



GLUKON[®]flex was specially developed for OT and OST in insole, orthotic and prosthetic construction. GLUKON[®]flex is a sprayable contact adhesive for bonding EVA together, as well as with other materials. Thanks to the outstanding bonding force, GLUKON[®]flex is ideal for the majority of permanent bonds.

GLUKON[®]flex is applied on BOTH SIDES when used as a contact adhesive. A wide range of materials can be bonded in the contact bonding process.

When applied on ONE SIDE, GLUKON[®]flex can be used as a rapid fixing aid for bonding awkward shapes or large-format material dimensions.

After hardening, GLUKON[®]flex forms a flexible adhesive joint and can be reshaped through the application of heat. The special formula of GLUKON[®]flex keeps the odour produced during application to a minimum.



MATERIALS

GLUKON[®] flex bonds materials including the following: Plantec, latex, Osnapren, cellular rubber, Carbosan, WBT, Lederett[®], diamond, Alcantara[®], Fidelitas[®], nora[®]Lunalight, Cellolight, milling materials, leather, cork, Velcro, Kevlar, acrylic, polyethylene, PE/PP, rubber, carbon, PU, aluminium, metal.

FEATURES

- + Adhesive application is quicker and easier
- + Can be used as bonding and contact adhesive
- + Flexible adhesive joint
- + Very high initial strength
- + Mobile, ready for immediate use without power or compressor
- + Spraying method: Web spray
- + Flash-off time: approximately 1- 3 minutes (at 20°C)
- + Does not contain toluol
- + The cured adhesive is not flammable

TECHNICAL DETAILS

- + Description: Solvent-based sprayable contact adhesive
- + Colour: White-yellowish
- + Solids content: 30 %
- + Resistance to temperature: approx. 85°C
- + A 22 l pressure container replaces approx. 50 - 60 kg of neoprene adhesive
- + Coverage: 13.6 kg pressure containers approx. 100 m² (The coverage is heavily dependent on the application and the materials used!)
- + For disposal refer to safety data sheet or label

INSTRUCTIONS FOR USE

Before every job, it is necessary to check whether the selected adhesive is suited to the requirements profile of the materials used! The materials to be bonded must be clean and free of grease. Smooth surfaces such as Plantec or WBT must be roughened and subsequently degreased again.

Use only acetone for de-greasing or isopropanol in the case of sensitive surfaces. To ensure optimum results, the adhesive should be used at temperatures of 10 - 25° C (ideally 20° C). This also applies to the materials to be bonded.

With first use, connect the hose and gun to the container. Then slowly open the container valve and check the system is leak-tight. The system is now ready for operation. To apply the adhesive, hold the gun approx. 10 cm (hand width) above the application surface. The rule of thumb for correct application here is: Spray jet width = distance to the workpiece.

Always apply the adhesive evenly, crosswise to both sides to be bonded (surface 1 vertically, surface 2 horizontally). Application quantity approx. 85g/m²/wet, **leave to dry for at least 1 minute**, until the solvents have completely evaporated off. **Precise compliance with the flash-off time is extremely important! Otherwise the bonded materials may detach.** Double application is recommended for very difficult materials around edges or on very absorbent substrates. Press both surfaces firmly together (contact pressure approx. 2.5 to 3 kg/cm²) to ensure a good bond. The open time is approx. 2 hours.

The adhesive is applied on one side for fixing. Application quantity approx. 45-50g/m²/wet. Allow the adhesive to flash off sufficiently again. It is now possible to fix together the parts to be joined. Fixed parts can be removed and their position corrected if necessary.

Important: Not final bonding strength!

Lock the spray gun after use. The valve on the adhesive container must **NEVER** be closed unless the container is being replaced with a new one or if it is necessary to transport the container in a motor vehicle. Please use Glukon Citrus Cleaning Spray for removing adhesive residues from surfaces. Before use, please read our Glukon instructions for use (enclosed with the container), which are also available to download from: www.glukon.de. Bonded materials can be further processed immediately. It takes about 24/48 hours until the adhesive is completely cured.

Important information: Depending on the raw material base, some cleaning agents may attack the adhesive and for this reason avoid directly spraying onto the adhesive joints when cleaning soiled surfaces. Recommendation: Do not apply the cleaning agent directly to the workpiece, but rather apply it to a lint-free cloth and clean the surfaces with this. Do not use Glukon flex for bonding plasticising materials such as PVC, CV coatings, vinyl and artificial leather!

APPLICATION CHECKLIST

- + Does the selected adhesive match the requirements profile and the intended materials?
- + Are the materials to be bonded dry, clean and free of dust and grease? Degrease only with acetone or isopropanol. Metals and smooth surfaces should be additionally roughened and then degreased again.
- + Do the application temperatures of the adhesive, the materials and the environment fall inside the permissible parameters (15 - 25 °C)?
- + Are you sufficiently familiar with how to apply the adhesive? Distance between the spray gun and the workpiece, spray jet width and spraying speed? Please visit our website: www.glukon.de/anwendung and watch our application video for further information.
- + Do you know the respective flash-off times and open times for the adhesive to be used? These must be adhered to!
- + Are the materials free of tears or similar damage?
- + Has the work process been thought through? Can dirt be ruled out when applying the adhesive?
- + Is the system ready to use? Is the product well shaken? Pistol and nozzle should spray without problem.
- + Is the correct nozzle being used? Please only use our Glukon standard nozzle with our web spray adhesives.
- + Are all tools available and ready for bonding the materials?
- + Is health and safety ensured?

HEALTH & SAFETY / SAFETY INSTRUCTIONS

- Personal protective equipment should be worn when working with the GLUKON[®] spray adhesive system. Please also be sure to observe our safety data sheets in this regard!
- Good ventilation of the workplace/site must be guaranteed or ensured by means of suitable technical measures (e.g. EX-protected extraction unit or stationary extraction). Directly breathing in the solvent should be avoided.
- With insufficient ventilation or incorrect use there is a risk of an explosive gas/air mixture forming! This results in a danger to life! The formation of naked flames and excessive heat (+50°C) must be avoided in general!
- The vessel is pressurised and must be protected against damage (e.g. valve being struck off, being dropped, the effects of heat, etc.).
- Never forcibly open full containers or containers that have not been completely emptied! Risk of explosion!

STORING AND HANDLING THE GLUKON[®] CONTAINER

Must be stored at a temperature between +10 °C and +50 °C. The container is under pressure. Protect containers from direct sunlight and heat sources. Do not store on a cold concrete floor. Avoid damage to the container or penetration by foreign objects. The containers may not be refilled! Transport containers in an upright position and secure against shifting/toppling. Close container valve when transporting in a motor vehicle. Open the container valve again after transport. Protect containers from rain. Handle containers carefully. Do not throw or drop. Only store in well-ventilated rooms. Containers showing damage from the outside,

such as dents or valve damage, are to be disposed of professionally. Do not stick objects in the spray head! Please also refer to the safety datasheet (Point 7 and Point 14) for our GLUKON[®] containers! GLUKON[®] can be stored under the recommended conditions for at least 12 months.

ATTENTION! SHAKE/ROLL THE CONTAINER WELL FOR AT LEAST 1 MINUTE BEFORE FIRST USE AND IF NOT USED FOR EXTENDED PERIODS. PROTECT FROM FREEZING. ENSURE THE CORRECT TEMPERATURE WHEN WORKING! (min. +15°C).

DISCLAIMER

We always recommend trying the adhesive on your materials first. Please refer to our technical leaflets and the adhesive recommendations of the respective material manufacturer. It is important to test all materials to be bonded before production. The person using the product is responsible for checking whether **GLUKON[®] flex** is suitable for the respective application. **Not suitable for bonding plasticised products such as PVC or artificial leather!**

The above details are based on results in practice and tests undertaken by us. As we have no influence on the choice of materials or the conditions of use, all details are non-binding information and, as such, no guarantee of characteristics. This also applies to instructions from our technical advice service. Publication of this technical leaflet renders all previous ones invalid.

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