

**TECHNICAL DATA**

<b>Composition:</b>	<b>polyurethane resin in water dispersion</b>
<b>Mode of setting:</b>	by water evaporation and reaction with an incorporated crosslinker.
<b>Colour:</b>	dispersion is white, turning transparent when drying.
<b>Solvents:</b>	solventless adhesive.
<b>Viscosity:</b>	1000-1500 mPa.s (Brookfield sp.5 speed 50 at 25°C)
<b>pH:</b>	neutral

Values given in this table must not be considered as specifications.

**PRODUCT DESCRIPTION**

Polyurethane-based adhesive in aqueous dispersion.

**PRODUCT CHARACTERISTICS AND USES**

**Z.Tex 9627/DM** is an adhesive suitable for bonding, by heat reactivation, leather, fabrics, plasticized PVC, polyurethane, halogenated TR and vulcanized rubber. One-component formulation developed for high temperature and hydrolysis resistance bonding.

**METHOD OF USE****Preparation of the sole:**

- Resin rubber, vulcanized rubber, TR soles: treat with halogenating primer **AC/20** o **AC/23/M**; if the sole surface is contaminated by release agents, previously rough it or solvent wipe with **ST/141**.
- PVC or Polyurethane soles: solvent wipe with **ST/141**.
- Leather soles: carefully rough.

**Preparation of upper:**

- PVC upper: solvent wipe with **ST/141**.
- PU coated upper: rough to expose the fabric underlayer..
- Leather upper: rough deeply. Onto very low porous surfaces it is suitable to use **Primer 9628 + 3-5% VKD Activator**, as first coat (drying time 10'). Onto leathers having high grease content a first coat of **Primer DV** or **Primer C** in addition with 3% of **Accelerator Desmodur RFE** should be applied.

**Application:** apply an even coat of adhesive on the two sides to be bonded by brush or other suitable device for waterborne adhesives.

**Drying time:** drying time noticeably depends on the room temperature and humidity as well as on the porosity of substrate.

Allow the adhesive film to turn from white to transparent before submitting it to heat reactivation. At a temperature of 20° C and 50% r.h. film turns transparent in about 30 minutes when porous substrates are involved and in 45 to 50 minutes with non-porous materials. Drying time can be noticeably reduced by heat.

**Assembly:** Heat reactivate the surfaces at 70°C then bring the two parts in contact and apply pressure of 4-5 bar with 10-12" dwell time. Bond strength gradually increases with time, reaching maximum value in 2 days after bonding.

**SAFETY AND HEALTH**

See the SDS.

**STORAGE STABILITY**

**6 months** in the original unopened container. The product is affected by frost. Keep preferably at a temperature range of +10°C+25° C.

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