

# X /51 SR

## Polyurethane adhesive for synthetics

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### Description

One component solvent based adhesive for bonding both at cold and at hot leather and fabrics to plasticized PVC, polyurethane, halogenated thermoplastic and vulcanized rubbers. Indicated for sticking wedges, heels, insole coverings in footwear and for bonding PVC laminated fabrics.

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### Characteristics

<b>Composition</b>	: polyurethane resin in a blend of organic solvents
<b>Mode of setting</b>	: release of solvent
<b>Colour</b>	: opalescent to transparent
<b>Solvents</b>	: ketones
<b>Components</b>	: one-part adhesive ready to use. Can be used with the addition of 3% <b>Desmodur RE</b> or <b>RFE</b> to improve the adhesion on to soles (e.g. polyurethane soles and plastic uppers)
<b>Pot life</b>	: 4 hours with the addition of the Accelerator

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### Technical data

<b>Solids content</b>	: 20 - 22 %
<b>Viscosity</b>	: 5000 - 7000 mPa.s at 25°C (Brookfield spindle 4, speed 50 rpm)

Values valid for product supply specification upon leaving the factory

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### Method of use

**Surface preparation** : it is recommended to solvent wipe the surface of PVC with **Solvente ST/141** or **ST 513** prior to apply the adhesive. The same solvent can be used in presence of release agents and oily matters.

Vulcanized rubbers: after solvent wiping, the surface must be treated with halogenating Primer **AC/20** or **AC/23/M**.

Thermoplastic rubbers: treat with Primer **AC/20** or **AC/23/M**.

**Application**: apply a coat of adhesive on to both sides to be joined.

**Drying time**: **X/51/SR** has good contactability at cold within 10 minutes from the application. After this time it is necessary heat activation by infrared rays or by hot air (temperature 50°-60°C).

**Assembly**: bring the two parts into contact and apply suitable pressure. Bond strength gradually increases with time, reaching maximum value in 2 or 3 days after bonding.

**Thinner**: ST/121

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## Technical Data Sheet

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**Packing:** tin kg 16

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#### **Storage stability**

12 months in the original sealed pack stored in a dry place at a temperature range +5°C+25°C.

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