

Z.TEX 9631 DM

ONE COMPONENT WATER BASED POLYURETHANE ADHESIVE

PRODUCT DESCRIPTION

Z.TEX 9631 DM is an adhesive suitable for bonding, by heat reactivation, leather, fabrics, plasticized PVC, polyurethane, halogenated TR and vulcanized rubber.

One-component formulation with a very good hot contactability, developed for high temperature and hydrolysis resistance bonding.

TECHNICAL DATA

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| Composition: | polyurethane resin in water dispersion |
| Mode of setting: | by water evaporation and reaction with an incorporated crosslinker |
| Colour: | dispersion is white, turning to transparent when drying |
| Solvents: | solventless |
| Viscosity (Brookfield sp.5 speed 50 at +25°C): | 1.300 - 2.000 mPa.s * |
| Ph: | neutral |

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

METHOD OF USE

Preparation of sole

- **Resin rubber, vulcanized rubber, TR soles:** treat with halogenating primer **AC/20** or **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 **SOLVENTE ST/141**.
- **Leather soles:** carefully rough.

Preparation of upper

- **PVC upper:** solvent wipe with **SOLVENTE ST/141**.
- **PU coated upper:** rough to expose the fabric underlayer.
- **Leather upper:** rough deeply. The product is not suitable to use on leathers having high grease content.

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 60°C - 70°C then bring the two parts in contact and apply an adequate pressure with 10 - 15 seconds dwell time.

Bond strength gradually increases with time, reaching maximum value in 2 days after bonding.

SAFETY AND HEALTH

See Safety Data Sheet.

STORAGE STABILITY

6 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 +10°C and +25°C.

The product is affected by frost.



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