

## **Adhesive CR 3307 CONTACT ADHESIVE FOR BONDING OF LEATHER, RUBBER, PLASTICS.**

### AREAS OF APPLICATION.

Adhesive CR 3307 specifically designed for bonding of natural and artificial leather, sheet rubber and textiles. Recommended for the manufacture and repair of footwear - inner assembly, bonding of soles from sheet rubber, including porous rubber. Applicable in the manufacture and repair of inflatable boats made of rubberized fabric. Has worked well for bonding of stones.

### PROPERTIES.

- High strength and good thermal stability of the assemblies.
- Resistance to hydrolysis (water resistance), acids and mineral oil.
- Good connection flexibility, including at low temperatures.
- Easy to apply.
- High adhesion to most porous bases.
- Short open time and therefore high initial strength of bonding.

### TECHNICAL DATA.

Based	<i>polychloroprene rubber and synthetic resins in organic solvents.</i>
Colour	<i>From pale orange to red</i>
Conventional solids content, %	<i>20 – 22</i>
Viscosity at 20°C, mPa.s	<i>approx. 2500</i>
Density at 20 °C, g/cm <sup>3</sup>	<i>approx. 0.83</i>
Open time at 20 °C, min	<i>10</i>
Bond Strength, N/cm, 24 hour	<i>55 – 65</i>
The time to reach 70% of maximum strength, min	<i>7 – 10</i>
Temperature resistance of the assemblies (adhesive strength not less than 20 N/cm), °C	<i>90</i>
Maximum allowable operating temperature (short-term exposure), °C	<i>125</i>

### PACKAGING.

Metal can 620g (0,8L)	12 units in cardboard box
Conical metal container 2,3kg (3L)	4 units in cardboard box
Conical metal container 16,5kg (20L)	
Cylindrical metal container 40kg (50L)	

### STORAGE.

Storage time 12 months. Recommended storage temperature: 5 - 25 °C. Storage in original containers.

### SAFETY.

Highly flammable and irritant.

This product data sheet is only valid in conjunction with the latest edition of the corresponding Safety Data Sheet. Any updating of safety-relevant information – in accordance with statutory requirements – will only be reflected in the Safety Data Sheet, copies of which will be revised and distributed. Information relating to the current classification and labeling, applications and processing methods and further data Read material safety data sheet before use.

## INSTRUCTIONS FOR USE.

### **Substrates preparation:**

The leather to be assembled must be touse, dust free and not have any traces of grease. Rubber must be dust free and not have any traces of grease. Textile – without processing. All details must be clean and dust free

### **Application :**

Apply a regular layer with a brush or a notched spreader to each substrate. Recommended applying temperature is 18 – 22 °C, humidity 60 - 65%. For highly absorbent surfaces (such as chipboard, gypsum) are recommended double glue application with 10 minutes interval between each application. For non-absorbing – one glue application.

### **Drying:**

Adhesive film should be dried under natural conditions. Minimal drying time depends on temperature and usually near 8 – 12 minutes. The end of drying is easy to identify by touch – adhesive ceases to be tacky.

### **Bonding:**

Press products to each other thermally activated adhesive films, and highly compressed (pressed) or rolled rollers. Leave under load is not needed. Press with 3 – 3,5 kg/cm<sup>2</sup> effort.

Attention. The time between the by compressing and thermal activation must not exceed the open time - this glue - 10 minutes. After 7 - 10 minures adhesive joint strength reaches 70% of its maximum. A further increase in strength occurs slowly during 30 - 40 hours.

## CONSUMPTION.

150 to 200 g/m<sup>2</sup> to each surface depending on substrates. For very porous materials, a higher amount may be necessary.

## PRECAUTIONS FOR USE.

Adhesive CR 3307 cannot be used for bonding expanded polystyrene or untreated polyethylene, polypropylene, fluorinated polymers or plasticised PVC.

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