

# 8000/N

## POLYCHLOROPRENE BASED ADHESIVE FOR BONDING UPPERS TO SOLES

**8000/N** is a two-part adhesive with long open time and high tack suitable for cold bonding of leather uppers to soles of vulcanized SBR, microcellular rubber, resin rubber (Thunit) and leather .

### CHARACTERISTICS

<b>Composition</b>	: polychloroprene rubber and synthetic resins in a blend of organic solvents.
<b>Mode of setting</b>	: evaporation of solvents and reaction with curing agent.
<b>Colour</b>	: light amber
<b>Solvent blend</b>	: esters, ketones, aliphatic hydrocarbons.
<b>Components</b>	: two components to be mixed prior to use. Part two is <b>Desmodur RE, RFE</b> , mixing ratio being 3-4% by weight to be added to the adhesive (part one).
<b>Pot life</b>	: The adhesive with addition of accelerator is to be used within 1 - 3 hours after mixing

### TECHNICAL DATA

<b>Solids content</b>	: 22 - 24 %
<b>Viscosity</b>	: 1800 - 2200 mPas (Brookfield spindle 4 speed. 50 at 25 °C)

Values valid for product supply specification upon leaving the factory

### METHOD OF USE

#### Surface preparation:

- Leather soles and leather uppers should be carefully roughened and brushed. Polychloroprene based adhesives are not suitable for bonding oily leathers, for which polyurethane based adhesives are recommended.
- Soles of vulcanized rubber should be roughened soon before using them in bonding. Soles obtained from rubber slabs, either of the expanded or of the non-expanded type, already roughened soon after manufacture might prove satisfactory even if aged up to some extent. Prior testing is therefore always recommended.

#### Application of Adhesive:

apply by brush the adhesive on to the two surfaces to be bonded.

#### Drying of Adhesive:

allow to dry 25-30 minutes so that solvents can evaporate.

#### Assembly:

bring the two parts into contact and apply pressure of 3-5 bar with 10-12 second dwell time. Adhesive strength gradually increases with time, and maximum bond strength is reached some 3 or 5 days after bonding.

### Thinner : SOLVENTE AP

### 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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