

PRIMER EVX/3515

UV-REACTIVABLE PRIMER FOR TREATING MICROCELLULAR EVA TO BE SUBSEQUENTLY CEMENTED USING PU BASED ADHESIVES OF EVX SERIES

Treatment using **PRIMER EVX/3515** is a **fast** system of pre-treating soles or midsoles based on **cross-linked expanded EVA**, thus avoiding surface roughing which would prove rather difficult to make when components have a specially elaborate shape.

When used combined with PU adhesives of X and EVX series, it allows cementing of all materials used in shoe manufacturing, such as synthetic uppers, oily leathers and in case of midsoles, outsoles of either vulcanized or thermoplastic rubber.

METHOD OF USE

Surface preparation: Primer **EVX/3515** should be applied to dry and clean surfaces. Pre-treatment can prove ineffective if any surface contaminants, such as release agents or plasticizers, are left on soles or midsoles. A carefully executed solvent wipe is generally recommended, which can be realised with Solvent like **ST/198**.

Application: Primer **EVX/3515** is ready to use and can be applied either using automatic spray applicators or by brush or pad. When applied in a thin and uniform coat, creates after drying a barely visible film.

When dried out, which takes 5 to 7 minutes, primed materials is exposed to UV-radiation into a special appliance like tunnel with at least 2 mercury-vapour lamps at medium high pressure, (210-370 nm wave length) power rating 80/150 W/cm. each, belt speed into the tunnel from 3 to 12 mt/min. The distance of the surface should be included between 20 and 30 cm.

According to the different kinds of cross-linked expanded EVA, 0,9-1,5 J/cm² is the UV dose required in a single passage to activate **Primer EVX/3515**.

In consideration of the expansion kind of the material, the parameters of UV oven will be adjusted each time, avoiding an useless overheating of the material.

Soles and midsoles treated as above, after a short cooling can be used for shoe cementing on truck lines, either immediately or a few days later, using the special two part PU based adhesive EVX 169 in addition with 2 to 4% of accelerator **Desmodur RFE**. The above mentioned adhesive was specially developed for use under low pressure conditions which is very often required with expanded materials so that to obtain the desired surface impact and at the same time to avoid the risk of permanent damages to the materials.

Wishing to use primed soles or midsoles a few weeks after their pre-treatment as above, it is suggested to apply onto their surface soon after the priming a coat of **EVX/169** or of **X/144 F** adhesive in addition with accelerator.

For further details as to characteristics and use of **EVX/169** adhesive please refer to the information sheet.

STORAGE STABILITY

12 months in the original pack. Keep in a dry place at a temperature range between +5°C and +25°C.

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