



PA5050E ADHESIVE

SOLVENT BASED ADHESIVE

KEY FEATURES

- Bonds a variety of soling materials
- Fast drying
- Suitable for use on moving track system

DESCRIPTION

Bostik PA5050E is a single part, solvent-borne, polyurethane adhesive used in footwear manufacture.

RECOMMENDED USE

Bostik PA5050E may be used for bonding a variety of correctly prepared soling materials (e.g. PVC, PU, TR etc), to leather, PVC, fabric, poromeric and PU coated shoe upper materials.

Bostik PA5050E is fast drying and is particularly suitable for cementing all types of uppers on a moving track system where drying times may be short.

Bostik PA5050E is therefore suitable in most cases where a single adhesive system is required, but can be used in conjunction with other **Bostik** polyurethane adhesives if preferred.

NOTE: **Bostik PA5050E** should be used with approved soling compounds only. Therefore, before selecting a particular TR soling compound and commencing factory production in quantity, the soling material should be fully tested with the adhesive system to ensure a satisfactory level of adhesion is being attained.

IMPORTANT

Before embarking on any work involving **Bostik PA5050E** the safety data sheet should be carefully studied by those carrying out the work.

METHOD OF USE

- **Bostik PA5050E** may be applied by brush or cementing machine to the prepared surfaces.
- At normal room temperatures drying times of at least 30 minutes for adhesive coated soles* and ten minutes for upper materials are suggested. These times can be reduced by forced drying.
 - ❖ On soft TR materials a minimum drying time of 1 hour is advised.
- A tack retention time (see later) on soles of seven days should not be exceeded if adhesive coated uppers are left over a weekend.

- Bonding is effected using heat and pressure.
 - The adhesive on one of the coated surfaces to be bonded together, usually the soling material, should be reactivated by heating to a temperature of 85 to 90°C, using a modern flash (high intensity) heat activating unit.
 - The upper and the sole are 'spotted' together and placed under pressure in a correctly adjusted sole attaching press.

TACK RETENTION TIMES

Minimum on upper	10 minutes (room temp drying)
Maximum on upper	3 days
Minimum on sole	1 hour (room temp drying)
Maximum on sole	7 - 14 days (sole heated)

N.B. The maximum time of 14 days on soles relates to uppers left for not longer than 4 hours after adhesive coating whilst the lower time of 7 days on soles relates to uppers left for 1 to 3 days.

TYPICAL CHARACTERISTICS

Physical form	Mobile liquid
Colour	Natural (translucent) or Black
Odour	Predominantly Ketonic
Chemical type	Polyurethane solution
Solvent	Mixture of ketones & ethyl acetate
Flammability	Highly flammable
Flash point [closed cup]	In the group -18 to -7°C
Viscosity Brookfield RVT 50rpm at 25°C [P]	Approx. 30
Total solids content [%]	Approx. 18
Relative density	Approx. 0.90
Cleaner	Bostik Cleaner 8 generally for removing excess adhesive and cleaning application equipment

BSI STANDARDS



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PACKAGING

For current pack sizes please contact the Customer Service Department.

STORAGE

Store in a cool, dry, well ventilated flame proof area in the temperature range 5 - 25°C.

SHELF LIFE

At least 12 months closed in original container stored under the above conditions.

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SMART HELP

Please contact your local representative

