Technical Department

Bonding Process

Costumer	LACTAE HEVEA
Nº	

Model	LATEX SOLE to LEATHER

Materials to Test			
Sole	LATEX	Upper:	LEATHER
Heel/Midle-sole		Welt:	
Inner sole		Wedge heel:	

Bonding Process

Surface preparation*:*

Sole	Mechanical abrasion followed by a Chemical abrasion with the halogen HALINOV 2189 or 2190 (wet the surface well and rub intensively with a brush with short hair). Let it dry for at least 1 hour.
Upper	Mechanical abrasion, then apply the primer PLASTIK 6271 with 5% of the hardener CIPADUR 2230-T and let it dry for around 15/20 minutes.

Bonding

1- Apply on the surfaces the adhesive – PLASTIK 2074-A With 5% of hardener CIPADUR 2230-T

2- Leave the adhesive films to dry for – 15/20 minutes,

3- Proceed with the films reactivation: 40/50 ºC

4- Straight after the adhesive films reactivation, join the both surfaces and press them for around 4/5 Bars, for 14/16 seconds.

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Technical Department

Bonding Process

Costumer	LACTAE HEVEA
Nº	

Model	LATEX SOLE to LEATHER

Materials to Test			
Sole	LATEX	Upper:	LEATHER
Heel/Midle-sole		Welt:	
Inner sole		Wedge heel:	

Bonding Process

Surface preparation*:*

Sole	Mechanical abrasion followed by a Chemical abrasion with the halogen HALINOV 2189 or 2190 (wet the surface well and rub intensively with a brush with short hair). Let it dry for at least 1 hour.
Upper	Mechanical abrasion.

Bonding

1- Apply on the surfaces the adhesive – CIPAQUA 6523 With 5% of hardener CIPADUR 4203

2- Leave the adhesive films to dry for – UNTIL THE ADHESIVE FILM IS TRANSPARENT.

3- Proceed with the films reactivation: 60/70 ºC

4- Straight after the adhesive films reactivation, join the both surfaces and press them for around 4/5 Bars, for 14/16 seconds.

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