



# 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

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

