FEVICOL SR 998FW

FOR INFORMATION ONLY

PRODUCT DESCRIPTION
FEVICOL SR 998FW is a synthetic rubber based solvent borne contact adhesive specially developed for Footwear and other allied industries. This is a versatile adhesive and is generally recommended for pasting of soles of heavy duty and high quality footwear.

APPLICATION AREAS
FEVICOL SR 998FW is used to bond variety of substrates encountered in Footwear assembly viz. sole attaching, lasting, upper making, etc. It is used to bond soles made from Microcellular rubber, Neolite / Thulite rubber, Cork rubber, all kinds of Leather, EVA to uppers made of leather, certain synthetic fabrics, split leather, etc.

TECHNICAL DATA:
- **Appearance**: Dark Brown liquid
- **Odour**: Aromatic solvent smell
- **Consistency**: Brushable liquid
- **Specific Gravity**: 0.85 – 0.89
- **Viscosity @ 30 °C**
  - Sp. 3/20 rpm: 20 – 25 Poise
  - (Brookfield RVT)
- **Diluent / Cleaner**: Toluene
- **Flash Point**: 0°C to 4°C
- **Drying time**: 5 – 10 minutes approx.
- **Tack retention time**: 45 minutes minimum
- **Flammability**: Flammable

APPLICATION INSTRUCTIONS:
I) SURFACE PREPARATION
Proper surface preparation is important to get optimum & consistent results. Care should be taken not to contaminate the prepared substrates, before adhesive application.

<table>
<thead>
<tr>
<th>SUBSTRATE</th>
<th>PREPARATION</th>
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<tbody>
<tr>
<td>Upper / Sole Leathers</td>
<td>Roughen</td>
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<tr>
<td>Vulcanised Rubbers</td>
<td>Roughen &amp; Solvent wipe</td>
</tr>
<tr>
<td>EVA</td>
<td>Roughen</td>
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II) ADHESIVE APPLICATION
1) Apply adhesive on both the substrates by brush or appropriate machine.
2) Second coat may be required on porous substrates e.g. Leather, which can be given after 5-10 minutes of first coat.
3) Allow a minimum of 20 – 30 minutes open time. The adhesive after drying exhibits tack. The finger test has proven itself to be a reliable method of judging the OPEN TIME, where as the time only serves as a rough indication, as variance may occur depending upon room temperature, ventilation, relative humidity, type of substrate etc. In the finger test the adhesive must feel dry but still slightly tacky. The substrates bonded after prolonged open time & in absence of tack may result in inferior coalescence & bond strength.
4) After appropriate open time (which is the span between Drying time & Tack retention time, bond both the substrates and give adequate pressure on a pressure device.
5) Even though the instant contact bond strength is sufficient to take care of spring back action between sole & upper, the bond strength builds up further in 24 hrs. to 3 days time.

SAFETY & PRECAUTION: Store under dry condition below 35°C. Since the product is highly flammable, the storage area and shop floor should be restricted from naked flame. Keep the adhesive container lid tightly closed when not in use to avoid unnecessary solvent evaporation from the adhesive. Proper ventilation must be provided on the shop floor. A detailed MSDS shall be available on request.

PACKING
- 1 Ltr, 5 Ltr & 30 Ltr.

NOTE: We recommend that before using our products in full-scale production, the customer should make his own tests to determine the suitability of the products for his own purpose under his operating conditions. As the circumstances under which our products are stored, handled and used, are beyond our control, we cannot assume any responsibility for their use by the customer.