

9627 HD

POLYURETHANE BASED ADHESIVE IN WATER DISPERSION

9627 HD is a waterborne 2-part adhesive, heat reactivable, for cementing leather uppers, fabric uppers, plasticized PVC, polyurethane, halogenated thermoplastic and vulcanised rubber. Suitable for application by brush or roller.

CHARACTERISTICS:

Composition	: polyurethane resin in water dispersion
Mode of setting	: by evaporation of water and reaction with vulcanising agent
Colour	: white in dispersion, turning transparent when drying.
Solvents	: solventless
Components	: 2-part adhesive, to be used with the addition of 3 to 5% VKD Activator
Pot life	: 8 hours

TECHNICAL DATA

Viscosity : 18000-30000 mPas (Brookfield spindle 5 speed 5 at 25°C)

Value valid for product supply specification upon leaving the factory

METHOD OF USE

Sole preparation:

-soles of resin rubber, vulcanised rubber, thermoplastic rubber: have them pretreated with halogenating Primers **AC/20** or **AC/23/M**. If the surface is contaminated by release agents it is recommended to solvent wipe with **ST/141** or to rough first.

-soles of PVC and soles of polyurethane: solvent wipe with **Solvente ST/141**.

-soles of leather: have them roughed in deep.

Upper preparation:

- PVC uppers: solvent wipe with Solvente ST/141
- Polyurethane uppers: rough to expose the fabric underlayer.
- Leather uppers: rough in deep. The adhesive is not suitable for oily leather. Onto very low porous surfaces it is suitable to use Primer 9628 + 3-4% VKD Activator, as first coat.

Application of adhesive:

Apply an even coat of adhesive on to both surfaces to be assembled, using a brush or any other spreading equipment suitable for adhesives in water dispersion.

Drying time:

Drying time noticeably depends on the 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 parts to 60-70°C then assemble under pressure considering 10-15 sec dwell time.

Maximum bond strength of the adhesive is reached in 48 hours.

STORAGE STABILITY

12 months in the original container. Keep in a dry place at a temperature range between +5° +25° C.

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