

XM/87 ANTISTATIC

FOR BONDING UPPERS TO SOLES WITH CONDUCTIVE ADDITIVE

XM/87 antistatic is a one-part adhesive with good green strength, resistant to oily matters of leather and to PVC plasticizers as well as to water. It is suitable for bonding leather uppers and plastic uppers to soles of vulcanized SBR, TR, resin rubber (Thunit), polyurethane, PVC and leather. The conductive additive contained in the adhesive promotes, in the dried film, the dispersion of electrostatic charge

XM/87 antistatic may therefore be suitable for bonding materials with antistatic characteristics.

The actual suitability of the adhesive to meet the requirements of antistatic footwear must be evaluated, before starting with industrial production, with an appropriate test on the complete footwear made with the same combination of materials which will be used for its assembly.

Properties

Composition :	polyurethane resin in a blend of organic solvents
Curing system :	by evaporation of solvents
Colour :	black
Solvent :	esters and ketones
Components :	one-part adhesive ready to use. It can be used with the addition of 2-3% of Desmodur® RFEto improve the heat resistance and the adhesion on to polyurethane soles and to plastic uppers.
Pot life :	4 hours after the addition of the Accelerator

Technical data

Solids content :	18 - 20 %
Viscosity :	2.200 - 2.500 mPa.s (Brookfield spindle 4, speed. 50, 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 roughed and brushed. Onto materials where it is necessary to improve adhesive penetration, apply a first coat of **Primer 144F** or **Primer C** with the addition of 3% **Accelerator Desmodur RFE**. **Primer C** is particularly indicated as first coat for bonding oily leathers.
- **Polyurethane soles** should be roughed or solvent wiped with **Solvente ST/141**.
- **PVC soles** should be solvent wiped with **Solvente ST/141**.
- **Vulcanised rubber soles** should be treated with **Primer AC/20** or **AC 23/M**, if the surface is contaminated by release agents or polluting substances, previously rough it or solvent wipe with **ST/141 Solvent**.
- **TR rubber soles** should be treated with **Primer AC 20** or **AC 23/M**.
- **THUNIT soles** should be treated with **Primer AC/20** or **AC/23 M**.
- **Synthetic uppers:** PVC uppers should be solvent wipe with **ST/141 Solvent**. coated materials check if any anti-adhesive finish was applied to the surface and remove it wiping with **ST/141 Solvent**.

Application: apply by brush a coat of adhesive onto both surfaces to be bonded. If a first coat of primer is required, this is to be applied some 5-10 minutes in advance.

Drying time: allow the adhesive to dry 20-30 minutes so that the solvents can evaporate, then heat activate to a temperature of 60° - 70°C.

Assembly: ubring the two parts in contact and apply pressure of 4-5 bars with 10-12 seconds dwell time. Bond strength gradually increases with time, reaching maximum value in 2 or 3 days after bonding.

Thinner: ST/121.

XM/87 ANTISTATIC

FOR BONDING UPPERS TO SOLES WITH CONDUCTIVE ADDITIVE

Storage stability

12 months for the product kept in the original sealed pack at a temperature range from + 5°C to + 25°C.



Fratelli Zucchini S.p.A.
Via C. Colombo, 6 - 44124 Ferrara - Italy
Tel. + 39 0532 782711 - Fax +39 0532 732121
info@zucchini.it - www.zucchini.it

COMPANY WITH
QUALITY SYSTEM
CERTIFIED BY DNV GL
= ISO 9001 =