

# Primer AC 20 - AC 23/M

## HALOGENATING PRIMERS FOR TREATING TR AND VULCANIZED RUBBER

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The halogenating primers make up a system proving both fast and effective in modifying rubber soles surfaces and making them suitable for being bonded with polyurethane based adhesives.

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**AC 20** - A two-part primer for treating by brush application SBS (TR) rubber soles and vulcanized SBR soles. The two parts are to be mixed together prior to use **AC/19** can be used with automatic spray machines

**AC 23/M** - One-part ready to use primer for spray application in connection with automatic spray machines, or for use by brush application, in treating soles of SBS and of vulcanised SBR.

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### METHOD OF USE

**Surface preparation:** Halogenating primers should be applied onto dry and clean surfaces. Halogenation treatment can prove ineffective if sole surface is contaminated by mould release agents or plasticizers. Whilst thermoplastic rubber soles generally show clean surfaces, onto which halogenation treatment can be carried out direct with no need of any previous cleaning, vulcanized rubber soles in most instances do need a careful wipe, to be made by means of a suitable solvent such as our **ST/141**. In some instances roughing of sole can be required.

### Application of primer

**Primer AC 20** : prepare the solution by adding part B (powder) to part A (Solvent). Mixing ratio is 18 g. of powder to 1000 g. of solvent. Carefully stir the solution until the powder is thoroughly dissolved. Pot life of the solution is not over 4 hours after mixing of components.

**Primer AC 23/M** : This is a ready to use primer, which can be used in connection with fully automatic spray machinery, and with brush application as well.

Halogenating primers are prone to be affected by moisture and are quickly damaged when in contact with metal parts. It is therefore recommended to pour out of the original pack into plastics or glass containers with narrow mouth the amount of primer which is expected to be used within a short period, in order to avoid solvent evaporation and exposure to moisture.

Residual primer in open pack must not be used for soles treatment.

It is recommended to treat soles under hood.

When applying primers by brush, it is sufficient to spread an even coat on to the surfaces to be bonded, avoiding of passing brush over and again and thus applying too much product.

With thermoplastic rubber it is to be avoided to leave any primer solution stagnate, especially in hollow parts of sole, for this could give rise to embrittlement of material.

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## Technical Data Sheet

### AC 20 - AC 23/M

**Drying of primers and effectiveness of treatment:** allow primer to dry 30-60 minutes prior to applying the adhesive, this is to let solvents fully evaporate. Halogenated soles can be used in shoe manufacturing a few days after treatment and even up to a few weeks after. Effectiveness of treatment is depending on nature of sole and storage conditions as well.

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#### STORAGE STABILITY

**AC 20:** can be stored for 12 months in closed (unopened) container in a dry place at temperatures between +5°C and +25°C.

**AC 23/M:** can be stored for 6 months in closed (unopened) container in a dry place at temperatures between +5°C and +25°C

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