



# Anglo Adhesives & Services Ltd.

INDUSTRIAL ADHESIVE MANUFACTURERS - CONTRACT FILLING AND PACKAGING

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## TECHNICAL DATA SHEET

### SOLIBOND 949

#### DESCRIPTION

High quality, single component, polychloroprene, contact adhesive having a versatile range applications. Particularly suitable for bonding plastic laminates and decorative hardboards to various building materials. In the footwear trade it is suitable for bonding leather, fabric and poromeric uppers to resin rubber, micro cellular and most composition rubber soiling materials. It has good heat resistance and is eminently suitable for footwear to be exported to tropical or semi-tropical conditions. 949 conforms to M.O.D. Specification AFS 1614.

#### SPECIFICATION

% Non Volatiles, w/w:	24 to 28
Viscosity, Brookfield RVT, Spindle 4, Speed 20, 20°C:	4200 to 5000cps
Weight per Litre:	0.85 to 0.88kg
Flammability of Dry Film:	Fire Retardant
Drying Time:	5 to 30 Minutes
Open Assembly Time:	up to 45 Minutes
Service Temperature Limits:	Minus 5 to 70°C

#### CLEANER

No. 1 Neoprene Solvent (Refer to Data Sheet)

#### APPLICATION

##### GENERAL USAGE

Stir the adhesive thoroughly before use. Ensure that the surfaces to be bonded are clean, dry and free from contaminants. Apply a uniform coat of adhesive to both surfaces by means of a brush or serrated spreader and allow to dry for approximately 5 to 10 minute. Position coated surfaces accurately and press firmly together. Mechanical pressing, even of very short duration, will always give superior results.

##### FOOTWEAR TRADE

Prepare leather/poromeric uppers by wire brush roughing. Soiling materials can either be roughed or treated with Solewipe A. Apply 949 adhesive to both upper and sole components by hand or cementing machine. Coated soles and uppers can be cold bonded for up to 30 minutes or by one way heat activation of either component to 75 to 85°C soles within 3 days of application of adhesive.

##### SHELF LIFE

6 months when stored in dry conditions, in unopened containers, between 5 to 30°C

##### PACKAGING

Supplied in 5, 25 and 205 litre containers