



FOOTWEAR

Product Selection Guide

CONNECT YOUR BUSINESS WITH A COMPETITIVE EDGE

To bring in-demand products to market, you need a partner with technical expertise that understands today's challenging footwear industry. You need a partner that can help you deliver the products your customers want and provide the valuable support your business needs. We tailor our product and process innovations to meet our customers' critical needs, such as lowering cost in use, and increasing efficiency and production output. Our problem solving-power can add measurable value to your footwear product.

Adhesive, primer and halogenating solutions for versatile, high quality and long-lasting performance with different application systems and substrates in the footwear segment.

UPPER CONSTRUCTION

Product Name	Technology	Characteristics	Viscosity
GENERAL UPPER BONDING			
Irutex™ 1051	Water-based – Chloroprene latex	Universally applicable, very tacky, sprayable	95 mPa.s @ 20°C
Irutex™ D 60 ST	Water-based – Natural latex	Universally applicable, sprayable	80 mPa.s @ 20°C
Helmitin® 758/2	Water-based – Natural latex	Universally applicable, rollable	700 mPa.s @ 20°C
Ibucoll™ 7310 N	Solvent-based – SBR	Very soft and flexible, sprayable	300 mPa.s @ 20°C
Helmitin® Blantal 8	Solvent-based – Polychloroprene	For lining, folding, upholstering, yellowing stabilized	2.100 mPa.s @ 20°C
Umbugzement™ 500 M	Solvent-based – Rubber	For lining, folding, for porous materials, tacky	7.000 mPa.s @ 20°C
Thermodur™ 203	Hot melt – Polyamide	For folding, flexible	2.400 mPa.s @ 160°C
Lunamelt™ 4015 ZP	Hot melt – PSA	For steel sole fixing, very tacky	5.500 mPa.s @ 175°C
Lunatack™ P201 AP 41	Hot melt – APAO	Excellent adhesion onto difficult substrates	20.000 mPa.s @ 175°C
TOE CAP AND COUNTER			
Hikaflex™ 404/05	Dispersion	For counters, very tacky, blocking free, dipping application	250 mPa.s @ 20°C
LASTING			
Isarment™ 5402 X	Solvent-based – Polychloroprene	High heat resistance	3.000 mPa.s @ 20°C
Thermostrang™ 2030	Hot melt – Polyester	Toe/Heel lasting	3.600 mPa.s @ 225°C
Thermostrang™ 2142	Hot melt – Polyamide	Side lasting	3.500 mPa.s @ 230°C

SOLE PREPARATION

Product Name	Technology	Characteristics	Viscosity mPas
GENERAL SOLE PREPARATION			
Körabond® PUR 54	Primer – Solvent-based – PUR	For PUR, TPU soles and parts – 2c	30 mPa.s @ 20°C
Ultraflex™ Vorstrich PU/D	Primer – Solvent-based – PUR	For PUR, TPU soles and parts – 2c	225 mPa.s @ 20°C
Ultraflex™ 4010 Y	Primer – Solvent-based – PUR	Excellent penetration on leather soles - 2c	370 mPa.s @ 20°C
Isarcoll™ Vorstrich NX	Primer – Solvent-based – Polychloroprene	Excellent adhesion to EVA, rubber and roughed leather soles – 1/2c	740 mPa.s @ 20°C
HALOGENATION			
Icortin™ C17	Halogenating agent	1c	40 mPa.s @ 20°C
Icortin™ C40	Halogenating agent	2c, long storage time	Not applicable

SOLE ASSEMBLY

Product Name	Technology	Characteristics	Viscosity mPas
UPPER PREPARATION			
Ultraflex™ 4010 Y	Primer – Solvent-based – PUR	For greasy, hydrophobic and loose fibered leathers – 2c	370 mPa.s @ 20°C
Helmitin® DS/17	Primer – Water-based – PUR	Good leather penetration, good brushability	2.000 mPa.s @ 20°C
SOLE BONDING			
Irutex™ FI 4006 G	Water-based – PUR	Solvent free with encapsulated hardener system	2.000 mPa.s @ 20°C
Ultraflex™ 4320	Solvent-based – PUR	Excellent green strength – 1/2c	2.800 mPa.s @ 20°C
Körplast® 179 M	Solvent-based – PUR	Very good green strength and excellent "Tack". Especially designed for hot environments	3.000 mPa.s @ 20°C
Ultraflex™ 4814	Solvent-based – PUR	High green strength at medium activation temperature – 1/2c	3.500 mPa.s @ 20°C
Ultraflex™ 4355	Solvent-based – PUR	Low activation temperature – 1/2c	3.300 mPa.s @ 20°C
Ultraflex™ 4320 Schwarz	Solvent-based – PUR	High green strength – 1/2c; suitable for the production of anti-static shoes - Black	2.800 mPa.s @ 20°C
Ultraflex™ 4822	Solvent-based – PUR	High green strength – 1/2c; suitable for the production of anti-static shoes - Colourless	3.200 mPa.s @ 20°C
Helmitin® Formel 1	Solvent-based – Polychloroprene	Multipurpose – 1/2c	1.100 mPa.s @ 20°C
DIRECT INJECTION			
Ultraflex® 4905 X	Solvent-based – PUR	For PU/Rubber combination – 2c	40 mPa.s @ 20°C
Iurban™ NBR	Solvent-based – NBR	Sprayable, for robot systems – 1c	2.200 mPa.s @ 20°C

1c = one component 1/2c = one or two component(s) 2c = two components

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Since 1887, H.B. Fuller has been a leading global adhesives provider focusing on perfecting adhesives, sealants and other specialty chemical products to improve products and lives. H.B. Fuller's commitment to innovation brings together people, products and processes that answer and solve some of the world's biggest challenges. Our reliable, responsive service creates lasting, rewarding connections with customers in electronics, disposable hygiene, medical, transportation, aerospace, clean energy, packaging, construction, woodworking, general industries and other consumer businesses. And, our promise to our people connects them with opportunities to innovate and thrive.



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