMCALL, phone 0800 243 622.

BOSTIK HOTLINE

Smart help 0508 222 777



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