

XM/B/4 J

POLYURETHANE ADHESIVE FOR BONDING UPPERS TO SOLES

PRODUCT DESCRIPTION

XM/B/4/J is a single-component adhesive with good hot tack and high initial strength, resistant to leather grease, PVC plasticisers and water. Suitable for bonding leather or synthetic uppers to soles made of vulcanised SBR rubber, TR rubber, Thunit, polyurethane, microcellular EVA, PVC and leather.

Due to its high solid content, it is particularly recommended for applications on very porous substrates.

DATI TECNICI

Composition:	polyurethane resin and mixture of organic solvents
Gripping mechanism:	solvent release
Colour:	colourless opalescent
Solvents:	ketones
Components:	the adhesive is single-component and ready to use. 2 - 3% VKL/50 activator can be added to increase chemical and thermal resistance and improve specific adhesion to adherents (e.g. polyurethane soles and synthetic uppers)
Workability time:	two hours with the addition of activator
Solid content:	19 - 21% *
Viscosity (Brookfield rpm4 speed50 at 25°C):	3.500 - 5.000 mPas *

* Values valid as product supply specification when leaving the factory..

TECHNICAL DATA

Surface preparation

- **Leather soles and uppers:** card and brush. On materials where the adhesive's penetration needs to be improved, apply a first coat of **Primer 144 F** or **Primer C** with the addition of 3% **VKL/50**. **Primer C** is particularly suitable as a first coat for bonding leathers with a high grease content.
- **Polyurethane soles:** wash with **Solvent ST/141** or card.
- **PVC soles:** wash with **Solvent ST/141**.
- **Vulcanised rubber soles:** treat with **Primer AC/20** or **Primer AC/23 M**; in the presence of release agents, wash with **Solvent ST/141** or card beforehand.
- **TR rubber soles:** treat with **Primer AC/20** or **Primer AC/23 M**; if necessary, wash first with **Solvent ST/141**.
- **Thunit soles:** treat with **Primer AC/20** or **AC 23/M**.
- **Microcellular EVA soles:** apply a first coat of **Primer 8200** with the addition of 3% **VKL/50**.
- **Synthetic uppers:** for PVC uppers, wash by pad with **Solvent ST/141**.
For polyurethane or coagulated coatings, check for any anti-adhesive finishes to be removed by washing with **Solvent ST/141**.

Application: spread a layer of adhesive on both surfaces to be joined.
Any first coat on leather must be applied 5 - 10 minutes in advance.

Drying time: wait about 20' - 30' to let the solvent evaporate, then reactivate at a temperature of 60°C - 70°C.
The high tack, high solid content and ease of impact of the adhesive film enable bonding even when there is poor thermal reactivation of one of the parts to be joined.
This feature is particularly advantageous when dealing with heat-sensitive materials which do not tolerate pressing at high temperatures.

Bonding: join the parts by pressing at 4 - 5 atm for 10 - 12 seconds.
The strength of the adhesive gradually increases over time until it reaches its maximum value 2 - 3 days after bonding.

Thinner: **Solvent ST/121**.

SAFETY AND HEALTH

See Safety Data Sheet.

STORAGE STABILITY

12 months from the date of manufacture if the product is kept sealed in the original container and stored in a dry place at temperatures between +5° and +25°C.



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