

E.S. 9901/HT

POLYCHLOROPRENE BASED ADHESIVE FOR BONDING UPPERS TO SOLES

PRODUCT DESCRIPTION

E.S. 9901/HT is a one part adhesive suitable for bonding leather uppers, leather welt, reclaimed leather, thunit, bonded leather, to leather soles, reclaimed leather, thunit. Characterised by high green strength, strong filling power and tack. It can be applied by brush or roller spreading machine. Expressly formulated for later bottom bonding at hot. Suitable for lasting operations with very absorbing leathers and loosely-woven.

CHARACTERISTICS

Composition:	polychloroprene rubber, synthetic resins in a blend of organic solvents
Mode of setting:	release of solvent
Colour:	dark amber
Solvents:	esters, ketones, hydrocarbons
Solids content:	22 - 23,5%
Viscosity:	2.400 - 2.600 mPa.s (Brookfield s.4 v.50 a 25°C)

Values valid for product supply specification upon leaving the factory

METHOD OF USE

Surface preparation:

- **Leather soles, reclaimed leather and leather welts, reclaimed leather, bonded leather:** rough and apply a first coat of adhesive **Primer 8200** + 3-5% of **Accelerator Desmodur® RFE** or **Accelerator K/E**.
- **Soles and welts made of thunit:** fresh rough before bonding.

Adhesive application: apply by brush onto both parts to join

Drying time: allow to dry 15-20 minutes so that the solvents can evaporate

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 48 hours 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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