

E.S. 8000/N/E POLYCHLOROPRENE BASED ADHESIVE FOR BONDING UPPERS TO SOLES

PRODUCT DESCRIPTION

E.S. 8000/N/E is a two-part adhesive with high green strength and adhesiveness suitable for cold bonding of leather uppers to soles of vulcanized SBR, microcellular rubber, resin rubber (Thunit) and leather .

CHARACTERISTICS

Composition:	polychloroprene rubber and synthetic resins in a blend of organic solvents
Mode of setting:	evaporation of solvents and reaction with curing agent
Colour:	light amber
Solvents:	esters, ketones, aliphatic hydrocarbons
Components:	two components to be mixed prior to use. Part two is Desmodur RFE® or Accelerator K/E . Mixing ratio being 4-5% by weight to be added to the adhesive (part one)
Pot life:	The adhesive with addition of accelerator is to be used: within 1 - 3 hours after mixing Desmodur RFE® within 5 - 6 hours after mixing Accelerator K/E
Solids content:	22 - 24 %
Viscosity:	2.000 - 2.200 mPa.s (Brookfield spindle 4, spd 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 20-30 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: Solvent AP

STORAGE STABILITY

12 months in the original sealed pack stored in a dry place at a temperature range +5°C + 25° C.

Desmodur® RFE is a trademark of Bayer AG



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