



### Helmitin<sup>®</sup> GPV-S

- Type of Adhesive** Polyurethane solvent based adhesive.
- Product Benefits**
- exhibits good heat, moisture and oil resistance as well as low temperature flexibility
  - can be used as one part or as two part adhesive with Helmitin<sup>®</sup> 500 FB, Swift<sup>®</sup> hardener 9513 or Helmitin<sup>®</sup> 49631, depending on the particular requirements
- Typical Applications** High performance sole attaching polyurethane cement for various shoe materials.
- Suitable substrates** Leather, PVC and polyurethane materials, primed rubber and thermoplastic rubber soles and most synthetic upper materials.

#### Typical Properties

Property	Value
Base	polyurethane
Colour	translucent
Viscosity (Brookfield)	approx. 5000 mPa.s
Solids content	approx. 20%
Density	approx. 0.87
Shelf life	12 months



### Application Instructions

- thinner: Helmitin® 694
- hardener (percentage): 5% Helmitin® 500 FB, Swift® hardener 9513 or Helmitin® 49631
- pot life: approx. 24 hours with Helmitin® 500 FB and Swift® hardener 9513; approx. 48 hours with Helmitin® 49631
- application: brush, roll-coating machine
- drying time: 20 – 30 minutes
- open time:
  - approx. 36 hours with Helmitin® 500FB
  - approx. 24 hours with Swift® hardener 9513
  - approx. 72 hours with Helmitin® 49631
- setting time: approx. 24 hours

Leather uppers must be roughened before the application of the adhesive.

Some vinyl coated or polyurethane coated upper materials may require light roughening or a wipe with solvent Helmitin® 694 prior to adhesive application.

Sole material such as thermoplastic rubber or composition rubber require halogenation with Helmitin® T/FL instead of mechanical roughening.

However, some rubber may not respond. Therefore the adhesion should be checked before the factory treatment is commenced.

Pay attention to the technical data sheet of Helmitin® T/FL. Soles and upper must receive a complete and even coating of cement and be allowed to dry thoroughly.

Heat reactivation of the adhesive layers is recommended to approximately 75°C - 80°C.

After which the sole is immediately attached to the upper by means of a sole press.

Allow a curing period of 2 days before testing the bond strength.



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## TECHNICAL DATA SHEET

<b>Cleaning Instructions</b>	Please contact your local Sales Office for available cleaning solutions.
<b>Typical Packaging</b>	Please contact your local Sales Office for available packaging options.
<b>Storage Conditions</b>	In original sealed packaging protected from sun, dust, moisture and high temperatures. Clean and dry conditions above 10°C and below 30°C. Sensitive to cold and moisture.
<b>Disposal Advice</b>	Please refer to the MSDS for disposal instructions.
<b>Safety Advice</b>	Please refer to the MSDS for safety advice.

### Our Focus is Clear. Perfecting Adhesives.

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