

Bostik® Thermogrip®
2124**HOT MELT
ADHESIVES****Product Description**

Bostik® Thermogrip® 2124 glue stick is a milky clear, flexible hot melt adhesive designed for high performance bonding of difficult substrates or substrate combinations.

It is in compositional compliance with FDA regulation 21 CFR 175.105 for food packaging.

Product Benefits

- Excellent adhesion to a wide variety of substrates
- Long set time
- Flexible

Product Applications

- Bostik® 2124 bonds well to glass, plastics, ceramics, and displays.
- Most difficult substrate combinations
- Bonds to porous and non-porous surfaces

Application Information

1. All surfaces should be clean and free of contaminants. If necessary, clean surfaces with solvent.
2. Apply the adhesive to the more difficult-to-bond surface. In general, hard, smooth surfaces are more difficult to bond than rough, porous surfaces.
3. "Open-time" varies depending on application temperature, amount of adhesive applied, type of substrate and ambient temperature conditions.
4. Mate the surfaces to be bonded as quickly as possible after adhesive has been applied for optimum bond strength.
5. Use firmest pressure practical for object being bonded. Do not move or adjust surfaces after contact has been made, as inferior bond strength will result.
6. Bonding some metals is enhanced by pre-warming the surfaces. Pre-warm up to 200°F (95°C) for optimum effect.

(continued...)

Application Information (...continued)

7. Because of its excellent adhesion properties, 2124 can be difficult to run in some glue guns, especially after idle durations greater than 20 minutes. It is recommended to run 2124 in guns having flexible feeding tubes or semi-rigid Teflon® feeding tubes, and to keep gun idling times as short as possible.
8. Typically, a properly formed hot melt adhesive bond will achieve 50% of its strength after 1 minute, 75% after 1 hour, and 100% after 1 day.

Typical Physical Properties* (After 24 Hour Cure)

Color:	Milky Clear
Size (dia. x length):	7/16" x 4", 7/16" x 10" 7/16" x 15", 1" x 3"
Tensile Strength/Elongation:	450 psi/800%
Softening Point:	195°F (91°C)
Specific Gravity, gms/cc:	0.96
Viscosity, cps:	
@350°F (177°C)	15,000
@400°F (205°C)	7,600
Open Time:	Long (30 + seconds)
Temperature Resistance:	-20°F to 154°F (-28°C to 68°C)

Bond Characteristics

Chemical Resistance:	
Water	Good
Acids & Alkalies	Fair
Fats & Oils	Poor
Solvents	Poor

Storage and Handling

Shelf Life:	999 days @ 73.4°F (23°C)
Shipping and storage:	Between 40°F to 95°F (4°C to 35°C)
Further Information:	Please refer to MSDS for complete details.

* Values given are not intended to be used in specification preparation.

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