

PRODUCT DATA

Bostik® Liquid Rivet™ 1152 FS

Urethane Adhesive/Sealant

Product Description

Bostik® Liquid Rivet™ 1152 FS is a one component, moisture curing, polyurethane adhesive that has extremely high thixotropy and cured strength. Significant product benefits include very high green strength and initial tack, excellent elastic high strength bonds, very high solids and minimal VOC's (both CARB and SCAQMD compliant). Also, meets OTC VOC regulations.

Liquid Rivet 1152 FS exhibits high thixotropy resulting in easy overhead and vertical bonding and panel holding that reduces clamping times. Increases the torsional stiffness of final assemblies! Replaces most, if not all, mechanical fasteners like rivets and screws when applied to proper engineering guidelines. Liquid Rivet 1152 FS is both sandable and paintable. Improves vibration attenuation and sound dampening when used without mechanical fasteners.

Typical Applications

- Bonding **floors** (plywood and composite) to sub-floors and metallic / non-metallic vehicle frames.
- Bonding **exterior side panels** (aluminum, stainless, FRP) to corner posts or tubular frames.
- Bonding **composite roof panels** to metallic or aluminum roof bows.
- Bonding **sandwich panels and walls**

Note: Can be used in conjunction with Bostik® LoVOC Sealant. Liquid Rivet 1152 FS holds panels in place and acts as the clamps while LoVOC Sealant cures to bond and seal the panels to the frame.

Applicable Standards

- Conforms to SCAQMD and CARB (California Air Quality Emission Standards)
- Very low VOC (Volatile Organic Compound) emissions
- Meets OTC VOC regulations
- Very Low HAPs (Hazardous Air Pollutants), Isocyanates <6 g/l
- Very low odor



Typical Uncured Properties*

Property	Value
Skin Formation Time	30 to 45 mins.
Cure Rate (1/8-inch bead)	24 hours
Slump/Sag (0.75-inch bead)	None
Open Time	50 mins.

**Typical Cured Properties*
(after 14 days cure at 77°F and 50% RH)**

Property	Value
Hardness, Shore A	55
Tensile Strength (psi)	300
Modulus @ 25% Elongation	200
% Elongation to Break	300
Lap Shear Adhesion (psi to break), 0.062-inch gap, 1-inch overlap, speed 2 inches/min.	
Plywood	250
FRP	240
Painted Aluminum	200
Stainless Steel	175
Temperature Resistance	-40°F to 190°F

Note: All test values reported are based on laboratory testing of prototype batches and may not be representative of actual performance. Testing to verify values is recommended. Testing to verify substrate adhesion is also recommended.

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

Directions for Use

Substrate Preparation—Substrates should be free of all loose contamination, greases, oils, etc. Use Isopropyl alcohol or other approved solvent for substrate pretreatment.

Temperatures of substrate must be above 40°F. Recommended substrate and product application temperatures are between 55°F and 100°F.

Application—Cartridge—Cut tip to desired shape and diameter. *Puncture inner seal **before** extruding!* Apply appropriate pressure to install Liquid Rivet 1152 FS so as to assure full contact (surface wetting) to promote sealing and adhesion performance. Tool and finish applied Liquid Rivet 1152 FS immediately to promote best mechanical adhesion and cure appearance. Use water or soapy water solution for tooling compound.

Application—Sausage Package—Cut metallic end-clip and place sausage into a pneumatic caulking dispenser. Apply appropriate pressure to install Liquid Rivet 1152 FS so as to assure full contact (surface wetting) to promote sealing and adhesion performance. Tool and finish applied Liquid Rivet 1152 FS immediately to promote best mechanical adhesion and cure appearance. Use water or soapy water solution for tooling compound.

Available Packaging Sizes / Colors

10.3 oz. Cartridge / White, Black
20 oz. Sausage / White, Black

Clean Up

Uncured Liquid Rivet 1152 FS can be easily removed from hands, tools and substrates using Bostik® Hand & Tool Towels.

Shelf Life

Six months from date of manufacture when stored below 80°F (27°C).

Bostik, Inc.
211 Boston Street
Middleton, MA 01949 U.S.A.
Tel: 888-603-8558
<http://www.bostik-us.com>

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