



BOSTIK 1669

SOLE ATTACHING CEMENT

3 June 2020

YOUR SMART ADVANTAGES

- Economic to use
- Excellent heat and creep resistance
- Good brushability
- Very low staining and excellent UV resistance
- Long shelf life

DESCRIPTION

Bostik 1669 is a translucent, solvent based, polyurethane adhesive of medium viscosity. It has outstanding heat resistance and is especially suited for bonding leather, PVC, PU and TPR premoulded sole units in the footwear industry.

USES

Attachment of shoe sole units
Bonding of flexible PVC sheet
Repair of PVC inflatable boats

PRODUCT CHARACTERISTICS

Type	Polyurethane Base
Colour	Translucent clear
Solvent	Ketone
Viscosity	Brookfield – 3000 cps/20°C
Solids	16%
Specific Gravity	0.86 g/cm
Cleaner	Bostik 9906 Solvent
Flammability	Highly flammable
Product code	
4x4 litre Containers	30608695

APPLICATION

Stir well before using

Footwear Applications

Sole Preparation

The cementing surface of the PVC unit soles should firstly be wiped clean with Bostik 9907 solvent to remove surface plasticiser and factory handling dirt, then cemented with 1669 and allowed to dry for a minimum of 60 minutes. Normal factory practice is to clean 4-6 pairs of soles then apply the cement.

The cementing margin of PU (polyurethane) units should be thoroughly cleaned with 9906 Bostik solvent to remove all traces of mould release, lacquer coating etc. ensuring to renew the cloth used for this operation after every 10 pairs of soles.

Two coats may be required on leather soles. If Bostik 9907 Solvent is not available use a Ketone Solvent such as M.E.K. as the solvent wipe.

Thermoplastic Rubber (TPR) Sole units must be treated with a Halogenation system prior to cementing with **Bostik 1669**. This system is dealt with in the information sheet covering Bostik 9300 Primer A&B, and a minimum drying time of 2 hours is recommended.

Preparation of shoe bottoms

If using leather upper material, it is important that the shoe bottom be thoroughly roughened with a sharp rotary wire brush, all traces of the tanners finish and grain surface must be removed.

PVC material should be solvent wiped with Bostik 9906 prior to cementing or by roughing with a soft wire or nylon roughing brush. If roughing is not practical, carefully wipe the lasted margin with Bostik Solvent 9906 taking care to remove any lacquer on the PVC surface, renew the cloth used for this operation after every 10 pairs of uppers.

Polyurethane coated fabrics should be treated in the same way as cloth supported PVC.

BOSTIK 1669 SELF ATTACHING CEMENT

APPLICATION Cont.

Fabrics

No preparation is normally required but some synthetic fibre based fabrics may need special treatment to ensure a good adhesion

Cementing

Apply a generous coat of **Bostik 1669** to the prepared upper to give at least a 12mm margin, care should be taken that sufficient cement has been applied especially to the more absorbent leathers and fabrics. **Bostik 1669** is suitable for brush or machine application.

Minimum drying times are recommended of 60 minutes (to a maximum of 3 days) for soles and 30 minutes for most upper materials, these times can be reduced by forced drying.

Certain leathers, especially greasy and high oil content ones up to 14% will greatly benefit from the use of Bostik 9101 curing agent mixed in with the adhesive.

Sole Attaching

The sole only is heat activated for 30 seconds at a minimum surface temperature of 65°C before attaching to the shoe bottom. The activation time can be varied depending on the temperature used, however, it is recommended that the temperature of the cement film before attaching be not less than 65°C. NOTE for leather 90°C is recommended

Non-Footwear Applications

For applications such as inflatable devices and tarpaulins, the use of Bostik 9101 or 9105 curing agent is recommended. These curing agents increase the bond strength and heat resistance of **Bostik 1669**.

Add 3% to 6% by volume of 9101 or 9105 to the adhesive and stir in thoroughly. Mixed adhesive will have a pot life of up to 6 hours.

Wipe the surfaces to be bonded with Bostik 9907 solvent. Apply the mixed adhesive to both surfaces and allow to dry for at least 60 minutes to a maximum of 120 minutes.

Use a hot air gun or infrared lamp to heat the glue surface to a minimum of 75°C.

Immediately combine the two surfaces with maximum pressure. Use of a hand roller is recommended.

LIMITATIONS

- Not for use for bonding metals
- Do not use on expanded polystyrene foam
- Not suitable for polyethylene or polypropylene plastic

CLEAN UP

Use Bostik 9907 solvent to clean excessive adhesive.
(As well as cleaning/priming soles prior to cementing).

STORAGE AND SHELF LIFE

Store in a cool, dry place, out of direct sunlight and away from all sources of ignition. Storage areas must be well ventilated and comply with Local, State and Federal regulations. For maximum shelf life, store between 5° and 20°C.

Shelf life is up to 12 months when stored in original, unopened containers, under the above conditions.

FIRE

This product is highly flammable.

PRECAUTIONS IN USE

Keep container closed when not in use as solvents in formulation evaporate quickly. Use in well ventilated areas only.

Complete details on each of the products mentioned are available on the product Safety Data Sheets. To ensure no harm is caused to persons using Bostik products, it is recommended that all concerned read the appropriate Safety Data Sheets. Visit www.bostik.com/au for copies.

For emergency information contact the Poisons Information Centre, phone 131 126 or the Emergency Response Service, phone 1800 033 111.

BOSTIK HOTLINE

Smart help 1800 898 551



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