Technical Data - Renia Aquilim 315

Polychloroprene-based adhesive dispersion for all materials used in shoes/insoles: leather, rubber, cork, natural rubber, PUR, EVA, textile, felt, metal, wood, etc. PVC and outer soles in general cannot be bonded without crosslinker.

Technical data

Color:	white	Viscosity [mPa·s]:	2000	Density [g/l]:	1000
pH-Value:	6 - 7	Solid Content [%]	52	Drying time [min]:	20 - 40
Pressure [bar]:	1 - 5	Reactivation temperature [°C]:	60 - 70	Open time [h]:	8
Temp.resistance [°C]:	70	peel strength* [N/mm]:	8	React.time [s]:	5 - 60

*determined with test rubber on test rubber, with a drying time of 15 minutes, after the adhesive has fully cured. Value varies with different material combinations, own tests are necessary.

Application

Sand or roughen compact materials. Upper leather, Alcantara, Textile, and expanded/foamed materials can be bonded without preparation (tests necessary, remove grease or separating agents if necessary). The adhesive can be applied by brush, roller or spray system to both parts of a material combination. As soon as the adhesive film has dried (the film becomes transparent), the parts can be fixed and pressed. By applying suitable heat (e.g., placing the coated parts in an oven at 55°C) the drying time of the adhesive film can be reduced to a few minutes. On passing the open time for cold bonding the adhesive films can be reactivated by fast warming up to 60 - 70°C. Aquilim is very tacky and crystallizes quickly. The bonded parts can be handled after a few minutes. The bonding strength increases continously and reaches its maximum after 2 - 3 days. With the addition of 3 - 5% Renia - Hardener A 300 the pot life is 3 - 5 hours.

Thinning/Cleaning

The adhesive can be thinned with water. Adhesive containers and application devices can be cleaned with water. The water can be added to the adhesive in small quantities. Precipitate larger amounts with acid and remove the solids.

Heat/Environment resistance

High heat resistance for a one-component system: 70°C, about 100°C if used with crosslinker.

Storage and Transportation

Minimum shelf life of 12 months at 20°C. The product is very sensitive to freezing. Do not store or ship below 4°C.

Hazard designation

according to CLP, see MSDS.

Packages

Article-Nr.	Package	Net-Contents	Units per Box/skid
450250	0,5 kg can	0,5 kg	18
450403	3,0 kg can	3,0 kg	6
450430	30 kg can	30,0 kg	16