



5390

SOLVENT BASED ADHESIVE

KEY FEATURES

- Footwear adhesive
- Good penetration
- Bonds difficult leather

DESCRIPTION

5390 is a single component synthetic rubber/resin adhesive formulated for use in the footwear industry.

RECOMMENDED USE

5390 has been especially formulated for the bonding of upper and soling materials; it is particularly suitable for bonding "difficult" leathers because of its high degree of penetration.

IMPORTANT

Before embarking on any work involving **5390** the safety data sheet should be carefully studied by those carrying out the work.

METHOD OF USE

SURFACE PREPARATION

- Substrates to be bonded should be perfectly clean dry and free from dust and grease.
- Insole boards normally require no additional surface preparation.
- Leather uppers and soles should be roughened.
- Synthetic uppers should be roughened so as to expose the underlying woven fabric.
- Compounded soling material should either be roughened, or freshly split.

APPLICATION & BONDING

- Stir the adhesive thoroughly.
- Apply an even film of adhesive to both surfaces by brush or roller coater within 24 hours of surface preparation.
- Ensure complete coverage and keep the components apart until the adhesive is dry. Drying time is dependent on conditions but is in the range 45 - 120 minutes.
- The dry adhesive should be reactivated within 7 days of application by heat.
- The reactivation temperature should be 80 - 85°C at this temperature a minimum press time of 10 seconds is required.

BSI STANDARDS



TYPICAL CHARACTERISTICS

Physical form	Moderately viscous liquid
Colour	Off white to amber
Chemical type	Blend of synthetic rubber & resin
Solvent	Ethyl Acetate/Hydrocarbon blend
Viscosity Brookfield RVT 20rpm at 25°C	[mPa.s] Approx. 3250
Total solids content	Approx. 26%
Relative density	Approx. 0.90
Flammability	Highly flammable

PACKAGING

Please refer to Customer Service Department for current pack sizes.

STORAGE

Store in original sealed containers in accordance with the requirements of the petroleum regulations in a dry flameproof area between 5 and 25°C.

SHELF LIFE

At least 12 months from date of manufacture, under the above conditions of storage.

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SMART HELP

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