

E.S. XM/148/LB

POLYURETHANE ADHESIVE FOR BONDING UPPERS TO SOLES

PRODUCT DESCRIPTION

E.S. XM/148/LB is a one-part adhesive with good hot tack and high green strength, resistant to leather grease, to PVC plasticizers as well as to water. Suitable for bonding leather or synthetic uppers to vulcanised SBR, to TR, polyurethane and PVC soles.

It can be applied by automatic spreader machine.

It is particularly suitable in manufacturing processes It is particularly suitable in manufacturing processes where high temperature reactivation is required.

CHARACTERISTICS

Composition:	polyurethane resin in a blend of organic solvents
Gripping mechanism:	solvent release
Colour:	opalescent
Solvents:	ketones
Components:	the adhesive is single-component and ready to use. 3 - 5% 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:	6 - 8 hours with the addition of activator
Solid content:	15,5 – 17% *
Viscosity (Brookfield rpm4 speed50 at 25°C):	1.700 - 2.000 mPa.s *

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

METHOD OF USE

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**.
- **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: 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.

The adhesive is ready to use for application with automatic spreader machine.

Drying time: allow the adhesive to dry 20' - 30' so the solvent can evaporate, then heat activate to a temperature ranging from 70°C to 75°C.

Bonding: 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**.

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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