Z.TEX 9631

POLYURETHANE ADHESIVE FOR BONDING UPPERS TO SOLES

PRODUCT DESCRIPTION

Z.TEX 9631 is a two part adhesive suitable for bonding at hot leathers and fabrics to PVC, polyurethane, thermoplastic rubbers, vulcanized and halogenated, leather and wood.

TECHNICAL DATA

Composition:	modified polyurethane resin in water dispersion
Mode of setting:	by evaporation of water and reaction with vulcanizing agent
Colour:	dispersion is white, turning to transparent when drying
Solvents:	solventless
Components:	2 part adhesive, to be used in addition of 3 - 5% **ATTIVATORE VKD**
Pot life:	5 hours approx.
Solid content:	50% *
Viscosity (Brookfield sp.5 speed 50 at +25°C):	1.300 - 2.500 mPa.s *

* Values valid as product supply specification upon leaving the factory.

METHOD OF USE

The adhesive must be used in addition to accelerator in the ratio 3 - 5% of weight, then mix carefully.
Mix using a screw agitator mounted onto a rotary device at law number of turns (200 - 300 turns/min.) to eliminate the risk of trapped air foam formation.

Application: apply an uniform coat of product onto both sides to be joined using a brush or a suitable device for water based dispersion adhesives.
For spray application use nozzles diam. 1,9 - 2 mm and pressure 2 - 3 atmospheres.

Drying time: it noticeably depends on the room temperature and humidity as well as on the porosity of substrate.
Before re-activation allow the film turns to transparent.
When completely dryed, usually 30 minutes onto absorbing surface, 45 - 50 minutes onto waterproof surface at +20°C and 50% r.h.
The time can be reduced by heat sources such as hot air.

Assembly: heat reactivate parts at +55°C / +60°C, then assemble under pressure considering 10 - 15 seconds dwell time.
Maximum bond strength of the adhesive is reached in 48 hours.

SAFETY AND HEALTH

See Safety Data Sheet.

STORAGE STABILITY

6 months from the date of manufacture if the product is kept sealed in the original container and stored in a dry place at temperatures between +10°C and +25°C.
The product is affected by frost.

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