

PRODUCT DATA

Date: July 2013

Information Sheet No.: TDS01464-01

EVO-STIK 3140

SOLVENTED ADHESIVE

EVO-STIK 3140 is a single component, high heat resistant polyurethane adhesive formulated to give good adhesion to most materials used in the footwear industry. It has good water resistance, excellent green strength and spotting tack, combined with a fast drying solvent for high speed production on modern track systems.

RECOMMENDED USE

EVO-STIK 3140 is used for bonding soling materials such as leather, resin rubber, polyurethane, PVC and thermoplastic rubber to most commonly used upper materials.

EVO-STIK 3140 is especially suitable for men's and sports footwear, particularly when bonding nylon soles, where resilience of the soling material can cause "gaping" at the feather edge.

BONDING INSTRUCTIONS

SURFACE PREPARATION

- Substrates to be bonded should be perfectly clean dry and free from dust, grease and other contaminants.
- Preparation for Uppers:

Leather	Rough well, removing all pigment
PVC	Rough lightly or wipe with solvent
Poromerics	Rough lightly with a synthetic brush
Suede	Rough lightly
Coated Fabrics	Rough away synthetic coating and solvent wipe
Denim or Canvas	Prime or apply two coats of EVO-STIK 3140
- Preparation of Soles:

Leather	Rough well, prime or apply two coats of EVO-STIK 3140
Normal PVC	Wipe with solvent
Resin Rubber	"Lacsol" scrub or "Satreat"
Microcellular	"Lacsol" scrub or "Satreat"
Gristle Rubbers	Rough and/or "Satreat" solvent wipe
Expanded PVC	
& Polyurethane units	Lightly rough away top skin of bonding area
Thermoplastic Rubber	Brush apply "Satreat"
Crepe Rubber	Brush "Satreat" well into surface

APPLICATION

- **EVO-STIK 3140** may be applied by brush; roller coater or automatic cementing machine.
- An even coat of adhesive should be applied to both surfaces to be bonded and the solvent allowed to evaporate.
- Normal drying time 10 - 15 minutes, but dependant on conditions.

BONDING

- The soles or uppers should be reactivated to a temperature of not less than 80°C and pressed at 80psi for 10 - 15 seconds.
- Soles may be pre-coated with adhesive up to 7 days prior to bonding provided a fresh coat of **EVO-STIK 3140** is applied to the uppers immediately before bonding.

GENERAL PRECAUTIONS

- Do not add anything to the adhesive to modify its properties.
- After each use, close the container tightly in order to avoid solvent evaporation.

TYPICAL CHARACTERISTICS

Physical Form:	Liquid
Colour:	Pearl/Clear or Black
Chemical Type:	Polyurethane
Solvent:	Ketone blend
Viscosity (Brookfield RVT, 20rpm at 20°C):	Approx. 3700 mPas
Solids Content:	Approx. 17%
Specific Gravity:	Approx. 0.86
Flammability:	Highly flammable
Flash Point	Approx. -17°C

PACKAGING

For current pack sizes please contact the Customer Service Department

STORAGE

Store in a dry flameproof area between 5 and 25°C. Material will gel at <5°C.

SHELF LIFE

6 months in its original container stored under the above conditions.

MATERIAL SAFETY DATA

For further information refer to the relevant Health and Safety Data Sheet.

Disclaimer - please read carefully

This disclaimer is issued by Bostik Limited ("the Company") and applies to the use of any products supplied by the Company ("the Products") displayed on this Technical Data Sheet ("TDS"). Please read this disclaimer carefully before using any of the Products. Using this TDS and/or the Product constitutes your acceptance of this disclaimer. Its contents shall prevail over any directions of use and any disclaimer and/or exclusion or limitation of liability of the Company which may appear on the packaging of the Products.

This disclaimer sets out the entire financial liability of the Company (including any liability for the acts or omissions of its employees, agents and sub-contractors) to any user of the Products ("Product User") in respect of any use made or resale by the Product User, of any of the Products in this TDS.

This disclaimer does not affect the Company's liability for death or personal injury arising from the Company's negligence in respect of the Products, or its liability for fraud, or fraudulent misrepresentation, or any other liability which cannot be excluded or limited under applicable law.

The Company's total liability however arising and whether caused by tort (including negligence and breach of statutory duty), breach of contract or otherwise, arising in connection with the use made or resale by the Product User of any of the Products in this TDS shall be limited to the price paid for the Product by the Product User.

The Company shall not be liable to the Product User for any pure economic loss, loss of profit, loss of business, depletion of goodwill or otherwise, in each case whether direct, indirect or consequential, or any claims (including in respect of personal injury insofar as not caused by the Company's negligence) for consequential compensation whatsoever (howsoever caused) which arise out of or in connection with the use made or resale by the Product User of any of the Products in this TDS.

The Company shall not be liable to the Product User in relation to any loss for any use which is inappropriate or use which is otherwise than in accordance with the relevant instructions for use of the Products in this TDS or on the Product. Product Users are advised to confirm the suitability of the Products by their own tests.

This TDS covers just one of a large range of products supplied by the Company. Full information on these products and advice on application is freely available from our fully trained staff throughout the country. In addition, specialist technical advice is available from our Technical Services Department. This TDS supersedes all previous TDSs relating to the Products and users of it must ensure that it is the current issue. Destroy all previous TDS, and if in any doubt, contact the Company, quoting the code number in the top right hand corner on the front of this document.

Bostik Limited, Ulverscroft Road, Leicester, LE4 6BW England. Tel: +44 (0)1785 272625 Fax: +44 (0)1785 272867

www.Bostik.co.uk