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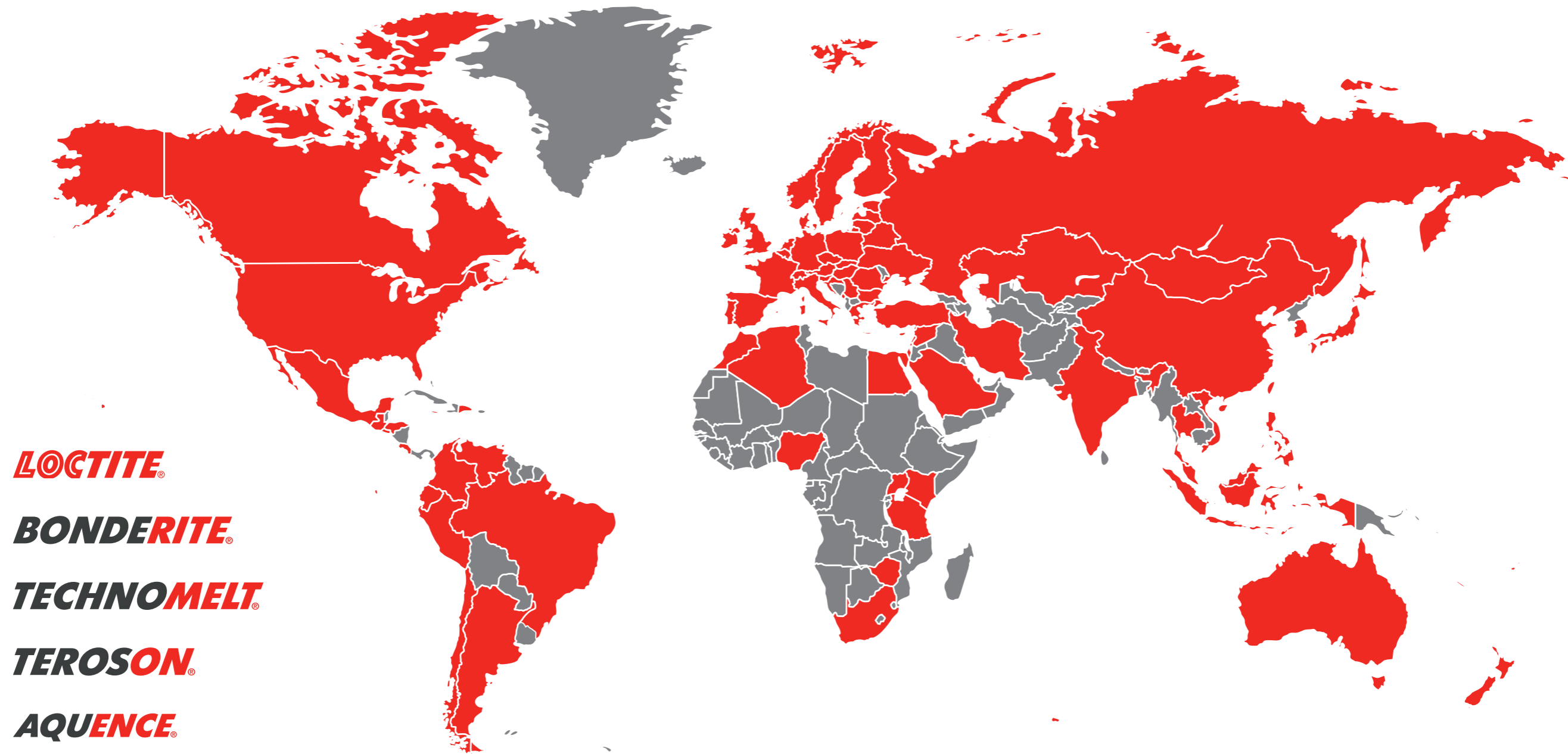
**Adhesive Solutions for
Shoe Bonding Using
Sustainable Technologies**

Henkel

When Leadership Is About Bonding With Responsibility

Henkel, headquartered in Dusseldorf, Germany, has more than 50,000 employees worldwide and counts among the most internationally aligned German-based companies in the global marketplace. People in approximately 125 countries around the world trust in brands and technologies from Henkel. Founded in 1876 by Fritz Henkel, the company today holds leading positions in its three strategic business areas-home care, personal care and adhesives, sealants and surface treatments.

Henkel's vision is to be a global leader in brands and technologies. Innovations are the basis for successfully turning this vision into reality. The key factor behind this is the ability to respond quickly to customer's wishes, to accelerate innovations and to continuously open up new markets with trendsetting solutions.



Sustainability in Shoe Adhesives

Are you seeking a reliable Adhesive Supplier?

Shoes are typically classified into four groups:

Sport Shoes, Dress Shoes, Sandals and vulcanised Shoes.

The unique purpose and speciality of each type of shoe means that many different materials and components are used including conventional leather, poromerics, fabrics rubber, PU coated fabrics, PVC coated fabrics, PVC, CR, EVA, PU as well as numerous other new and advanced synthetic materials. This broad diversity of materials and ability to accommodate many difficult conditions, while providing comfort and long life in indoor and outdoor environments, is impossible without a reliable shoe adhesive. Henkel provides tailor- made products for your factory with the accumulated experience know-how you would expect of a worldwide leader in the Shoe Adhesive Industry.

Innovating for over 50 years

Innovation and Process Improvement are the key to survival for any business, Starting with the development of UV Curing Primer in 1998. our approach to Innovation and Process Improvement has supplied the whole Shoe Industry with safer, cleaner, most cost effective components for bonding. When it was first to successfully commercialize Water-Based PU Adhesive for the shoe industry(1995), develop an environmental-friendly Water-Based Primer for Rubber(1999) and launch PU Reactive Hot Melt in the market(2000). We really demonstrated the difference one most of all your business. It's acquisition by Henkel Adhesive Technologies in 2008 highlighted our standing within the Shoe Industry and ensured that it will remain a World Leader in years to come.



Cleanest, Greenest and Safest

Never before have our customers been more aware of the impact industry has on the people that live and work in that environment. They expect, if not demand, that industries manufacturing produce for them, are doing it in a responsible, safe and environmentally friendly way. The Shoe Industry has historically used products that have challenged those expectations, relying heavily on products with high concentrations of Volatile Organic Compounds (VOC), both harmful to the environment and the people in the industry manufacturing and working with them. Henkel has continually worked towards developing a safer environment for everyone in the industry and are well aware of the importance of safety. Through the environmental management system(ISO 14001). Henkel continuously puts every effort into making the Shoe Industry a Greener, Cleaner and Safer Industry of the future. By monitoring and actively predicting the impact of our new products on the environment, from the design stage to the application stage we challenge ourselves to be Greener, Cleaner and Safer in the final finished product.

Product Line

Water - Based Adhesives

Water - Based Adhesives uses water instead of harmful solvents to suspend the adhesive so its much less irritating to human skin and non flammable. For some Water - Based Cleaners and Primers that partially contains solvents, we systematically investigate the toxicity and harmfulness of the solvents in order to design safer products. We began our research into Water - Based products in the very early stage of our business and our focused efforts enabled to develop the Water - Based PU Adhesives, Water - Based UV Primers, Water - Based Rubber Primers and Water - Based Cleaners applicable to each shoe - making process.

Solvent - Free Adhesives

Traditional Solvent - Based Adhesives have been applied to numerous types of shoe materials and manufacturing processes for decades and are proven to have exceptional bonding properties. Where customer have continued to demand

Solvent - Based Adhesive we have developed a range of Toluene - Free Adhesives with dramatically low levels of Toluene. Benzene and Xylene content substances, which are all very harmful to the human body, However, Toluene - Free Adhesives maintain the strength and productivity to traditional Solvent - Based Adhesives while enabling you to maintain quality standards and provide a safer environment for your workforce.



Thermoplastic Hotmelt Adhesive

Thermoplastic Hotmelt Adhesive is a 100% solid adhesive without any solvent contents. Using a heated applicator, the adhesive can be precisely applied to the substrate. Thermoplastic Hotmelt Adhesive is suitable for use in temporary fixing for upper stitching, black counter fixing or sock liner lamination. Especially, Henkel has introduced the new EASYMELT packaging system where part of the adhesive works as a release paper so that you can keep clean work environment. With the growing interest in Hotmelt Adhesive Suppliers and in partnership aim to develop even smarter Hotmelt technologies for the future.



PU Reactive Hotmelt Adhesive

PU Reactive Hotmelt Adhesive is a 100% solid adhesive without any solvent contents. Unlike Thermoplastic Hotmelt Adhesive, PU Reactive Hotmelt Adhesive reacts with the moisture in the air and provides great bond strengths similar to other Solvent Based or Water Based PU Adhesive.



Main Product

Water Based Adhesive System

Main Product

Water Based Adhesive System

	Product	Main Component	Application	Viscosity (cps)	Shelf Life (Months)
Cleaner	LOCTITE AQUANCE CL-800A	Water	Cleaner for rubber, general phylon sole, injection phylon sole, polyolefins and other thermoplastic foam. Perfect cleaning effect and help bonding strength increase remarkably by cleaning release agent after demolding.	Below 100	6
	LOCTITE AQUANCE CL-800B	Water	Cleaner for rubber, general phylon sole, injection phylon sole, polyolefins and other thermoplastic foam. Perfect cleaning effect and help bonding strength increase remarkably by cleaning release agent after demolding.	Below 100	6
	LOCTITE AQUANCE CL-811H	Water	General purpose water-based cleaner, also used for cleaning of PU/TPU/PVC sole.	Below 100	6
Lamination Adhesive	LOCTITE AQUANCE L-601	Waterborne Synthetic Emulsion	Mainly used for the textile lamination eg. Nonwoven to Fabric, synthetic leather to fabric in shoe making industry.	6,000-9,000	6
	LOCTITE AQUANCE E - 395	Waterborne Synthetic Emulsion	Used for lamination of Eva-Fabric, Foam - Fabric application	5000-9000	6
Curing Agent	LOCTITE AQUANCE ARF - 40	Polyisocyanate	Curving agent (hardner) used only for water-based adhesives and has good discoloration resistance. Enhances bond strength and heat resistance of adhesive.	Below 100	12
	LOCTITE AQUANCE ARF - 45	Amide Derivative	Curving agent used only for water-based PU adhesives and LOCTITE AQUANCE-651, a water-based primer for die-cut EVE. LOCTITE AQUANCE ARF-45. Remarkably enhances hydrolysis resistance of water-based PU adhesives.	Below 100	12
Primer	LOCTITE AQUANCE D-200	Dispersion of PU	Primer for various upper materials such as buffed leather synthetic leather of vulcanizing shoes. Applied by brushing. It shows good bonding performance and water resistance. Moreover, it has excellent discoloration resistance, which can give the valuable quality to finished shoes.	550-3500	6

Category	Product	Main Component	Application	Viscosity (cps)	Shelf Life (Months)
Primer	LOCTITE AQUANCE SW-7001	PU	1 component water based PU primer for various mid sole, upper and especially suitable for synthetic leathers.	1000-5000	3
	LOCTITE AQUANCE PR-505	Water, Chlorinated Compound	Cleaner for rubber, general phylon sole, injection phylon Chlorinating primer used for vulcanized rubber, RB foam and thermoplastic rubber (TPR).	Below 100	6
	LOCTITE AQUANCE PR-651	PU Derivatives	Water-based primer used for die-cut EVA.	low 100	3
	LOCTITE AQUANCE W-104	PU	PU primer for various mid soles, upper materials and especially suitable for synthetic leathers. It is also used as a reinforcing primer for Phylon.	550-4500	6
	LOCTITE AQUANCE W-105	PU	PU primer for various upper materials. It is suitable for soft leather such as full grain leather, nubuck with its good penetrating property.	50-500	6
	LOCTITE AQUANCE PR-607	PU Derivatives	UV-curing primer used for DC EVA, phylon soles including Compression molded pre-foam (CMP) and Injected phylon. Has excellent bonding performance, yellowing properties and workability to replace Solvent based UV primers on CMP and IP materials.	Below 100	3
Adhesive	LOCTITE AQUANCE W-08	PU	2 - component water-based PU adhesive for various sole and upper materials for stockfit and assembly line. Especially has gone resistance to heat and hydrolysis.	4000-8000	6
	LOCTITE AQUANCE SW-07	PU	One component water-based PU adhesive for various sole and upper materials for stockfit and assembly line. Can be applied to both general heat-drying system and heat-activation system.	6000-20000	3
	LOCTITE AQUANCE	PU	1 component water-based PU adhesive for various sole and upper materials for stockfit and assembly line.	6000-20000	3

Main Product

Water Based Adhesive System

Category	Product	Main Component	Application	Viscosity (cps)	Shelf Life (Months)
Adhesive	LOCTITE AQUANCE C-330	Water-based CR	Sprayable CR adhesive for leather/leather, leather/Foam (Sock-liner, PU Foam or Latex foam) and Insole (cellulose board/ cellulose board). It offers good tack, good initial bonding and heat resistance. Not like other water-based type, it can be dried at room temperature and be able to be attached.	Below 1000	6
	LOCTITE AQUANCE C-350	Water-based CR	Adhesive used for lasting in dress shoe. It is suitable for the adhesion of bonding insole (cellulose board) or mesh board to various upper materials. Also it can be applied on EVA/EVA Bonding for specific EVA.	10000-50000	6
	LOCTITE AQUANCE C-390	Water-based CR	Water-based CR adhesive for leather/Foam (sock-liner, PU Foam or Latex foam) and Insole (cellulose board/ cellulose board). It offers good tack, good initial bonding and heat resistance. Not like other water-based type, it can be dried at room temperature and be able to be attached.	10000-50000	6
	LOCTITE AQUANCE D-2	NR latex	Adhesive for canvas, synthetic leather and buffing leather of vulcanizing shoes. Applied by brushing. It shows outstanding bond strength and water resistance. Moreover, it has excellent discoloration resistance, which can give the valuable quality to finished shoes.	1200-4000	6
	LOCTITE AQUANCE D-20	Modified NR latex	Adhesive for curved or un-cured rubber of vulcanizing shoes. Can be applied by brush or suitable fabrics. It shows outstanding bond strength and water resistance. Moreover, it has excellent discoloration resistance, which can give the valuable quality to finished shoes. Can be substituted for solvent-based NR adhesives in vulcanizing processes.	Below 1700	6
	LOCTITE AQUANCE C-380S	Water-based CR	Water-based CR (sprayable) adhesive for upper preparation, fixing upper components and counter materials for stitching. It is very suitable for stitching process with long tack-retention time. Not like other water-based type. It can be dried at room temperature.	Below 1000	6

Main Product

Solvent Based Adhesive System

Category	Product	Main Component	Application	Viscosity (cps)	Shelf Life (Months)	Toluene Free (Yes/No)
Cleaner	LOCTITE BONDANCE 233BF	Hydrocarbons	Used for cleaning the surface of synthetic leather and enamel-coated materials at the minimum of damage. Moreover, it is suitable to clean phylon soles before coating enamel. Benzene and Toluene free.	Below 100	12	●
	LOCTITE BONDANCE 233BFU	Ketones	Suitable for materials which are difficult to be cleaned out with LOCTITE BONDANCE 233BF. It applies to PU mid soles and phylon soles instead of MEK and Toluene.	Below 100	12	●
	LOCTITE BONDANCE 233C	Aliphatic Solvent	Used for finishing shoes and dilution of adhesives.	Below 100	12	●
	LOCTITE BONDANCE 233M	Aliphatic Solvent	Used for cleaning PU sole, Pebax, nylon, TPU and synthetic leather.	Below 100	12	●
	LOCTITE BONDANCE 233NR-2	Aliphatic Solvent	Solvent for preparing NR solution applied to vulcanizing shoes.	Below 100	12	●
	LOCTITE BONDANCE 233A	Ketones	Can be substituted for ACETONE and it is mainly used for cleaner and dilution of solution.	Below 100	12	●
	LOCTITE BONDANCE 233AN	Aliphatic Solvent	Cleaner used for Air bags repairing and also used for diluents or cleaner in screen ink printing process.	Below 100	12	●
	LOCTITE BONDANCE PC-3	Hydrocarbons	Environment-friendly solvent-based cleaner from which high-toxicity substances such as Benzene and Toluene are eliminated.	Below 100	12	●
Curing Agent	LOCTITE BONDANCE 100	Poly-isocyanate	Curing agent with slow reaction time. It is used for solvent-based adhesives based on CR or PU.	Below 100	12	●
	LOCTITE BONDANCE ARF-1000	Poly-isocyanate	Curing agent for solvent-based adhesives and primers. It has good discoloration resistance. Enhances bond strength and heat resistance of adhesive and primer.	Below 100	12	●

Main Product

Solvent Based Adhesive System

Main Product

Solvent Based Adhesive System

Category	Product	Main Component	Application	Viscosity (cps)	Shelf Life (Months)	Toluene Free (Yes/No)
	LOCTITE BONDANCE 007	Ketones Chlorinated Compound	Chlorinating primer used for vulcanized rubber, RB foam and thermoplastic rubber (TPR)	Below 100	6	●
	LOCTITE BONDANCE 008-2	Modified PU	Primer used for die-cut EVA	Below 100	6	●
	LOCTITE BONDANCE 008-2RX	Modified PU	Primer used for die-cut EVA	Below 100	6	●
Primer	LOCTITE BONDANCE 167-2	Modified PU	High-performance solvent based primer used for difficult to bond materials (nylon, hytrel, pebax, carbon plate, etc) Toluene-free, Phenol free.	Below 100	6	●
	LOCTITE BONDANCE 173-2	Modified PU	UV curving primers widely used for Phylon 9 (molded EVA) such as normal, injected Phylon IP Compression molded pre-form (Cmp), unit sole (IU), improved initial setting and final bonding in comparison with the existing UV primers.	Below 100	6	●
	LOCTITE BONDANCE P-7-2	Modified PU	High-performance solvent based primer used for difficult to bond materials (nylon, hytrel, pebax, carbon plate, etc) Toluene-free, Phenol free.	Below 100	6	●
	LOCTITE BONDANCE 207	Ketones Chlorinated Compound	UV curving primers widely used for Phylon 9 (molded EVA) such as normal, injected Phylon IP Compression molded pre-form (Cmp), unit sole (IU), improved initial setting and final bonding in comparison with the existing UV primers.	Below 100	6	●
	LOCTITE BONDANCE 005G	Modified Polyofine	Two component type solvent based primer without UV Irradiation process for die-cut EVA @ Phylon Has high bonding performance, heat- resistance @ good anti-discoloration. Application : 1) Die-cut EVA primer* 2) Phylon painting primer 3) Reinforcing @ repairing primer after UV treatment 4) Phylon primer without UV process Recommended Low hardness Die-cur EVA (rr 50 Shore C type)	Below 100	6	●

Category	Product	Main Component	Application	Viscosity (cps)	Shelf Life (Months)	Toluene Free (Yes/No)
Primer	LOCTITE BONDANCE 218-2	Modified PU	Toluene-free primer used for reinforcing phylon bonding after UV and for assisting enamel coloring to phylon.	Below 100	6	●
	LOCTITE BONDANCE 224-2A	Modified PU	Primer used for various leather (nubuck, garment, action (A/C). Since having good penetrating property and interfacial bonding force they are especially suitable for nubuck and leather with high oil content.	Below 500	6	●
	LOCTITE BONDANCE 224-2	Modified PU	Primer used for various leather (nubuck, garment, action (A/C). Since having good penetrating property and interfacial bonding force they are especially suitable for nubuck and leather with high oil content.	100-500	6	●
	LOCTITE BONDANCE 231-2	Modified PU	PU-based primer which maximizes the interfacial cohesion and also assists the penetration into hard PU soles, PVC soles, phylon soles and synthetic leather.	Below 500	6	●
	LOCTITE BONDANCE 232H-2	Modified PU	PU-based primer which maximizes the interfacial cohesion and also assists the penetration into hard PU soles, PVC soles, phylon soles and synthetic leather.	100-500	6	●
	LOCTITE BONDANCE 234F-2	Modified PU	Primer used for various leather (synthetic, PVC, full grain (F/G), action(A/C), split, nubuck), canvas, nylon fabric and polyester fabric , Especially,	1000-2,000	6	●
	LOCTITE BONDANCE 2003	Ketones Chlorinated Compound	Chlorinating primer used for vulcanized rubber RB foam and thermoplastic, rubber(TPR).	Below 100	6	●
	LOCTITE BONDANCE 2005T(S)	Modified PU	Toluene free Primer used for Die-cut EVA	Below 100	6	●
Adhesive	LOCTITE BONDANCE 6100U-2	Modified PU	Adhesive for various sole and upper materials for stock-fit and assembly line. Has good resistance to discoloration and heat. Especially, it is suitable for short-drying process, some processes which require strong initial bonds and initial heat resistance.	1,900-4,500	6	●
	LOCTITE BONDANCE 6100UL-2	Modified PU	Adhesive for various sole and upper materials for stock-fit and assembly line. Has good resistance to discoloration and heat. Especially, it is suitable for short-drying process, some processes which require strong initial bonds and initial heat resistance.	1,300-2,500	6	●

Main Product

Solvent Based Adhesive System

Main Product

Solvent Based, Cyanoacrylates & Hotmelt Adhesive System

Category	Product	Main Component	Application	Viscosity (cps)	Shelf Life (Months)	Toluene Free (Yes/No)
Adhesive	LOCTITE BONDANCE 5100 -2	PU	PU adhesive for various sole and upper materials for stock-fit and assembly line.	1,700-3,000	6	●
	LOCTITE BONDANCE	PU	Adhesive used for special shoe categories such as mountain climbing boots, golf shoes and dress shoes which need very strong bonds. Suitable for both of general heat-drying system, heat activation system & HF welding.	1,200-500	6	●
	LOCTITE BONDANCE 203-2	Modified PU	Adhesive for for rubber in the sole making process by direct PU pouring.	100-500	6	●
	LOCTITE BONDANCE 8250-2	CR	Adhesive for living upper components and counter materials for stitching and padding.	4,000-12,000	6	●
	LOCTITE BONDANCE 7300	CR	Adhesives for living upper components and counter materials for stitching and padding. Suitable not only for stitching process with strong cohesives forces and long hacktime but also for lasting with high heat-resistance.	1,500-1,900	6	●
	LOCTITE BONDANCE 7300TF	CR	CR adhesives for living upper components and counter materials for stitching and padding. it is very suitable not only for stitching process with strong cohesives forces and long hacktime but also for lasting with high heat-resistance.	1,500-1,900	6	●
	LOCTITE BONDANCE 14-2	Modified NR	Treatment agent used for un-vulcanized rubber to bond with canvas.	100-200	6	●
	Repair Adhesive	LOCTITE FT 220	Cyanoacrylate	Gap repairing of various soles & upper materials of shoe without getting hard after drying and maintaining flexibility.	N/A	6

Category	Product	Main Component	Application	Viscosity (cps)	Shelf Life (Months)	Softening Point (deg C)
Hot Melt Adhesives	TECHNOMELT MELTACE 709-04	Modified Rubber	Thermoplastic hot-melt adhesive for fixing upper components for stitching and padding.	1830-2730	12	75-85
	TECHNOMELT MELTACE 720	Polyolefin	Fixing upper components for stitching and padding.	700-1300	12	115-125
	TECHNOMELT MELTACE 722	Polyolefin	Hot-melt pressure sensitive adhesive used for uppers such as PU Foam, leather, Texon board and non-woven fabrics. Has excellent spray-ability and with its long lack time, workability is very good.	1400-2400	12	105-125
	TECHNOMELT MELTACE 733	Modified Rubber	Thermoplastic hot-melt adhesive for edge folding (or French piping). Suitable foe white-colored material and has good workability.	4600-6000	12	83-107
	TECHNOMELT MELTACE A-100	Polyolefin	Thermoplastic hot-melt adhesive for edge folding (or French piping). It has short open time and goodinitial setting.	950-1550	3	105-115
	TECHNOMELT MELTACE 770	Modified Rubber	Thermoplastic hot-melt adhesive for bonding TR counter to PU lining, especially in Soccer Shoes. Offers excellent worlablity with good hot tack and good bonding performance.	3800-5200	12	83-97
	PUR HMA	MELTACE R-2060S	PU	PU reactive hot melt adhesive for suitable for stock-fit line. Especially suitable for 2D application.	35000-55000	12
PURMELT R-633		PU	PU reactive hot melt adhesive for suitable for stock-fit line. Especially suitable for 3D application.	-48000	3	130-145

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The data contained herein is intended as reference only. Some products / package sizes may not be available in your country or may have a lead time, Please contact your local Henkel subsidiary for assistance and recommendation on specifications and applications of these products.

Contact us at:

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