

XM/87

POLYURETHANE ADHESIVE FOR BONDING UPPERS TO SOLES

XM/87 is a two-part adhesive with high penetration onto porous substrates, good green strength and high tackiness under heat conditions, resistant to grease of leathers, to plasticizers of PVC and to water. Suitable for bonding leather and synthetic upper materials to SBR vulcanized rubber soles, TR rubber, Thunit, Polyurethane, PVC. Particularly suitable for bonding low hardness rubber soles.

CHARACTERISTICS

Composition	: polyurethane resin in a blend of organic solvents.
Mode of setting	: release of solvent and reaction with vulcanising agent
Colour	: opalescent clear
Solvents	: ketones.
Components	: two-part adhesive, to be used with the addition of 4% of Desmodur® RFE or RE
Pot life	: 4 hours after mixing with Accelerator.

TECHNICAL DATA

Solids content	: 17 - 19 %
Viscosity	: 1800 - 2100 mPas (Brookfield spindle 4 speed. 50 at 25°C)

Values valid for product supply specification upon leaving the factory

METHOD OF USE

Surface preparation:

- Leather soles and leather uppers should be carefully roughed and brushed. Onto materials where it is necessary to improve adhesive penetration, apply a first coat of **Primer 144/F** or **Primer C** used with the addition of 3% **Accelerator Desmodur®** RE or RFE. **Primer C** is particularly suitable as first coat for bonding oily leathers.
- Polyurethane soles should be roughed or solvent wiped with **Solvente ST/141**.
- PVC soles should be solvent wiped with **Solvente ST/141**.
- Vulcanised rubber soles should be treated with **Primer AC/20** or **AC/23 M**; if the surface is contaminated by release agents, previously rough it or solvent wipe with **Solvente ST/141**.
- TR rubber soles should be treated with **Primer AC/20** or **AC 23/M**.
- THUNIT soles should be treated with **Primer AC/20** or **AC 23/M**.
- Synthetic uppers: PVC uppers should be solvent wiped with **Solvente ST/141**. In case of polyurethane coated materials check if any anti-adhesive finish was applied to the surface and remove it by solvent wipe using **Solvente ST/141**.

Application of Adhesive: apply a coat of adhesive onto the two 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 the adhesive to dry 20-30 minutes so that the solvent can evaporate, then heat activate to a temperature in the ranging from 50°C to 60°C.

Assembly: bring the two parts in contact and apply pressure of 4-5 bars with 10-12 seconds dwell time. The high green strength and the ease of impact of the adhesive film allow the bond to take place even if one of the parts should be scarcely heat activated. Bond strength gradually increases with time, reaching maximum value in 2 or 3 days after bonding.

Thinner : ST/121

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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