

X/165

POLYURETHANE BASED ADHESIVE FOR BONDING UPPERS TO SOLES

X/165 LB is an one-part, brush grade adhesive characterized by an excellent green strength, resistant to oily matters of leathers and to PVC plasticizers as well as to water. The adhesive is suitable for bonding leather uppers and plastic uppers to vulcanized SBR soles, and to TR, polyurethane and PVC soles.

CHARACTERISTICS

Composition	: polyurethane resin in a blend of organic solvents
Mode of setting	: release of solvent
Colour	: opalescent to transparent
Solvents	: ketones
Components	: one-part adhesive ready to use. It can be used with the addition of 2-3% of Desmodur RE or RFE to improve the adhesion on to soles (e.g. polyurethane soles and plastic uppers)
Pot life	: 2 hours with the addition of the Accelerator

TECHNICAL DATA

Solids content	: 17 – 18 %
Viscosity	: 2050 - 2350 mPa.s (Brookfield spindle 4, spd 50, 25°C)

Values valid for product supply specification upon leaving the factory

METHOD OF USE

Preparation of the surfaces:

- Leather uppers and leather soles should be carefully roughed and brushed. Onto leathers having high grease content or onto materials where it is necessary to improve adhesive penetration, a first coat of **Primer 144F** or **Primer C** in addition with 3% of Accelerator **Desmodur RE** or **RFE** should be applied.
- Polyurethane soles should solvent wiped with **ST/141** or roughed.
- PVC soles should solvent wiped with **ST/141**.
- Vulcanized rubber soles: treat with **Primer AC/20** or **AC23/M**. In the presence of release substances it is recommended to solvent wipe with **ST/141** or to rough.
- TR rubber soles: treat with **Primer AC/20** or **AC23/M**
- Plastics uppers: in case of PVC uppers solvent wipe with **ST/141**. In case of PU coated materials, check if any anti-adhesive finish was applied to the surface and remove it by solvent wipe using **ST/141**

Application: apply by brush a coat of adhesive on to both surfaces to be bonded. If a first coat of primer is required, this is to be applied some 5-10 minutes in advance.

Drying of adhesive: allow to dry 20-30 minutes, then heat activate at a temperature of 70°C.

Assembly. Bring the two parts into contact and apply pressure of 4-5 bars with 10-12 seconds dwell time. Bond strength gradually increases with time, reaching maximum value in 2 or 3 days after bonding.

Technical Data Sheet

X/165



Thinner: ST/121.

STORAGE STABILITY

12 months in the original sealed pack or container, stored in a dry place at a temperature ranging from 5° up to 25°C.

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