

CASWELL
396 Adhesive
(Footwear)

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Description:

Long Tack Life Sole Attaching Cement
396 Footwear Adhesive is a pale fawn translucent adhesive with a long tack life. It is formulated as a sole attaching cement and is ideal for application to leather, composition, resin, microcellular and crepe rubbers. It is also used in the leather goods industry and allied trades

Physical Characteristics:

Appearance	Translucent Pale Fawn
Base	Polychloroprene
Viscosity	3000 cps @ 25°C approx
Solid Content	23% approx
Specific Gravity	0.9 approx
Flammability	Highly flammable
Diluent	3939 Solvent
Cleaner	3939 Solvent
Shelf Life (Under Recommended Storage Conditions)	12 months
Any other essential data	

Recommended Usage:

396 Footwear Adhesive can be applied by brush or through-feed cementer / roller coater. A minimum drying time of 1 hour is recommended for uppers, but this can be

reduced by force drying. Since the cement is slow drying, it is normally recommended that soles should be cemented overnight. However, drying times as short as 4 hours can be used under certain conditions. 396 Footwear Adhesive should be reactivated to 70°C-75°C by one way heat, but it is possible to use the cement for cold bonding after approximately 10-15 minutes drying on both surfaces. Bonding should take place under constant pressure for between 10-15 seconds minimum.

Precautions in Use:

Important: For full details please refer to the separate *Material Safety Data Sheet* for this Product

This product is highly flammable. This product is harmful by inhalation. Avoid breathing vapour - use only in well ventilated areas. Confined spaces should be avoided. Avoid excessive contact with the skin during use. Wear solvent resistant gloves and eye protection.

Environmental and Waste Issues:

Solvent-based residues should be disposed of as hazardous waste.

Storage:

Keep away from heat, sparks and flame. Keep container closed. Store in a dry area designated for flammable materials. Keep between 5°C and 30°C.

Important Note:

Because of the variation in materials likely to be handled by prospective users of this product, together with differences in production techniques and ultimate performance required, it is important that this product is thoroughly evaluated under production and end use conditions before being commercially adopted. Such an evaluation should incorporate a reference to ageing and should be repeated if the substrates on which the adhesive is used are changed in any way or are purchased from a different source. It is the customer's responsibility to carry out the appropriate actions during the evaluation of the product for the protection of the environment and for the health and safety of its employees and purchasers of its products. No Caswell & Company Limited employee has any authority to waive or change the forgoing provisions. The above recommendations are made in good faith for the guidance of users and are without liability. Any queries should be referred to our Technical Services Department.