



**HELMITIN**  
QUALITY ADHESIVE SOLUTIONS

# HELMITEX 8322-3

## HIGH PERFORMANCE ADHESIVE

### Product Description

HELMITEX 8322-3 (+ 2.0% 8322-3 Curing Agent) is a high performance adhesive system that displays high initial green strength and extremely strong final bonds. The cured glue line is tough, flexible and exhibits good heat, moisture and oil resistance. This quality adhesive also provides good low temperature flexibility and aging properties

### Benefits

- High initial bonds
- Strong final bonds
- Heat, moisture, and oil resistant
- Cold temperature flexibility
- Good aging properties

### Suggested Uses

Designed primarily for footwear manufacturing as a vulcanizing cement to bond SBR compounds to uppers by direct injection or biscuit process.

### SURFACE PREPARATION

In order to achieve good bonds, leather upper materials must be thoroughly roughed to the corium layer prior to the application of HELMITEX 8322-3 + Curing Agent.

### Physical Properties

<b>Base:</b>	Synthetic elastomer
<b>Solids Content:</b>	26.0 ± 3.0%
<b>Viscosity:</b>	2,200 cP
<b>Specific Gravity:</b>	0.87 @ 20 °C (68 °F)
<b>Shelf Life:</b>	2 months from date of manufacture
<b>Color:</b>	Dark amber
<b>Odor:</b>	Medium
<b>Clean Up:</b>	SOLVENT 665
<b>Curing Agent:</b>	Water-like fluid- 35% solid content

### Caution

Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.

HELMITEX 8322-3 + 2% 8322-3 Curing Agent contain flammable solvents. Keep from open flames or sparks.

Provide adequate ventilation in work areas.

Store and use at room temperature (18°C/65°F). Not to be taken internally.

Purchasers must determine the suitability of this adhesive system

for their materials and manufacturing process

### Application Guidelines

Add 2% by weight of 8322-3 Curing Agent to the adhesive HELMITEX 8322-3. Mix thoroughly to ensure complete blending of the curing agent with the adhesive. Inadequate mixing may cause unsatisfactory bonds.

Apply a smooth, continuous coat of mixed adhesive to the upper, then allow approximately one hour for drying.

Fleshy or porous upper leathers may require 2 coats of adhesive. Allow 15 – 20 minutes drying time between coats.

The outsole compound may now be vulcanized to the upper. The compound temperature should be between 165 – 175°C (329 – 347°F) for reactivation and curing of the adhesive.

Production plant trials must be performed to determine correct vulcanizing time, temperature and pressure.

