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AQUILIM

THE WATER BASED ADHESIVE

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Renia USA Inc.
Bonding for Life

AQUILIM water-based Adhesives

Aquilim 130 is a PU-based contact adhesive, suitable for leather, rubber, PU (sheets, unit soles), PVC, TR (with yellow Rehagol Primer), etc. Apply thin coat on both sides and let the adhesive dry (10–20 minutes, depending on layer thickness, can be accelerated by heating). The adhesive turns transparent when completely dry. Heat-activation at 80 °C necessary. Join parts while still hot and let them cool down under pressure (at least 1 bar). Areas of application: shoe making (outsoles), PU foam lamination, exotic leathers, chrome-tanned leather. Adhesive is pre-mixed with a heat-activated crosslinker that ensures excellent resistance against heat, water, chemicals, and other environmental influences.

Aquilim 315 is a CR-based contact adhesive, suitable for leather, rubber, EVA, PU sheets, cork, plastazote, etc. Two sided application: Apply thin coat on both sides and let the adhesive dry (10–20 minutes or 2–3 minutes on leather, depending on layer thickness, can be accelerated by heating). The adhesive turns transparent when completely dry. Join parts within open time or after heat activation and press with at least 1 bar. One sided application: Apply slightly thicker coat on one side and immediately lay absorbent material onto wet adhesive layer. Press materials together and allow several hours of drying/curing time. Two sided application possible for all materials, one-sided application only if one side is absorbent/permeable. Leather to leather: instant bond with one-sided application, adhesive needs to penetrate into the fiber structure. Sewing/stitching is possible after 30–60 minutes. Areas of application: leather crafting, shoe uppers, bags, clothing, orthopedic insoles (not ideal on PE/PP).

Aquilim 325 is a CR-based contact adhesive, suitable for leather, rubber, EVA, PU sheets, cork, foamed and compact PE/PP, copolymer, metal, carbon fiber, etc. Apply thin coat on both sides and let the adhesive dry (10–20 minutes or 2–3 minutes on leather, depending on layer thickness, can be accelerated by heating). The adhesive turns transparent when completely dry. Join parts cold within open time or after heat activation and press with at least 1 bar. One-sided application is possible if one side is absorbent/permeable. Areas of application: bonding of flexible materials to compact plastics like PE/PP and metal, as found in O&P applications (insoles, braces, prostheses).

Aquilim GL is a CR-based semi-permanent contact adhesive, suitable for leather, rubber, EVA, PU sheets, cork, plastazote, etc. Apply thin coat on both sides and let the adhesive dry (10–20 minutes or 2–3 minutes on leather, depending on layer thickness, can be accelerated by heating). The adhesive turns transparent when completely dry. Join parts cold within open time and press or hammer together. One-sided application is possible if one side is absorbent/permeable. The adhesive is similar to a classic Rubber Solution: Opening and adjusting the bond remains possible for several hours without damaging the material. Sewing/stitching is possible after 30-60 minutes. Areas of application: materials that need to be held in place for sewing, insole topcovers, shoe uppers.

Aquilim SG is a PVA-based non-permanent pressure-sensitive adhesive, suitable to bond leather, rubber, fabric, EVA, PU, plastazote to all common materials. Apply adhesive to the more absorbent/rough side and let it dry (5-15 minutes, 2-3 minutes on leather, can be accelerated by heating). The adhesive turns transparent when completely dry. Attach to other surface and press or hammer both materials together. Sewing/stitching is possible right away. The adhesive works like a classic Rubber Solution: Opening the bond remains possible indefinitely, the adhesive never cures completely. Areas of application: materials that need to be held in place for sewing, shoe uppers, foam pads that need to be removed or moved around later.

Aquicork CF is a Cork Bottom Filler, as used in welted shoes. Apply filler in desired thickness and shape accordingly. Let dry for 24 hours. Forced drying with heat is possible, using a heat lamp or an oven. The filler then develops a dried layer on top. If the outsole is attached to that, the rest of the water needs to evaporate through the shoe itself, which takes a lot longer. Letting the filler dry out completely before the work continues is always preferable. The product is very tacky and remains so even when drying, so the layer holds together very well, while still staying flexible.

General properties: All Aquilim/Aquicork products cannot be allowed to freeze, so storage and transportation above 4 °C is necessary. These products are completely free of organic solvents, so no VOC concerns, no fume extraction (except for spray application), and no fire hazard. Water-based adhesives are less tolerant to surface contaminations on the materials to be bonded, so sanding and/or cleaning are usually recommended. Switching to any new adhesive, especially to a water-based product, requires an effort – some processes might turn out a little different, based on the physical and chemical properties of the new product.

Abbreviations:

PU: Polyurethane	**PP:** Polypropylene	**EVA:** Ethylvinylacetate/Crepe	**TR:** Thermoplastic Rubber
PE: Polyethylene	**PVA:** Polyvinylacetate	**CR:** Polychloropren/NeoprenTM	**VOC:** most solvents except Acetone and MEK

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