

All bonds were made to 1" x 5" strips of cotton duck. These were then aged for 72 hours at 120°F before being pulled on a Scott Tensile Tester at 2"/min.

Surface Preparation	Levels	Type of Failure
Thin Country Sole		
3703/3213/2406	10-15#	Spotty sole tear
Rough/3213/2406	15#	Spotty sole tear
Thin Country Heel		
As is/3213/2406	17-20#	Rubber tear
3703/3213/2406	10-17#	Spotty rubber tear
Rough/3213/2406	20-25#	Rubber tear
BARKLA 36 Sole		
As is/3213/2406	10-30#	Spotty rubber tear
3703/3213/2406	10#	Adhesive peeled from rubber
Rough/3213/2406	27#	Rubber tear

Comments: Best system for all rubber pieces was to rough, chlorinate with 3213, then topcoat with a polyurethane adhesive. In some cases roughing may not be necessary for adequate bonds, but roughing showed more consistency. Difference in bond values and tear between thin Country sole and heel is due to softness of sole vs. heel- resulting in bond shear when pressure was released on thinner sole. 2406 is a good all - purpose PU adhesive put any PU sole-attaching adhesive can be used over chlorination.

Reported by Barbara Strickland

IMPORTANT NOTED: UPACO believes the information on this sheet to be reliable but does not guarantee its accuracy or completeness
 Conduct your own tests of this product the only obligation of UPACO nor its distributors shall be libe for any injury, loss or damage
 direct or consequential, relating to the use or inability to use this product. Except as expressly provided above, all product are sold
 and sample furnished without any warranty of merchantability or any other warranty, express or implied