

A close-up photograph of a shoemaker's hands working on a shoe. The shoemaker is wearing a white long-sleeved shirt and a dark apron. They are using a pair of pliers to work on the sole of a brown leather shoe. The workshop is filled with various tools, including a hammer, a mallet, and several metal shoe lasts. A finished black leather shoe with yellow laces is visible in the foreground. The lighting is warm and focused on the hands and the shoe being worked on.

# Footwear

The logo for Fratelli Zucchini, featuring a large, stylized red 'FZ' monogram. Below the monogram, the words 'FRATELLI' and 'ZUCCHINI' are written in a bold, sans-serif font.

**FRATELLI  
ZUCCHINI**



GLUE, ADHESIVE,  
TOO EASY.

**FRATELLI ZUCCHINI**

GLUING SOLUTIONS

# ***FRATELLI ZUCCHINI***

Fratelli Zucchini was born in 1930, and starting from 1950's is specialized in the production of adhesives and sealants for any application field, from footwear to buildings, from automotive to window frames, from boats to household appliances.

Since the beginning, a particular attention was focused on Footwear Adhesives, with a whole Department completely dedicated to this sector; today we can boast references among the most important names of Made in Italy, and export relationships worldwide.

Fratelli Zucchini does not mean just "glue", but Gluing Solutions: our strength is the undisputed quality of our products, indissolubly supported by the know-how and expertise of our Technical Assistance, able to fully understand the request of the Customer and to evaluate with him the best solution in order to satisfy its needs concerning products, process and performances.

The R&D Lab, thanks to the firm commitment to research and to the attention focused on Customers' needs, is able to offer answers even to the technically most progressive requests or tailor made solutions for each specific need.

Our standards meet the strict requirements of our Quality System, certified according to ISO 9001 and applied to the whole industrial process, from the birth of the new formula, to the prototyping in our labs, to its final production and to all after sales services.

Abreast of the most updated requirements about environmental protection, Fratelli Zucchini is able to offer both traditional adhesives (solvent based) and a whole range of adhesives absolutely devoid of solvent (water based), which can be used in closing room assembly works, lasting of uppers and sole-upper bonding, granting a production under European mark Ecolabel.





## FOOTWEAR PRODUCTS

Our contribution to the footwear market for a complete answer to every problem

- experience and constant commitment to research
- long term quality and fine performance
- ability to sense the needs of the customer
- expert and efficient technical assistance
- the largest range of adhesives, primers and auxiliaries

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## POLYCHLOROPRENE ADHESIVES













The resin content gives them a yellow color, from light amber to pale yellow or dark amber. They allow cold bonding of natural materials and, sometimes, of vulcanized rubbers. They are NOT suitable for gluing oily leathers, for which polyurethane adhesives are recommended.

PRODUCT	DESCRIPTION	% SOLIDS CONTENT	VISCOSITY mPas	USE
<b>49/BCF</b>	adhesive for insole factories, high tack, long open time, specific for bonding cellulosic insoles on cardboard (also one way)	23-27	2000-2600	
<b>CZ/108/R</b>	two-part adhesive suitable for bonding leather uppers to thermoplastic rubber soles or wedges	21-23	2100-2500	
<b>599/S</b>	adhesive with high tack and long open time, suitable for bonding soft polyurethane foams and latex to themselves	15-18	300-500	
<b>5360</b>	one-part adhesive for lasting of uppers, fast drying time, low tack, excellent resistance to oven temperature for uppers ironing	22-24	2100-2500	
<b>5362/L</b>	one-part adhesive suitable for bonding uppers to soles, high green strength and medium open time, high resistance to temperature	22-26	2500-2900	
<b>8000/N</b>	two-part adhesive with long open time and high tack suitable for cold bonding of leather or vulcanized rubber soles to uppers	22-24	1800-2200	
<b>8000/N/E</b>	two-part adhesive with high green strength and high tack suitable for cold bonding of leather or vulcanized rubber soles to uppers	20-24	2000-2400	
<b>8000/N/LB</b>	two-part adhesive with long open time and high tack suitable for cold bonding of leather or vulcanized rubber soles to uppers. High solids content and viscosity, it is particularly suggested for bonding very porous materials	23,5-25	2800-3200	
<b>8000/N ANTISTATICO</b>	antistatic version of 8000/N. Black	22-24	1800-2200	

**CLOSING ROOM ASSEMBLY**  
**SOLE / UPPER BONDING**  
**LASTING OPERATIONS**

## POLYCHLOROPRENE ADHESIVES





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PRODUCT	DESCRIPTION	% SOLIDS CONTENT	VISCOSITY mPas	USE
<b>9000</b>	one-part adhesive suitable for bonding leather uppers to leather soles, high green strength and tack.	22,5-23,5	2400-2600	
<b>9000/F</b>	Due to its high temperature resistance, it is suitable for lasting operations too	21-23	2100-2500	
<b>9204</b>	light not yellowing adhesive for closing room assembly, high tack, long open time, particularly resistant to yellowing and therefore suitable for assembling light materials. It needs to be applied onto both sides	20-24	2100-2600	 
<b>9207 TENAX</b>	light not yellowing adhesive for closing room assembly, high tack, long open time, high green and final strength, particularly resistant to yellowing and therefore suitable for assembling light materials. It needs to be applied onto both sides	22,5-24	2600-2800	 
<b>9300</b>	one-part adhesive suitable for bonding leather uppers to leather soles, high green strength and long open time.	22-24	2400-2600	
<b>9300/F</b>	9300/F version is suitable for application by roller spreader	21-23	1800-2200	
<b>9400</b>	one-part adhesive for closing room assembly, high tack, long open time, clear, non staining, it forms an elastic film and doesn't stiffen the substrates. Also one way	26-28	3200-3600	 
<b>9400/BCF</b>	one-part adhesive for closing room assembly, medium viscosity, high tack, long open time, clear, non staining, it forms an elastic film and doesn't stiffen the substrates. Also one way	23-27	2000-2600	 
<b>9500/NV</b>	one-part adhesive for closing room assembly, high tack, long open time, it doesn't stiffen the substrates. Very clear colour. Suitable for lasting operations of "ideal" shoes	22-25	2400-2800	 

**CLOSING ROOM ASSEMBLY**  
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## POLYCHLOROPRENE ADHESIVES

The resin content gives them a yellow color, from light amber to pale yellow or dark amber. They allow cold bonding of natural materials and, sometimes, of vulcanized rubbers. They are NOT suitable for gluing oily leathers, for which polyurethane adhesives are recommended.

PRODUCT	DESCRIPTION	% SOLIDS CONTENT	VISCOSITY mPas	USE
<b>9600</b>	one-part adhesive for closing room assembly, high tack, long open time, clear and not staining, it doesn't stiffen the substrates	22,5-25	1800-2200	
<b>9800</b>	one-part adhesive for closing room assembly, very prolonged tack, long open time, clear and not staining, it doesn't stiffen the substrates. It can be applied also by roller spreader after a light dilution through Solvente AP	min 29	4000-5500	
<b>9901/HT</b>	one-part adhesive suitable for bonding leather uppers to leather soles and lasting works, high heat resistance, high filling property and high tack, specially conceived for later sole bonding at hot. Available also in S (spray) version	22-23,5	2400-2600	
<b>R/900/BIS</b>	one-part adhesive, fast drying, high green strength, excellent resistance to oven temperature for uppers ironing, suitable for lasting operation upper/insole	24,5-26,5	1900-2200	



## POLYURETHANE ADHESIVES

Polyurethane adhesives are suitable for bonding a wide range of materials, also synthetics and oily leathers. This bonding requires heating reactivation.

PRODUCT	DESCRIPTION	% SOLIDS CONTENT	VISCOSITY mPas	USE
<b>X/51/SR</b>	one-part adhesive for bonding synthetics both at cold and at hot	20-22	5000-7000	
<b>X/162</b>	one-part adhesive, high green strength and good hot tack, resistant to leather grease, PVC plasticizers and water. Particularly suitable for sole pre-treatment	17-18	2200-2500	
<b>X/165</b>	one-part adhesive, high green strength and good hot tack, resistant to leather grease, PVC plasticizers and water. Available also in F version, suitable for application by roller spreader or spray equipments, and FS, for spraying	17-18	2050-2350	
<b>X/165/F</b>		15,5-16,5	1400-1600	
<b>X/165/FS</b>		12-14	250-500	
<b>X/165/LB</b>	one-part adhesive, high green strength, resistant to leather grease, PVC plasticizers and water. High hot tack	17,5-18,5	2000-2300	
<b>X/233</b>	two-part adhesive for coverings and closing room assembly, both at cold and at hot	20-22	2700-3300	
<b>XM/B/4</b>	one-part adhesive, high green strength and good hot tack, resistant to leather grease, PVC plasticizers and water. It is particularly suggested for bonding very porous materials	19-21	3500-5000	
<b>XM/81/N</b>	two-part adhesive characterized by excellent penetration onto porous substrates, high hot tack, resistant to leather grease, PVC plasticizers and water. It is also suitable for bonding PVC to leather and synthetics by direct injection	17-19	1800-2100	

**CLOSING ROOM ASSEMBLY**  
**SOLE / UPPER BONDING**






## POLYURETHANE ADHESIVES

Polyurethane adhesives are suitable for bonding a wide range of materials, also synthetics and oily leathers. This bonding requires heating reactivation.

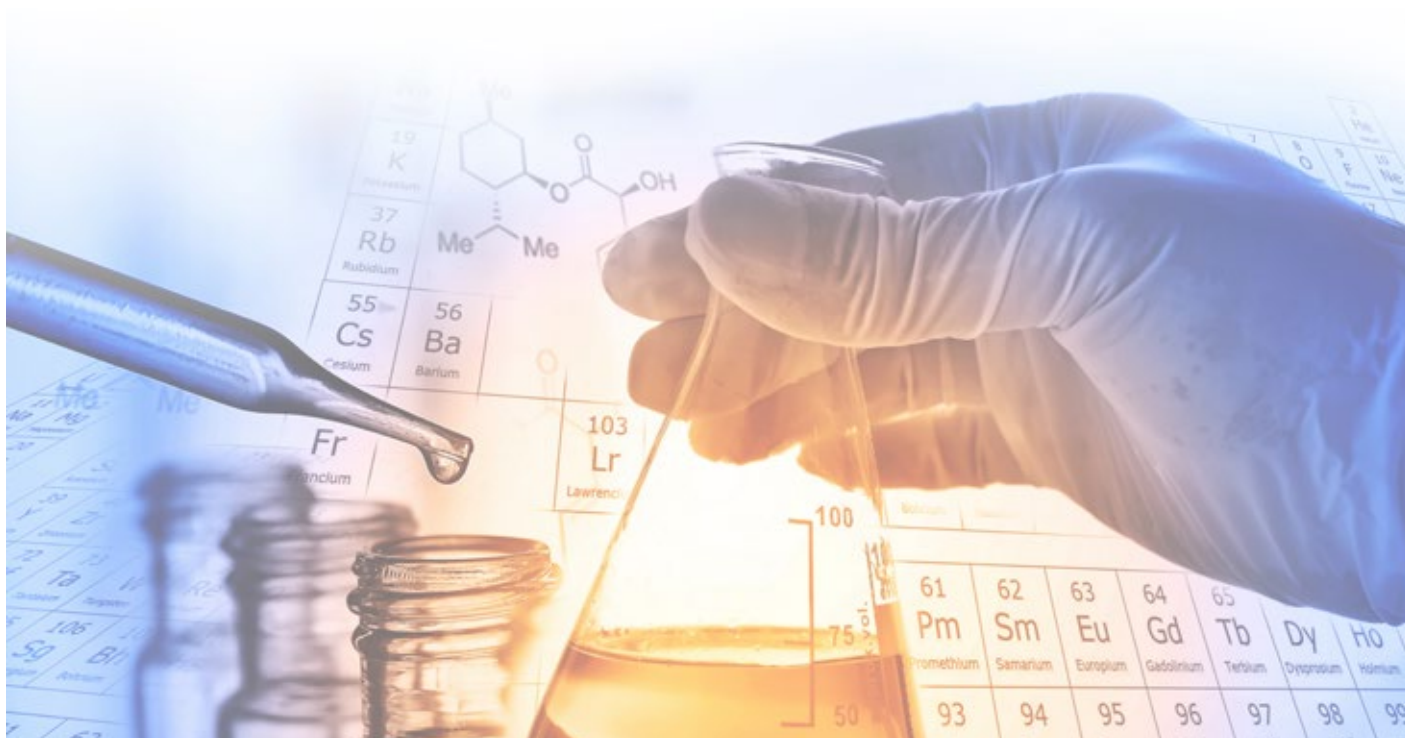
PRODUCT	DESCRIPTION	% SOLIDS CONTENT	VISCOSITY mPas	USE
<b>XM/87</b>	two-part adhesive with high penetration onto porous substrates, high hot tack, resistant to leather grease, PVC plasticizers and water. Particularly suitable for bonding low hardness rubber soles	17-19	1800-2100	
<b>XM/148</b>	one-part adhesive with good hot tack and high green strength, resistant to leather grease, PVC plasticizers and water. It can be applied by roller spreader for uppers. Suitable for PVC sole injection moulding on leather	15-17,5	2000-2300	
<b>XM/148/LB</b>	one-part adhesive with good hot tack and high green strength, resistant to leather grease, PVC plasticizers and water. Fast drying. It can be applied by automatic spreader machine for uppers	14-16	1100-1400	
<b>XM/149</b>	one-part adhesive with good green strength, resistant to leather grease, PVC plasticizers and water. Fast drying and high hot tack	16-18	1900-2300	
<b>XM/149/LB</b>		16-18	2200-2500	
<b>XM/175</b>	one-part adhesive with good hot tack and high green strength, resistant to grease leather, PVC plasticizers and water. Fast drying	16-18	2100-2500	
<b>XM/887</b> <b>ANTISTATICO</b>	one-part adhesive with high green strength, resistant to leather grease, PVC plasticizers and water. ANTISTATIC with conductive additive which promotes the dispersion of electrostatic charges. Black	18-20	2200-2500	
<b>EVX/169</b>	two-part adhesive specific for cementing microcellular EVA pretreated with UV-activated EVX primer	18-19	1800-2000	

## SYNTHETIC RESINS

Elastomer and synthetic resins based adhesives for specific applications.











PRODUCT	DESCRIPTION	% SOLIDS CONTENT	VISCOSITY mPas	USE
<b>CZ/80</b>	adhesive for injection molding of thermoplastic rubber sole to leather or fabric upper. Colorless	28-33	1000-1500	
<b>584/N</b>	adhesive formulated for bonding polystyrene foam, and therefore suitable for those materials, which can be easily damaged by solvent. It can be used at service temperature range from -20°C to +60°C. Available also in S (spray) version	33-42	800-1200	
<b>584/NS</b>		30-40	sec. 35-70	
<b>SD/14</b>	solution of synthetic resins specific for treating leather covers of polystyrene heels by direct injection. EL version, more elastic and flexible, is particularly suitable for high bended surfaces. White	32-35	1000-1200	
<b>SD/14/EL</b>		35-37	600-800	

### CLOSING ROOM ASSEMBLY SOLE / UPPER BONDING











## SOLVENT BASED NATURAL RUBBER ADHESIVES

Adhesives for closing room assembly, particularly suitable for lining/upper bonding, do not modify the flexibility of bonded materials, non-aggressive to synthetic or leather

PRODUCT	DESCRIPTION	% SOLIDS CONTENT	VISCOSITY mPas	USE
<b>3501/E</b>	light adhesive for inner assembly, permanently soft	11-13	3500-5000	 
<b>3502</b>	adhesive for closing room assembly, permanently soft, high tack, long open time	14-17	2500-5000	 
<b>3502/E</b>		11-13,5	4000-6000	 
<b>3504/E</b>	adhesive for closing room assembly, permanently soft, high tack, long open time	16-20	2500-5000	 
<b>3622</b>	adhesive for closing room assembly, permanently soft, high tack, long open time	18-24	4000-7000	 

## WATER BASED NATURAL RUBBER ADHESIVES

Adhesives for inner assembly, they do not stiffen materials, and have a high green strength. At least one of the adherends should be permeable to water

PRODUCT	DESCRIPTION	% SOLIDS CONTENT	VISCOSITY mPas	USE
<b>Z TEX 226</b>	concentrated natural rubber latex, in water dispersion, low ammonia content, after drying the film is permanently smooth and flexible	61	600-1400	  
<b>Z TEX 226 F</b>		min 50	0-100	  
<b>Z TEX 226 LE</b>		60	600-1400	 



### **What does water based adhesive mean?**

Water based adhesives are polyurethane or polychloroprene resins in water dispersion. Bonding takes place by water evaporation, therefore it takes a bit longer than with solvent based products (above all in case of not absorbing or waterproof materials); however the difference disappears in presence of ovens on the conveyor or in warm environments. The dispersion is white, turning transparent when drying.

### **Why should you choose a water based adhesive?**

The yield of a water based adhesive can be more than twice compared to a solvent based one, thus reducing a lot the apparent higher kg/price of the product.

They set at zero the harmful emissions into the atmosphere and the VOC amount.

They allow the elimination of expensive ventilation systems, necessary for using solvent based adhesives.

The frequency of compulsory worker's medical examinations drastically decreases, improving the healthiness of the working environment and reducing costs for the firm.

They reduce waste disposal costs for empty packaging, because they did not contain solvents, therefore they don't need to be disposed as an ADR dangerous waste. (\*)

The new BOX and VITOP packaging reduce even more waste disposal to the inner sac only.





They can be used in closing room assembly works, lasting of uppers and sole-upper bonding, enabling a production under European mark Ecolabel

**For further information, enquiries, gluing tests, do not hesitate to contact us!**

**[www.zucchini.it](http://www.zucchini.it)**












(\*) however they cannot be considered as municipal solid waste

## WATER BASED POLYCHLOROPRENE ADHESIVES

PRODUCT	DESCRIPTION	% SOLIDS CONTENT	VISCOSITY mPas	USE
<b>Z TEX 4427</b>	suitable for bonding leather, fabrics, woven-non woven, felt, and foam to wood, polyurethane, foamed polystyrene. Also one way	53-56	50	
<b>Z TEX 4740</b>	specific for bonding leather or synthetic uppers to leather lining, fast setting	57-59		
<b>Z TEX 4756/LBS</b>	contact adhesive suitable for upper/lining bonding, on both sides, long open time, high cold tack, fast setting, high resistance to hot and dry climate (80°C) when completely dry, good resistance to ageing		50-300	
<b>Z TEX 4756/P</b>			2000-3000	



## WATER BASED POLYURETHANE ADHESIVES

PRODUCT	DESCRIPTION	% SOLIDS CONTENT	VISCOSITY mPas	USE
<b>Z TEX 9605/S</b>	adhesive for bonding upper to lining and leather to polyurethane foam fussbett. It can be applied one way. Fast drying, good contactability at cold, low penetration in porous substrates. It can be used as two-part adhesive for heat resistance applications		< 200	
<b>Z TEX 9627</b>	low viscosity adhesive for sole/upper bonding, or primer for first layer. Two-part	49-51	30-500	
<b>Z TEX 9627/DM</b>	medium viscosity adhesive for sole/upper bonding, second layer, one-part		1000-1500	
<b>Z TEX 9627/HD</b>	high viscosity adhesive for sole/upper bonding, for brush spreading machines, two-part. Primer 9628 recommended on not very porous surfaces		18000-30000	 (M.A.)
<b>Z TEX 9627/M</b>	primer for leather, low viscosity, one-part, suitable for sticking by direct injection PVC and TPU to leather and fabrics, it improves the tear strength of leather, used in combination with 9627/DM creates a good system for high temperature and hydrolysis resistance bonding	48-50		
<b>Z TEX 9628</b>	low viscosity primer for leather, two-part, it improves the tear strength of leather, compatible with solvent based PU adhesives	40		
<b>Z TEX 9629</b>	adhesive for heat sealing the 45° cuts of moccasins	41	1100-1600	
<b>Z TEX 9630</b>	one-part adhesive suitable for bonding at hot or cold, leather and synthetic linings and insoles, perfectly crystal-clear, it can be applied by roller machine	34-37	100-700	 
<b>Z TEX 9631</b>	medium viscosity adhesive for leather and synthetics, two-part	50	1300-2500	
<b>Z TEX 9631/DM</b>	medium/high viscosity adhesive for leather and synthetics, one-part, high temperature and hydrolysis resistance		1300-2000	


**CLOSING ROOM ASSEMBLY**  
**SOLE / UPPER BONDING**

## PRIMERS

Primers modify chemically the surface and make it compatible with the adhesive, but they do not replace washing operations needed in presence of surface contamination elements like releasing agents or plasticizers.

PRODUCT	DESCRIPTION
<b>PRIMER AC/20 (A) POLVERE AC/20 (B)</b>	two-part halogenating primer for treating SBS (TR) rubber soles and vulcanized SBR soles. Product life almost unlimited, until the two parts are not mixed. After mixing, use immediately. It can be applied by brush
<b>PRIMER AC/23 M</b>	one part halogenating primer for treating SBS (TR) rubber soles and vulcanized SBR soles. Ready to use, it can be applied by fully automatic spray machinery and by brush
<b>PRIMER C</b>	two-part primer to improve the adhesion of PU adhesives on oily leathers; it can be used as adhesive for two-part polyurethane foaming on synthetics and TPU direct injection
<b>PRIMER DV</b>	two-part primer to improve the adhesion of PU adhesives on oily leathers; very liquid, to increase the penetration. It can be used as adhesive for polyurethane foaming on synthetics and TPU direct injection
<b>PRIMER M/51</b>	primer to improve the adhesion of polychloroprene glues to solid polyolefins based plastics
<b>PRIMER RA/66 (PARTE A + PARTE B)</b>	two-part primer to improve the adhesion of 8000/N to metal and metallized surfaces
<b>PRIMER RT PRIMER RTS</b>	two-part primer to improve the adhesion of polyurethane glues to nylon and similars. Available also in RTS version for nylon with longer molecular chain
<b>PRIMER 110/P/E</b>	primer for polystyrene
<b>PRIMER 144/F</b>	two-part primer for leather for polyurethane adhesives
<b>PRIMER 540/E</b>	two-part primer for leather for polychloroprene adhesives
<b>PRIMER 705</b>	primer to improve the adhesion of polychloroprene glues to thermoplastic EVA. Recommended to cover wedges
<b>PRIMER 858</b>	stiffener impregnant for fabrics and leather, thermoformable, it can also be used as light toe on fabrics
<b>PRIMER 8200</b>	two-part primer for roughed microcellular EVA
<b>PRIMER EVX 3513 PRIMER EVX 3515</b>	UV-reactivable primer for treating microcellular EVA before bonding with polyurethane adhesive EVX/169

## SOLVENTS & THINNERS

PRODUCT	DESCRIPTION
<b>SOLVENTE AP</b>	thinner for polychloroprene adhesives
<b>ST/120</b>	cleaner to remove traces of adhesive from uppers without demaging leather and synthetic finishing
<b>ST/121</b>	thinner for polyurethane adhesives
<b>ST/133</b>	thinner for SD/14 and SD/14 EL and polyurethane adhesives in application by machine
<b>ST/141</b> <b>ST/142</b>	cleaner for rubber, polyurethane soles and synthetic uppers. Cleaner for tools and roller machine. Thinner for PU adhesives
<b>ST/198</b>	cleaner for rubber and plastics
<b>ST/216</b>	cleaner for polyether soles

## VULCANIZING AGENTS

Vulcanizing agents, added at the proper rate by weight, improve bonding heat resistance and the adhesion to many materials.

PRODUCT	DESCRIPTION
<b>K/E</b>	specific for primer RT/RTS and adhesives for nylon
<b>VKD</b>	specific for water based adhesives
<b>VKL/50</b>	specific for polyurethane adhesives, low reaction speed
<b>DESMODUR RC</b> <b>ATTIVATORE H</b>	for polyurethane adhesives, colorless, medium reaction speed
<b>DESMODUR RFE</b>	for polyurethane and polychloroprene adhesives, amber color, high reaction speed

## OTHERS

PRODUCT	DESCRIPTION
<b>NERO GT</b>	black color for adhesives, available also in concentrated version GC
<b>UV MARKER</b>	UV rays detector for halogenating primers
<b>STIK 85</b>	hot melt adhesive sticks to be applied with proper electric gun
<b>E.S. 810 N</b>	hot melt adhesive in grains to be applied with proper electric gun
<b>MS CLEAR</b>	sealant adhesive based on MS polymer suitable for bonding rhinestones and strasses. Viscous liquid consistency. Solventless, therefore it does not damage substrates. Lightly opalescent. Packaged in cartridge. Moisture curing
<b>MS CRISTALLINO</b>	sealant adhesive based on MS polymer suitable for bonding rhinestones and strasses. Paste, thixotropic consistency. Solventless, therefore it does not damage substrates. Absolutely crystal-clear. Packaged in cartridge. Moisture curing
<b>MS SUPER</b>	sealant adhesive based on MS polymer suitable for bonding of plastics (among which some mixtures of ABS and SEBS) previously treated with primer and tested. Moisture curing
<b>MS SPRAY F</b>	sealant based on MS polymer suitable for stitching waterproofing. Moisture curing. Spray application with proper electric gun
<b>EVERGREEN 1666</b>	hot melt adhesive with permanent tack, packaged in pillows, it can be applied both with roller machine, spray and bead dispenser

## ACCESSORIES

**MEASURING CUP FOR VULCANIZING AGENT**






**TAP FOR AC/23 M JERRY CAN**

**TAP FOR VITOP - CONNECTOR S**







**ELECTRIC GUN FOR MS SPRAY F**

**TNT OVERALL**




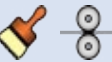
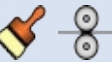
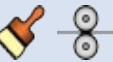




**COTTON OVERALL**

UPPER SOLE			POLYCHLOROPRENE ADHESIVES									
			SOLVENT BASED									
			5362/L	8000/N (*)	8000/N/E	8000/N/LB	9000	9000/F	9300	9300/F	9901/HT	CZ/108/R
SUBSTRATE	PREPARATION	PRIMER SOLVENT										
leather	rough + primer	540/E	0	•	•	•			0	0	0	
oily leather												
split leather	rough + primer	540/E	0	•	•	•			0	0	0	•
leather (or textile)	rough			•	•	•						
thunit	rough (sheet)			•	•	•			0	0	0	
microcellular rubber	rough (sheet)			•	•	•						
microcellular EVA	rough (sheet)			•	•	•						
vulcanized rubber	rough			•	•	•						
thermoplastic rubber	wash	ST141										•
natural rubber	wash	ST141 or ST198		•	•	•						
polyurethane, TPU												
PVC, Nylon												
polystyrene												
wood, cork	primer	8200	0	•	•	•			0	0	0	
APPLICATION CHARACTERISTICS OF ADHESIVES												
green strength			3	2	2	2			4	4	2	3
application												
viscosity mPa.s.			2500 2900	1800 2200	2000 2400	2800 3200	2400 2600	2100 2500	2400 2600	1800 2200	2400 2600	2100 2500
hot tack			2	4	4	4	4	4	4	4	3	1
penetration into porous substrates			2	4	4	4	3	3	2	2	3	2
FURTHER POSSIBLE APPLICATIONS (see corresponding chart in the following pages)												
lasting operations			0								0	
welt bonding											0	
sole industry				0	0	0					0	0
direct injection												0





























(\*) available also in ANTISTATIC version  
• two-part adhesive

UPPER / SOLE			POLYURETHANE ADHESIVES					
			SOLVENT BASED					
			X/162	X/165	X/165/LB	XM/B/4	XM/81/N	XM/87
SUBSTRATE	PREPARATION	PRIMER SOLVENT						
leather	rough + primer	144/F				O	O	O
oily leather	rough + primer	C or DV		O	O			
thunit	halogenating primer	AC/20 or AC/23 M						O
microcellular rubber	halogenating primer	AC/20 or AC/23 M						O
microcellular EVA	primer	EVX 3513						
vulcanized rubber	halogenating primer	AC/20 or AC/23 M	O	O	O	O		O
thermoplastic rubber	halogenating primer	AC/20 or AC/23 M	O	O	O	O		O
polyurethane	wash or rough	ST 141	O	O	O	O	O	O
PVC	wash	ST 141	O	O	O	O	O	O
polystyrene	primer	110/P/E	O	O	O			O
nylon	primer	RT or RTS						O
TPU	wash	ST 141	O	O	O	O	O	O
wood cork	primer	DV or C 8200	O	O	O	O	O	O
APPLICATION CHARACTERISTICS OF ADHESIVES								
green strength			3	3	4	3	2	2
application								
viscosity mPa.s.			2200-2500	2050-2350	2000-2300	3500-5000	1800-2100	1800-2100
hot tack			2	2	2	2	3	3
penetration into porous substrates			2	2	2	4	3	3

- first layer of 144/F + vulcanizing agent recommended

POLYURETHANE ADHESIVES									
SOLVENT BASED							WATER BASED		
XM/148	XM/148/LB	XM/149	XM/149/LB	XM/175	XM/887 ANTISTATIC	EVX/169	9627	9627/DM	9627/HD
0	0	0	0	0	0		0	0	0
0	0	0	0	0	0				
		0	0		0		0		
		0	0		0		0		
						0			
		0	0		0	0	0	0	0
0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0		•	•
0	0	0	0	0	0			0	0
0	0	0	0	0	0	0			
					0				
0	0	0	0	0	0	0		0	0
0	0	0	0	0	0	0		0	0
4	4	2	3	4	2	3	2	2	2
									
2000-2300	1100-1400	1900-2300	2200-2500	2100-2500	2200-2500	1800-2000	30-500	1000-1500	18000-30000
2	2	2	2	2	3	2	3	2	2
2	2	2	2	2	3	2	4	3	3

# FURTHER APPLICATIONS

ADHESIVE	APPLICATION	USE	VISCOSITY mPas	NOTES
<b>SOLES INDUSTRY</b>				
<b>8000/N</b>	bonding of rubber, microporous and leather		1800-2200	
<b>9901/HT</b>	bonding of leather and leather board (premilled soles)		2400-2600	
<b>CZ/108/R</b>	bonding of thermoplastic rubber, leather		2100-2500	
<b>INSOLES INDUSTRY</b>				
<b>49/BCF</b>	bonding of cellulose derivatives insole on cardboard		2000-2600	also one way
<b>9400</b>	bonding of sponge and lining in stuffed insoles production		3200-3600	
<b>Z TEX 9605/S</b>	water based polyurethane adhesive, bonding of fussbett		< 200	also one way
<b>UPPERS INDUSTRY</b>				
<b>Z TEX 9629</b>	butt joining of leather, also oily, in moccasin stitching. Heat-sealable		1100-1600	water based polyurethane
<b>858</b>	impregnant and stiffener for fabrics and leather uppers, alternative to light toe		300-700	synthetic polymer
<b>CLOSING ROOM ASSEMBLY</b>				
<b>9400</b>	wedge covering		3200-3600	
<b>9400/BCF</b>	bonding of upper/lining and insoles		2000-2600	
<b>9500/NV</b>	transparent, light, bonding of upper/lining and insoles		2400-2800	
<b>9600</b>	bonding of upper/lining and covering		1800-2200	
<b>9800</b>	bonding of upper/lining and insoles		4000-5500	also one way
<b>LB/1071/S</b>	self-adhesive, permanent tack, good cohesion		450-550	
<b>3501/E</b>	natural rubber solution for inner assembly		3500-5000	
<b>3502</b>	natural rubber solution for inner assembly		2500-5000	
<b>3502/E</b>	natural rubber solution for inner assembly		4000-6000	
<b>3504/E</b>	natural rubber solution for inner assembly		2500-5000	
<b>3622</b>	natural rubber solution for inner assembly		4000-7000	
<b>Z TEX 226</b>	natural rubber latex for upper/lining bonding	 	600-1400	available also in F version
<b>Z TEX 226/LE</b>	natural rubber latex for upper/lining bonding		600-1400	
<b>Z TEX 4427</b>	bonding of upper/lining (sponge)		50	water based polychloroprene
<b>Z TEX 4740</b>	assembly of leather or fabrics upper/lining, fast setting			water based polychloroprene
<b>Z TEX 4754</b>	immediate setting, for very absorbent materials, one-part or two-part			water based polychloroprene
<b>Z TEX 4756/LBS</b>	assembly of leather or fabrics upper/lining, long open time. Available also in P version		50-300	water based polychloroprene
<b>Z TEX 9630</b>	assembly of upper/lining and bonding of insoles. Perfectly crystal-clear	 	100-700	water based polyurethane

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