

# E.S. XM/148

## POLYURETHANE ADHESIVE FOR BONDING UPPERS TO SOLES

### PRODUCT DESCRIPTION

**E.S. XM/148** is a one-part adhesive with high hot tack and green strength, resistant to leather grease, to PVC plasticizers as well as to water. Suitable for bonding leather or synthetic uppers and for PVC sole injection moulding, it can be applied by roller spreader.

### CHARACTERISTICS

<b>Composition:</b>	polyurethane resin in a blend of organic solvents
<b>Mode of setting:</b>	release of solvents
<b>Colour:</b>	opalescent
<b>Solvents:</b>	ketones
<b>Components:</b>	one-part adhesive, can be used with the addition of 3-5% of <b>Desmodur® RFE</b> or <b>Accelerator VKL/50</b> to improve thermal and chemical resistance and the adhesion on polyurethane and synthetic materials
<b>Pot life:</b>	3 hours with addition of <b>Desmodur RFE®</b> 6-8 hours with the addition of <b>Accelerator VKL/50</b>
<b>Solids content:</b>	15 – 16%
<b>Viscosity:</b>	1700 - 2100 mPa.s (Brookfield spindle.4 speed.50 at 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 materials where it is necessary to improve the adhesive penetration, apply a first coat of **Primer 144/F** or **Primer C** in addition with 3% of **Desmodur RFE®** or **Accelerator VKL/50**. **Primer C** is particularly indicated as first coat for bonding oily leathers
- Polyurethane soles:** should be roughed or solvent wiped with **ST/141 Solvent**.
- PVC soles:** should be solvent wipe with **ST/141 Solvent**.
- Vulcanized rubber soles:** should be treated with **Primer AC/20** or **Primer AC/23/M**; if the sole surface is contaminated by release agents, previously rough it or solvent wipe with **ST/141 Solvent**.
- TR rubber soles:** should be treated with **Primer AC/20** or **Primer AC/23 M**
- Synthetic uppers:** PVC uppers should be solvent wiped with **Solvent 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 **Solvent ST/141**.

**Application:** 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 10-15 minutes in advance.

**Drying time:** allow the adhesive to dry 20'-30' so the solvent can evaporate, then heat activate to a temperature ranging from 65°C to 70°C

**Assembly:** bring the two parts in 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.

**Thinner:** **Solvent ST/121 - Solvent ST/141**

### STORAGE STABILITY

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

Desmodur® RFE is a trademark of Bayer AG



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