

Bostik

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Information Sheet No B33/9
(supersedes Sheet No. B33/8)

1777 ADHESIVE

DESCRIPTION

BOSTIK 1777 ADHESIVE is a single part, heat curing, solvent-borne adhesive which exhibits high bond strengths combined with high heat resistance. Also it has good gap filling properties.

MATERIALS BONDED/APPLICATIONS

BOSTIK 1777 ADHESIVE is specifically designed for bonding friction materials to metal: vehicle brake linings, clutch linings and industrial drum brake linings.

BONDING INSTRUCTIONS

1. Thoroughly clean the surfaces. Metal should be grit blasted or abraded to give a grease-free matt surface.
2. Apply an even coat of the adhesive by brush or spray* to the lining surface only. (Adhesive application to both lining and brake shoes is not usually carried out in production processes.)
3. Allow the adhesive to dry completely. This may be accelerated by drying for 10 minutes at room temperature followed by heating for 30 to 60 minutes at 50 to 70°C. The adhesive coated surfaces may be left indefinitely before bonding, providing they are kept clean and dry.
4. To effect bonding bring the lining and brake shoe together under a pressure of 0.35 to 1.4 MPa (50 to 200psi) and maintain this for the following times and temperatures in order for the adhesive to be heat cured.

Either 4 hours at 100°C
or 45 minutes at 150°C
or 5 minutes at 200°C
or 2 minutes at 250°C

The temperatures quoted are
measured at the bond line

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Every endeavour has been made to ensure that the information given herein is true and reliable but it is given only for the guidance of our customers. The Company cannot accept any responsibility for loss or damage that may result from the use of the information, due to the possibility of variations of processing or working conditions and of workmanship outside our control. Users are advised to confirm the suitability of this product by their own tests.

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TYPICAL BOND CHARACTERISTICS

Temperature Resistance: -50 to 150°C. Will withstand temperatures of up to 250°C for short periods, but because of varying conditions i.e. stress, tension, etc., these figures are quoted for guidance only. Users should check the suitability of the adhesive for particular requirements

Water Resistance: Good

Oil, Petrol & Kerosene Resistance: Good

Shear Bond Strengths: (steel/steel bonds)	Test Temperature	MPa	(psi)
	Room	10.3	(1500)
	100°C	5.5	(800)
	150°C	3.4	(500)

PACKAGING

Please refer to the BOSTIK Customer Services Department for details of current pack sizes.

SUBSTANCE IDENTIFICATION NUMBER

UN 1133 (Packing Group 2)

STORAGE AND TRANSPORTATION

Store in a dry flameproof area between 5 and 25°C.

Subject to the Highly Flammable Liquids and Liquefied Petroleum Gases Regulations 1972.

SHELF LIFE

1 year from the date of manufacture under the above conditions of storage.

(BOSTIK 1777 ADHESIVE - continued 2)

For this curing process two production methods are mainly used:

a) anvil curing - a rapid process whereby the brake and shoe lining are bonded under the required pressure on a heated anvil, the brake shoe being pre-heated before the adhesive coated lining is positioned.

b) clamping - the brake shoe and lining are brought together under the required pressure in a clamping device of the strap and expander type, the whole assembly then being subjected to an appropriate heating cycle.

*Application by spray: Dilute BOSTIK 1777 ADHESIVE in the ratio of 5 parts by volume of adhesive to 3 parts of BOSTIK CLEANER/THINNER E(6316) and then spray with suitable equipment.

COVERAGE: Approximately 2m² per litre.

CLEANER/THINNER: Use BOSTIK CLEANER/THINNER E(6316) for thinning the adhesive prior to spray application and the cleaning of application equipment.

TYPICAL ADHESIVE CHARACTERISTICS

Physical form:	Viscous liquid
Colour:	Off white
Odour:	Fruity
Chemical Type:	Filled nitrile rubber/phenolic resin based solution
Solvent:	Mixture of ethyl acetate and ethanol
Viscosity:	10 Pa s (100 poise) approximately
Solids Content:	44% approximately
Specific Gravity:	1.0 approximately
Flammability:	Highly Flammable.
Flash Point: (Closed Cup)	In the group -7 to +4°C

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