

EVX/169

PU BASED ADHESIVE FOR CEMENTING MICROCELLULAR EVA PRETRATED WITH UV-ACTIVATED *EVX PRIMER*

Description

EVX/169 is a two-part adhesive with very good hot tack and good initial strength, resistant to oily leathers, to PVC plasticizers as well as to water. The adhesive was specially developed for cementing soles and midsoles based on cross-linked EVA foams to all materials used in shoe manufacturing, such as synthetic uppers, oily leathers, soles of either vulcanised or thermoplastic rubber.

CHARACTERISTICS

Composition	: polyurethane resin in a blend of organic solvents
Mode of setting	: release of solvent and reaction with accelerator
Colour	: opalescent to colourless
Solvents	: ketones
Components	: to be used with 2 to 4% of Accelerator Desmodur RFE
Pot life	: 4 hours with the addition of the Accelerator

TECHNICAL DATA

Solids content	: 18 - 19%
Viscosity	: 1800 - 2000 mPa.s (Brookfield spindle 4, spd 50, 25°C)

Values valid for product supply specification upon leaving the factory

METHOD OF USE

Surfaces preparation:

EVA soles: to prepare and treat cross-linked expanded EVA soles and midsoles see "Primer **EVX/3513**" technical data sheet

- 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 144F** or **Primer C** with the addition of 3% of Accelerator **Desmodur RE** or **RFE** should be applied. For leather with high grease content it is recommended to use **Primer C** as first coat.
- polyurethane soles should solvent wiped with **ST/141** or roughed.
- PVC soles should solvent wiped with **ST/141**.
- Vulcanized 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**
- Plastic 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 of adhesive: allow to dry 20-30 minutes so that the solvent can evaporate.

Technical Data Sheet

EVX/169

Assembly: activate the surfaces at 50°C/60°C and bring the two parts into contact and apply pressure of 4-5 bars with 10-12 seconds dwell time. The high tackiness of the adhesive film allows the parts to be joined at low pressure and low thermal activation, treatment recommended for expanded materials in order to avoid any deformation.

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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