



## **Technical Data Sheet S42 PU ADHESIVE**

### **DESCRIPTION:**

Solvent based Polyurethane Adhesive specially designed for the footwear industry. This adhesive has a very high heat, hydrolysis and oils resistance. It develops an excellent initial and final strength. Some recommended applications:

Upper material: All type of leather, synthetic and natural fabrics, PVC, PU, etc...  
Sole material: Leather, TR, PVC, PU, Rubbers (NR; CR; SBR...)

You can add a 5-10 % of Desmodur RFE, RC (Bayer AG) to this adhesive in order to improve its adhesion properties, crystallization speed, temperature resistance, etc.

### **GENERAL PROPERTIES:**

POLYMER: Polyurethane.  
SOLVENT: Ketones mixture.

SOLIDS (%):  $16.0 \pm 0.5\%$

VISCOSITY:  $2500 \pm 300$  cps. Brookfield LTV a 20 r.p.m. sp. 3 a 25 °C.

APPLICATION: Manual (brush) or roll machine.

DRIED TIME: Rapid, 10-15 minutes, related to the materials, temperature, humidity...

ACTIVATION TEMPERATURE: 55 - 65° C.

STORAGE: 6 months in the original container, closed staunchly. It is necessary preserve the adhesive of temperatures lower than 4°C. At these temperatures, it will tend to freeze.

NOTE: Due to the constant variations concerning quality and/or different materials used in the footwear industry, it is advisable the employment of this adhesive in two components system (ADHESIVE 29-CR/4 + Desmodur), so the adhesion and mechanical properties of the adhesive are considerably increased.

## RECOMMENDED SURFACE TREATMENT

### UPPER MATERIAL:

LEATHER: Roughed until the corium or central part of the leather.

PU covered leather: Roughed or washed with solvent *HL*.

PVC covered leather: Roughed or washed with solvent *AC*.

FABRICS: These materials are absorbent; it's recommended the application of two adhesive coats or a primer coat with our *Primer 106*.

### SOLE MATERIAL:

LEATHER: Roughed. Sometimes, when the materials structure is low, or the leather was very absorbent, it is necessary to prime with our product *Primer 106* before the adhesive application.

PVC: Wash with our solvent *AC* or *AF*. Let to dry at least 10 minutes before the adhesive application.

TR (SBS): Halogenation with our products *HALOGENANTE P*. Let to dry at least 20 minutes before the adhesive application.

RUBBERS (NR; CR; SBR; NBR...) Roughed and halogenated with our product *HALOGENANTE - P*. Let to dry at least 20 minutes before the adhesive application.

PU: Roughed. In occasions where could not be roughed, apply the *Primer P-128*, and when dry (20 minutes approximately) apply the adhesive.

EVA COPOLYMER: Roughed and primed with our product *Primer-104 + 5% Desmodur RFE*, when dry (20 minutes approximately) apply the adhesive.

Sometimes, for some kinds of expanded EVA with very difficult adhesion, it is necessary to apply special primers as *EVA-148*, mainly I when it is not possible to rough the EVA.

The advice who include in this document as well as the verbal information of our Technical Department are correct according to our experience and results in different processes from manufacture, offering itself like collaboration without commitment, since the application and/or use of our products is outside our control. The tests made by our Technical Department do not guarantee the effectiveness of the recommended processes, nor do they exempt to them of its responsibility to verify them in its facilities.