

DATI TECNICI

Composition:	polyurethane resin in water dispersion
Mode of setting:	by evaporation of water and reaction with vulcanizing agent
Colour:	Dispersion is white, turning transparent when drying
Solventi:	solventless
Components:	two to be added with 3 - 5% of Attivatore VKD
Viscosity:	3.000 - 4.000 mPa.s (Brookfield gir.4 vel.50 a 25°C)
pH:	neutral

The values in this table must not be considered as specifications
 Desmodur® RFE is Covestro registered trademark.

PRODUCT DESCRIPTION

Z.Tex 9627 HDM is a polyurethane solventless adhesive in water dispersion.

One part, developed for high temperature and hydrolysis resistance bonding.

Z.Tex 9627 HDM is 2K adhesive suitable for bonding at hot of leathers, fabrics, plasticized PVC, thermoplastic rubbers, vulcanized and halogenated.

Formulated for application by brush, or roller device.

20° C and 50% r.h. film turns transparent in about 30 minutes when porous substrates are involved and in 45 to 50 minutes with non-porous materials. Drying time can be noticeably reduced by heat.

Assembly: Heat reactivate parts to 60-70° C then assemble under pressure considering 10-15 sec dwell time.

Maximum bond strength value is reached after 48 hours.

SAFETY AND HEALTH

See Safety Data Sheet

METHOD OF USE**Sole preparation:**

- **Leather soles, vulcanised rubber, thermoplastic rubber:** pre-treat with halogenating Primer **AC/20** or **AC/23/M**. If the surface is contaminated by release agents it is recommended to solvent wipe with ST/141 or to rough.
- **Soles of PVC and soles of polyurethane:** solvent wipe with Solvente ST/141.
- **Leather soles:** have them roughed in deep.

Upper preparation:

- **PVC uppers:** solvent wipe with Solvente ST/141
- **Coated or Coagulated polyurethane uppers:** rough to expose the fabric underlayer.
- **Leather uppers:** rough in deep. The adhesive is not suitable for oily leather. Onto very low porous surfaces it is suitable to use **Primer 9628** added with 3-5% of **Attivatore VKD**, as first coat. (drying time 10'). With grease leather it is recommended the use of **Primer C** or **Primer DV** in addition of 3% of **Desmodur® RFE** (drying time 15').

Application of adhesive: apply an even coat of adhesive on to both surfaces to be assembled, using a brush or any other spreading equipment suitable for adhesives in water dispersion.

Drying time: it noticeably depends on the temperature and humidity as well as on the porosity of substrate.

Allow the adhesive film to turn from white to transparent before submitting it to heat reactivation. At a temperature of

STORAGE STABILITY

6 months in the original container. Keep in a dry place at a temperature range between +10°/ +25° C.

The product is affected by frost

PACKAGING

Code	Pack	Unit
1101024	Drum 10 kg	-
1101025	Vitop 10 kg	-

Other sizes available upon request

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