

CZ/108 R POLYCHLOROPRENE BASED ADHESIVE FOR BONDING UPPERS TO SOLES

PRODUCT DESCRIPTION

CZ/108 R is a two-part adhesive suitable for bonding leather uppers to thermoplastic rubber soles.

NOTE

Because of the large variety of thermoplastic rubber compounds available on the market, it is always recommended to make previous testing before using the product on industrial scale.

CZ/108 R is not indicated for bonding oily leathers for which it is recommended the use of polyurethane adhesives.

CHARACTERISTICS

Composition:	polychloroprene rubber and synthetic resins in a blend of organic solvents
Mode of setting:	release of solvent
Colour:	light amber
Solvents:	esters, ketones and hydrocarbons
Components:	two-part adhesive to use with the addition of 3-4% of Desmodur® RFE
Pot life:	1-2 hours with the addition of accelerator
Solids content:	21 - 23%
Viscosity:	2.100 - 2.500 mPa.s (Brookfield spindle 4, spd 50 at 25°C)

Values valid for product supply specification upon leaving the factory

METHOD OF USE

Preparation of the surfaces:

leather uppers should be carefully roughed and brushed.

TR rubber soles should be solvent wiped with **Solvente ST/141** 5-10 minutes before the application of the adhesive.

Application: apply a coat of adhesive by brush on to both surfaces to be bonded.

Drying of adhesive: allow to dry 20-25 minutes so that the solvents can evaporate, then heat activate at a temperature in the range 30°C-40°C by hot air or infrared rays.

Assembly: bring the two parts into contact and apply pressure of 3-5 bar with 10-12 seconds dwell time. Bond strength gradually increases with time, reaching maximum value in 4 or 5 days after bonding.

STORAGE STABILITY

12 months in the original sealed pack or container at a temperature ranging from 5° up to 25°C

Desmodur® RFE is a trademark of Bayer AG



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