

# XM/81 N

## POLYURETHANE ADHESIVE FOR BONDING UPPERS TO SOLES

**XM/81N** is a two-part adhesive characterized by an excellent penetration onto porous substrates, high hot tack, resistant to oily leathers, to PVC plasticizers and to water. Suitable for bonding leather or synthetic uppers to soles made of SBR vulcanized rubber, TR, Thunit, polyurethane, PVC. In furnishing the product can be used for bonding leathers and fabrics to fiberglass, uPVC, wood and ABS.

XM/81N is suitable for bonding PVC to leather and synthetics by **direct injection**.

### CHARACTERISTICS

<b>Composition</b>	: polyurethane resin in a blend of organic solvents
<b>Mode of setting</b>	: release of solvent and reaction with curing agent
<b>Colour</b>	: opalescent to transparent
<b>Solvents</b>	: ketones
<b>Components</b>	: two-part adhesive, to be used with the addition of 4% of <b>Desmodur RE</b> or <b>RFE</b> , or <b>VKL50</b>
<b>Pot life</b>	: 4 hours with the addition of the Accelerator

### TECHNICAL DATA

<b>Solids content</b>	: 17 - 19%
<b>Viscosity</b>	: 1800 - 2100 mPa.s (Brookfield spindle 4, spd 50, 25°C)

Values valid for product supply specification upon leaving the factory

### METHOD OF USE

#### Surface preparation:

- leather uppers and leather soles should be carefully roughed and brushed. Onto leathers having high grease content or on to materials where it is necessary to improve adhesive penetration, a first coat of **Primer 144 F** or **Primer C** with the addition of 3% of Accelerator **Desmodur RE** or **RFE** should be applied. Primer C is especially indicated for bonding oily leathers.
- Polyurethane soles should be solvent wiped with **ST/141** or roughed.
- PVC soles should be solvent wiped with **ST/141**
- Vulcanized rubber soles: treat with **Primer AC/20** or **AC23/M**, if the surface is contaminated by release agents, previously rough it or solvent wipe with **Solvente ST/141**.
- TR soles: treat with **Primer AC/20** or **AC23/M**
- THUNIT soles: treat with **Primer AC/20** or **AC23/M**
- Synthetic uppers: PVC uppers should be solvent wiped 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 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 time:** allow to dry 20-30 minutes so that the solvent can evaporate, then heat activate at a temperature of 50-60°C.

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

When bonding coverings made of leather or fabric to plastic panels, if the surface is contaminated by release agents previously rough or solvent wipe with **Solvente ST/141**.

Onto fiberglass it is recommended to rough before the application.

Bring the parts in contact after the heat reactivation, press by hand, by roll or by other suitable device.

With bag shaped upholsteries, insert the covering at cold (the glue has to be completely dry), and after having adjusted them, heat reactivate and press.

**Thinner: ST/121.**

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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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