

TECHNICAL DATA

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
Solvent blend:	esters, ketones, aliphatic hydrocarbons
Components:	two components to be mixed prior to use. Part two is Desmodur RFE , mixing ratio being 3-4% 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
Solids content:	20 – 23 %
Viscosity:	2000 - 2300 mPas at 25 °C (Brookfield spindle 4 s peed. 50)

Values given in this table must not be considered as specifications.

Desmodur® RFE is a registered trademark of Covestro.

PRODUCT CHARACTERISTICS AND USES

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 .

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 : SOLVENTE AP

SAFETY AND HEALTH**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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