

8000/N LB

POLYCHLOROPRENE BASED ADHESIVE FOR BONDING UPPERS TO SOLES

Description

8000/N LB 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. High solid content and viscosity, it is particularly suggested for bonding very porous materials. Combined with 8000/N it can be used onto non porous substrates.

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
Solvent blend : esters, ketones, aliphatic hydrocarbons.
Components : two components to be mixed prior to use. Part two is **Desmodur RE, 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.

Technical data

- Solid content** : 23,5 – 25 %
Viscosity : 2800 - 3200 mPas. (Brookfield sp.4, speed 20 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' 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

Technical Data Sheet

8000/N LB

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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