

# XM/149

## POLYURETHANE BASED ADHESIVE FOR BONDING UPPERS TO SOLES

**XM/149** is an one-part adhesive characterized by an excellent green strength, resistant to oily matters of leathers and to PVC plasticizers as well as to water. The adhesive is suitable for bonding leather uppers and plastics uppers to vulcanised SBR soles, and to TR, polyurethane and PVC soles. It is particularly suitable in manufacturing processes where quick drying and high temperature reactivation are required.

### CHARACTERISTICS

<b>Composition</b>	: polyurethane resin in a blend of organic solvents
<b>Mode of setting</b>	: release of solvent
<b>Colour</b>	: opalescent to transparent
<b>Solvents</b>	: ketones
<b>Components</b>	: one-part adhesive ready to use. It can be used with the addition of 2-3% of <b>Desmodur RE</b> or <b>RFE</b> to improve the adhesion onto soles (e.g. polyurethane soles and plastics uppers)
<b>Pot life</b>	: 2 hours with the addition of the Accelerator

### TECHNICAL DATA

<b>Solids content</b>	:16 – 18%
<b>Viscosity</b>	:1900 - 2300 mPas (Brookfield spindle 4, spd 50, 25°C)

Values valid for product supply specification upon leaving the factory

### METHOD OF USE

#### Surfaces preparation

- Leather uppers and leather soles should be carefully roughed and brushed. Onto leathers having high grease content or onto materials where it is necessary to improve adhesive penetration, a first coat of **Primer 144 F** or **Primer C** in addition with 3% of Accelerator **Desmodur RE** or **RFE** should be applied.
- polyurethane soles should solvent wiped with **ST/141** or roughed.
- PVC soles should solvent wiped with **ST/141**
- Vulcanised rubber soles: treat with **Primer AC/20** or **AC23/M**. In the presence of release substances it is recommended to solvent wipe with **ST/141** or to rough.
- TR rubber soles: treat with **Primer AC/20** or **AC23/M**
- Plastics uppers: in case of PVC uppers solvent wipe 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 onto 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 15-20 minutes so that the solvent can evaporate, then heat activate at a temperature of 70° - 75°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.

## Technical Data Sheet

### XM/149

Thinner: ST/141

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Package: tin of kg 15

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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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