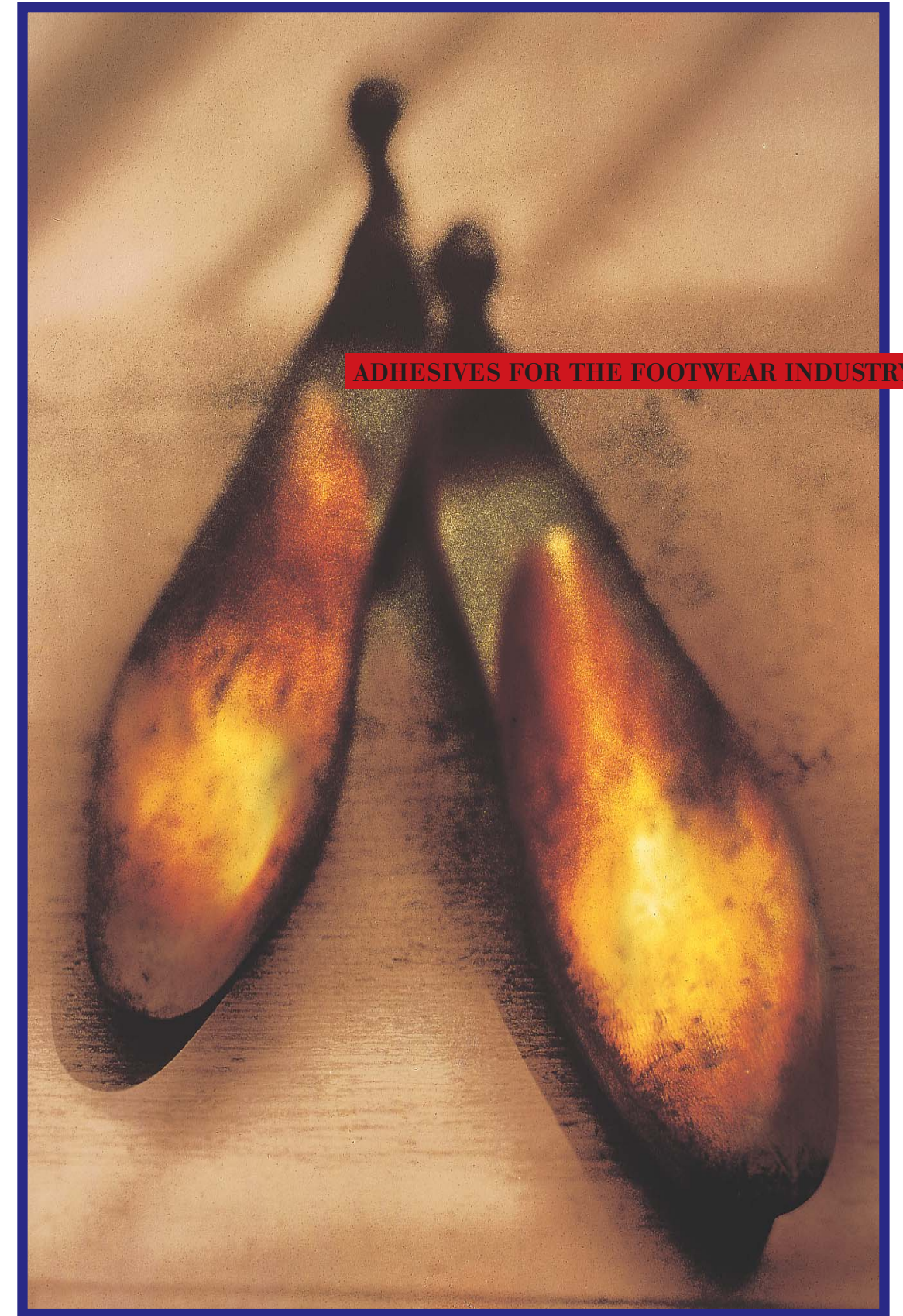


KÖMMERLING





# Adhesives for the world of shoes



Competence comes with experience. Since 1897 KÖMMERLING has been developing and marketing adhesives for the footwear industry. Over the past 100 years, we have succeeded in numerous pace-setting developments for industrial shoe production. This was the case in 1949 when KÖMMERLING was the first in Europe to use synthetic rubber for the manufacture of sole attachment adhesives. Thus, the cold contact glue “Kövuifix” marked the beginning of a new era in sole bonding.

Today KÖMMERLING offers a complete programme of high quality adhesives for all shoe-related applications. Certification in accordance with international quality standard DIN EN ISO 9001 confirms this high priority on quality. With its innovative products KÖMMERLING is continuing to demonstrate its strong commitment in the area of research and development. In collaboration with our customers as well as machine and material suppliers we are developing up-to-date solutions for efficient shoe production. One of the focal points in this regard is the further optimization of solvent-free adhesives. Our new development center offers excellent facilities for this.

KÖMMERLING has an international network of sales and production partners which guarantees supplying capability and aftersales service in many countries. Together with experienced product engineers from our headquarters in Pirmasens, we offer you the desired technical support on-site.

KÖMMERLING is meeting the challenges of the future. Take us at our word, we are always happy to serve you, no matter where you are in the world of shoes.

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- Pre-assembling / Lamination
- Folding
- Toe puffs / Counters



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- Heel building
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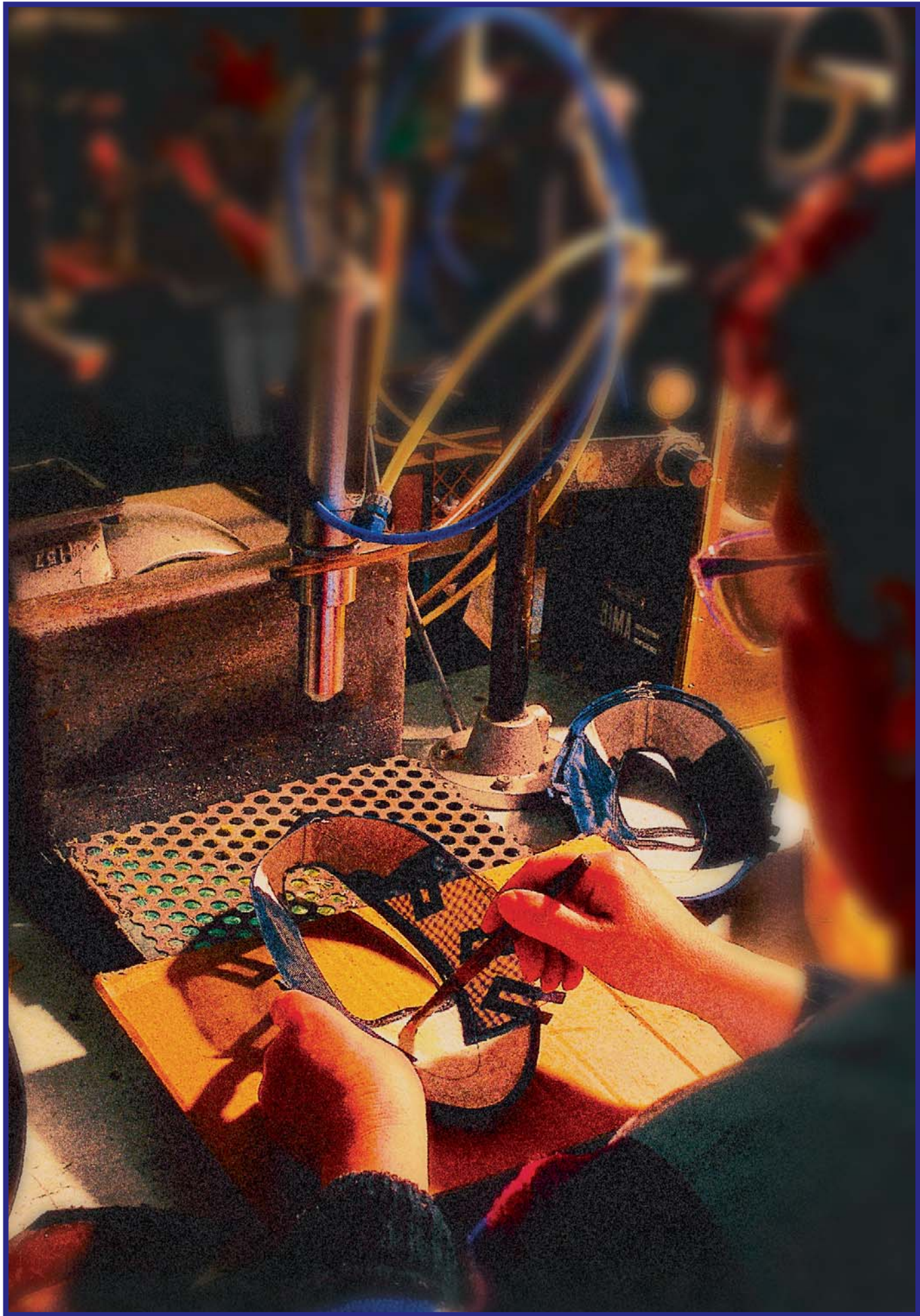
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### Nomenclature

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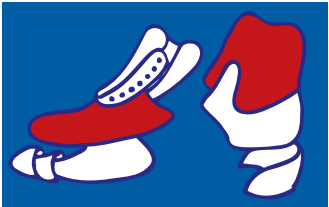
Solvent based

■ Solvent based adhesive

Solvent free

■ Water based adhesive

■ Hot melt



Pre-assembling / Lamination

■ ■ ■	medium viscosity, non-yellowing, medium open time	<b>Körapren</b>	<b>30</b>
■ ■ ■	high viscosity, non-yellowing, medium open time, high bond strength	<b>Körapren</b>	<b>31</b>
■ ■ ■	low viscosity, high bond strength, short open time, also suitable for shoe repair	<b>Körapren</b>	<b>36</b>
■ ■ ■	medium viscosity, correctable setting contact, light colour	<b>Körapren</b>	<b>38</b>
■ ■ ■	low viscosity, favourable brushing properties, high bond strength, short open time	<b>Körafix</b>	<b>215</b>
■ ■ ■	low viscosity, non-yellowing, multi-purpose	<b>Körafix</b>	<b>TRO/HL</b>
■ ■ ■	crepe-based, high viscosity, long open time	<b>Kö-Cement</b>	
■ ■ ■	resistant to plasticizers, non-yellowing, PUR-based	<b>Köraplast</b>	<b>192 LF</b>
■ ■ ■	permanent tacky, non-yellowing	<b>Köratan</b>	<b>55</b>
■ ■ ■	low viscosity, sprayable, especially for synthetic materials	<b>Köratex</b>	<b>243</b>
■ ■ ■	medium viscosity, fast-setting, sprayable, especially for synthetic materials	<b>Köratex</b>	<b>261</b>
■ ■ ■	medium viscosity, long open time, high bond strength, especially for synthetic materials	<b>Köratex</b>	<b>263</b>
■ ■ ■	low viscosity, fast-setting, for spraying and roller coating	<b>Köratex</b>	<b>660</b>
■ ■ ■	medium viscosity, fast-setting	<b>Köratex</b>	<b>677</b>
■ ■ ■	low viscosity, fast-setting, especially for spraying	<b>Köratex</b>	<b>680</b>
■ ■ ■	high tack, non-penetrating, pH-value 5 - 6	<b>Köracoll</b>	<b>DH 557</b>
■ ■ ■	cold-flexible, transparent, non-blocking	<b>Köramelt</b>	<b>603</b>
■ ■ ■	permanent tacky, flexible	<b>Köramelt</b>	<b>898</b>
■ ■ ■	permanent tacky, high bond strength	<b>Köramelt</b>	<b>906</b>





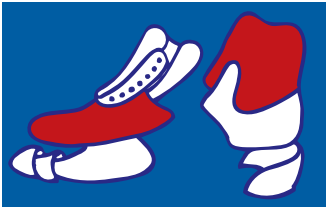
Solvent based

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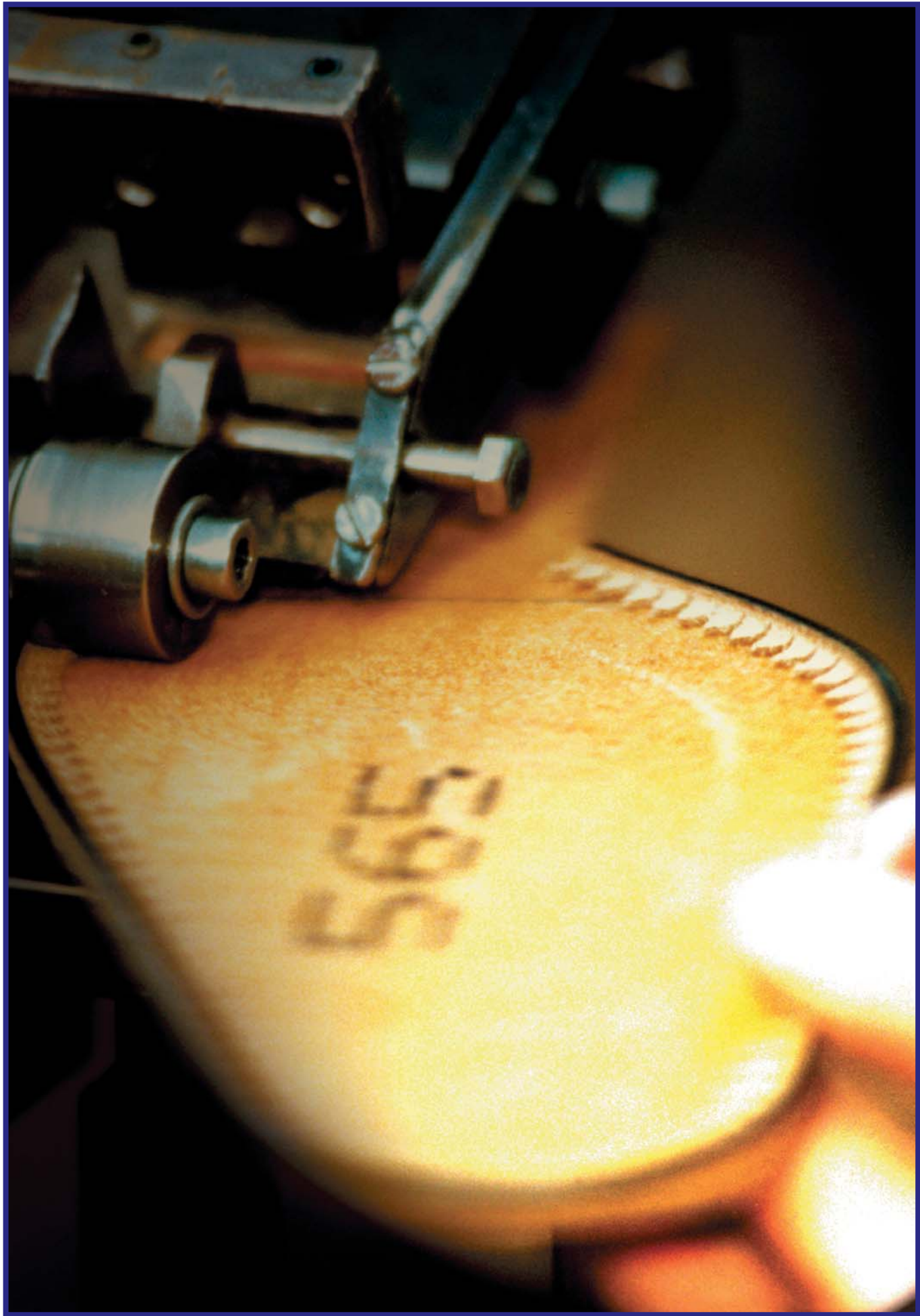
Folding

<input type="checkbox"/> <input type="checkbox"/> <input checked="" type="checkbox"/>	polyamide granule for folding and insole edge binding machine, processing temperature: 145 - 155 °C	<b>Köramelt</b> 451 GR
<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	crepe-based, high viscosity for manual folding, long open time	<b>Kö-Cement</b>
<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	low viscosity, high bond strength, for manual folding, short open time	<b>Körapren</b> 36

Toe puffs / counters

<input type="checkbox"/> <input type="checkbox"/> <input checked="" type="checkbox"/>	polyamide granule for the coating of toe puffs, flexible film, processing temperature: 180 - 200 °C	<b>Köramelt</b> 460 GR
<input type="checkbox"/> <input type="checkbox"/> <input checked="" type="checkbox"/>	polyamide-V8-rod for the coating of toe puffs, flexible film, processing temperature: 160 - 180 °C	<b>Köramelt</b> VK 8
<input type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/>	for pre-coating of counters, non-blocking, for dipping and spraying	<b>Köracoll</b> 550
<input type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/>	for direct processing of counters, for dipping and spraying, especially for heavy-duty shoes	<b>Köracoll</b> 611
<input type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/>	for direct processing of counters, for dipping and spraying, low sealing temperature, favourable wetting properties	<b>Köracoll</b> 617
<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	for dipping and direct processing of pre-coated forming toe puffs / counters	<b>Körasolv</b> PU
<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	for dipping and direct processing of TPR-counters	<b>Köratan</b> 734





Solvent based

■ Solvent based adhesive

Solvent free

■ Water based adhesive

■ Hot melt



Insoles production

<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	for roller coating, medium viscosity	<b>Körapren</b>	<b>142</b>
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	for roller coating, low viscosity	<b>Körapren</b>	<b>143</b>
<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	for roller coating, long open time, high bond strength	<b>Köratex</b>	<b>263</b>
<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	cold-flexible, transparent, non-blocking	<b>Köramelt</b>	<b>603</b>

Heel building

<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	for dipping of PS- and PP-heels, strong adhesive film	<b>Körapren</b>	<b>352</b>
<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	for covering, sprayable and for roller coating, favourable wetting properties	<b>Köratex</b>	<b>257</b>

Wedge / Orthopedic sock / Plateau

<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	primer for PUR-parts, for dipping and spraying	<b>Körabond</b>	<b>PUR 51</b>
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	primer for PS-parts, for dipping	<b>Körabond</b>	<b>660</b>
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	for dipping of PS- and PP-parts, strong adhesive film	<b>Körapren</b>	<b>352</b>
<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	for covering, sprayable and for roller coating, favourable wetting properties	<b>Köratex</b>	<b>257</b>

Welt cementing

<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	especially for TPR-material, low activation temperature, PUR-based	<b>Köraplast</b>	<b>168</b>
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	resistant to plasticizers, non-yellowing, low activation temperature, PUR-based	<b>Köraplast</b>	<b>192 LF</b>
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	1-component, for cold contact bonding, CR-based	<b>Körafix</b>	<b>1935</b>
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	2-component, for cold contact bonding, CR-based	<b>Körafix</b>	<b>TRO</b>





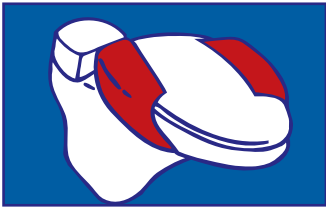
Solvent based

■ Solvent based adhesive

Solvent free

■ Water based adhesive

■ Hot melt

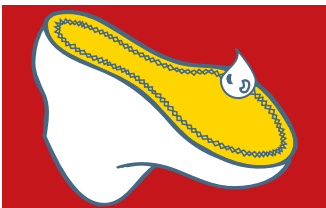


Hand lasting

■ ■ ■	long open time, CR-based	Körapren	1074
■ ■ ■	short open time, high heat resistance, CR-based	Körapren	1075
■ ■ ■	high viscosity, resistant to plasticizers, PUR-based	Köraplast	159
■ ■ ■	medium viscosity, non-yellowing, resistant to plasticizers, PUR-based	Köraplast	192 LF

Machine lasting

■ ■ ■	polyamide granules, processing temperature: 140 - 160 °C	Köramelt	450 GR
■ ■ ■	polyester rod cement, processing temperature: 210 - 230 °C	Köramelt	53 S
■ ■ ■	polyamide rod cement, processing temperature: 210 - 230 °C	Köramelt	505 S
■ ■ ■	polyamide rod cement on cardboard spools, processing temperature: 210 - 230 °C	Köramelt	505 P



Bonding of membrane / Sealing

for upper / seam sealing, transparent, deeply penetrating, flexible, PUR-based	Köraplast	158
primer for membrane, PUR-based	Köraplast	159 NV
main coat for membrane and upper, high viscosity, PUR-based	Köraplast	159
for upper / seam sealing, solvent-free, curing at moisture, PUR-based	Körapur	120
impregnating agent, for dipping and spraying	Köphoban	L
hot melt for the temporary fixation of insole to last without clips	Köramelt	470 GR





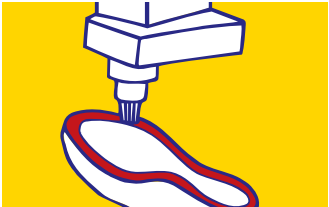
Solvent based

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Solvent free

■ Water based adhesive

■ Hot melt



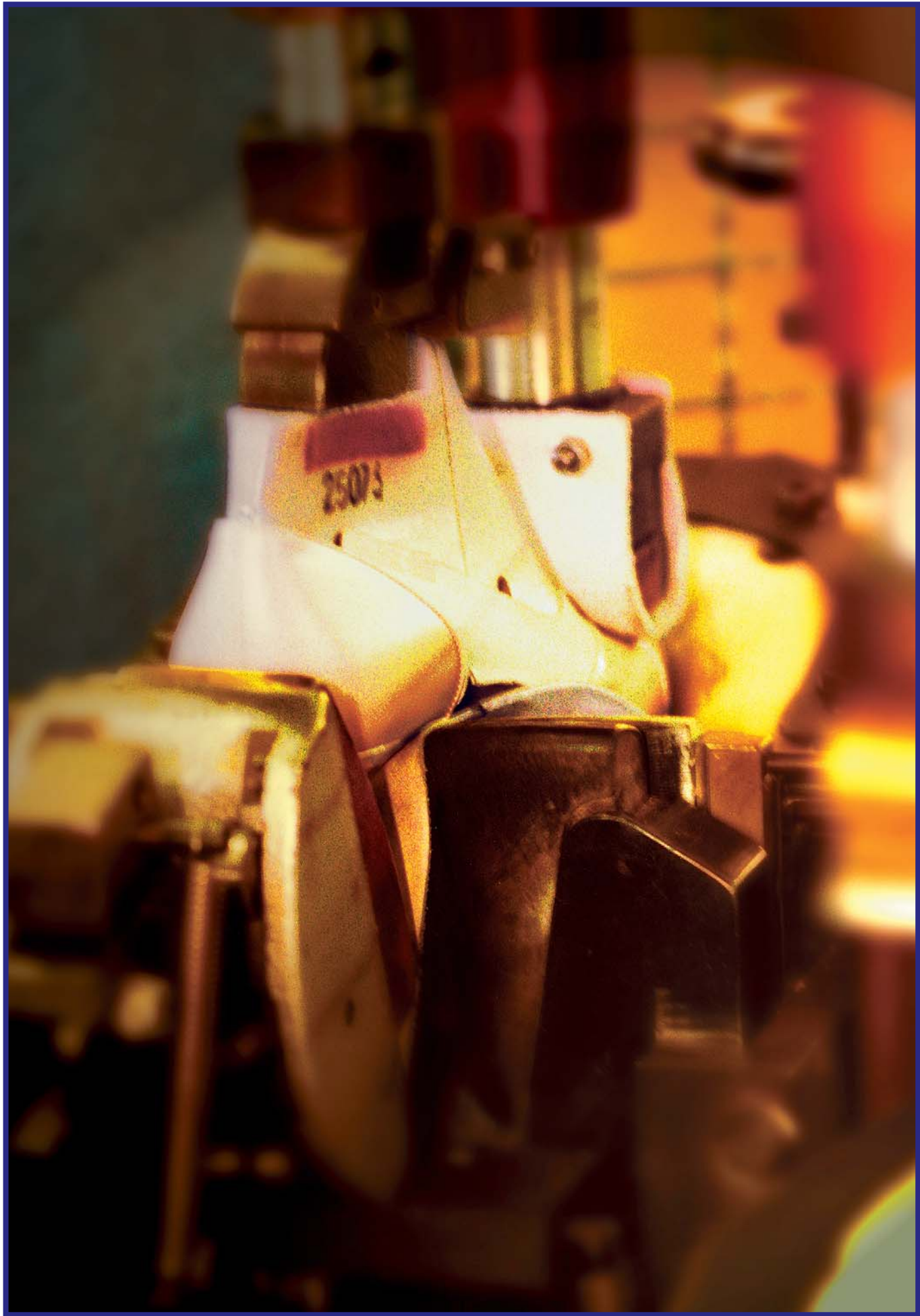
Primers

■ □ □	washing and swelling agent for PUR	Polyurethan	Körabond PUR 50
■ □ □	for roughened and unroughened PUR, fluorescent		Körabond PUR 51
■ □ □	for roughened and unroughened PUR		Körabond PUR 65
■ □ □	2 - component fluorescent halogenizer for TPR, rubber and latex	TPR / rubber / Latex	Halosol W 5 FL
■ □ □	1 - component fluorescent halogenizer for TPR, rubber and latex		Halosol 6
■ □ □	for roughened flat EVA-material	EVA	Körabond P 40
■ □ □	for flat EVA- material and unroughened moulded soles without additional UV-treatment		Körabond 11
□ ■ □	for roughened flat EVA-material		Körabond 1177
■ □ □	washing agent for PVC	PVC	Körasolv M
■ □ □	for extreme fatty leather, deeply penetrating	Leather	Köraplast 154 LF
■ □ □	for fatty and fibrous leather		Köraplast 172
■ □ □	standard leather primer, low viscosity		Köraplast 173
■ □ □	for fatty and fibrous leather, adhesion to rubber		Köraplast 174 NV
■ □ □	for polyamide, favourable adhesion to PA 6, Nylon and Pebax	Polyamid	Körabond 5

Hardeners

■ □ □	colourless, low reaction time	Köracur TR 203
■ □ □	colourless, medium reaction time	Köracur TR 250
■ □ □	yellowish, fast reaction time	Köracur TR 400
■ □ □	yellowish, for extreme greasy leather	Köracur TH 240
□ ■ □	for PUR-dispersions, medium reaction time	Köracur D 8





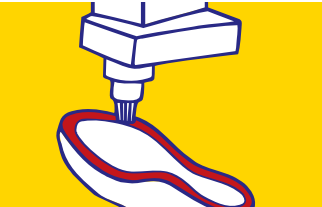
Solvent based

■ Solvent based adhesive

Solvent free

■ Water based adhesive

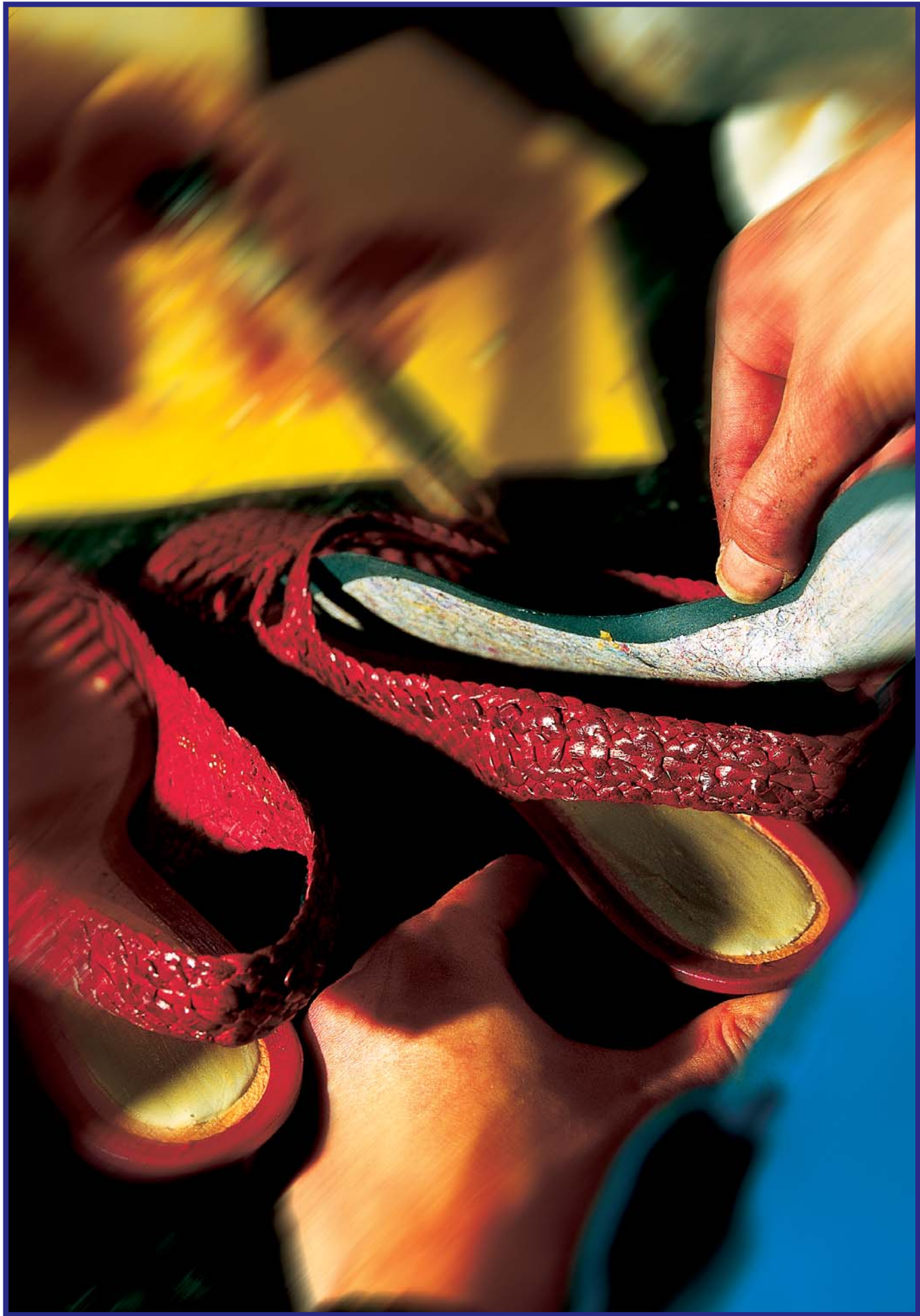
■ Hot melt



Main coats

■ ■ ■	cold contact adhesive for sole bonding of light footwear and shoe repair	Köraplast	160
■ ■ ■	high initial bond strength, favourable machine processing properties, favourable suitability for TPR-soles, sprayable	Köraplast	163 T
■ ■ ■	low activation temperature, retarded setting contact, especially for thin dish-shaped TPR-soles	Köraplast	168
■ ■ ■	high initial bond strength, favourable setting contact	Köraplast	170
■ ■ ■	high initial bond strength, high heat resistance	Köraplast	174 R
■ ■ ■	low activation temperature, favourable setting contact	Köraplast	177
■ ■ ■	high initial bond strength, favourable setting contact	Köraplast	179 M
■ ■ ■	antistatic, colourless, high heat resistance	Köraplast	182 A
■ ■ ■	low activation temperature, for materials sensitive to heat	Köraplast	187
■ ■ ■	favourable setting contact, especially for TPR-soles	Köraplast	188
■ ■ ■	very low activation temperature, for materials sensitive to heat, non-yellowing	Köraplast	192 LF
■ ■ ■	low viscosity, high initial bond strength	Köraplast	198 M
■ ■ ■	multi-purpose, high heat resistance	Köraplast	199
■ ■ ■	CR-adhesive, low viscosity, high initial bond strength, also suitable for shoe repair	Körafix	212
■ ■ ■	PUR-dispersion, high initial bond strength	Köracoll	1142
■ ■ ■	PUR-dispersion, favourable setting contact, deeply penetrating	Köracoll	1172
■ ■ ■	PUR-dispersion, favourable setting contact and wetting properties	Köracoll	D 155
■ ■ ■	reactive PUR-hot melt, favourable setting contact, favourable machine processing properties	Köramelt	102
■ ■ ■	reactive PUR-hot melt, high initial bond strength, stress-resistant, low activation temperature	Köramelt	110





### Solvent based

■ Solvent based adhesive

### Solvent free

■ Water based adhesive

■ Hot melt



■ ■ ■	for injection of PUR to PVC, short drying time	<b>Köratac</b>	<b>DF 841</b>
■ ■ ■	for injection of PUR to halogenized rubber outsoles and pretreated upper materials	<b>Körplast</b>	<b>157</b>
■ ■ ■	for injection of PUR, high viscosity, sealing properties	<b>Körplast</b>	<b>158</b>
■ ■ ■	for injection of PUR to halogenized rubber outsoles, antistatic	<b>Körplast</b>	<b>165 A</b>
■ ■ ■	for injection of PVC, high viscosity, brushable	<b>Körplast</b>	<b>181</b>
■ ■ ■	for injection of PVC to greasy leather and specific membrane materials, sprayable	<b>Körplast</b>	<b>195</b>
■ ■ ■	for vulcanization of NBR-rubber to leather	<b>Köravult</b>	<b>82</b>
■ ■ ■	for injection of TPR to leather, PUR, PVC	<b>Körabond TPR</b>	<b>148</b>
■ ■ ■	for injection of PVC, PUR and TPU	<b>Körabond</b>	<b>D 101</b>

### Solvent based

■ Solvent based adhesive

### Solvent free

■ Water based adhesive

■ Hot melt



■ ■ ■	medium viscosity, fast-setting, especially for synthetic materials	<b>Köratex</b>	<b>261</b>
■ ■ ■	medium viscosity, long open time, high bond strength, especially for synthetic materials	<b>Köratex</b>	<b>263</b>
■ ■ ■	low viscosity, fast-setting, for spraying and roller coating	<b>Köratex</b>	<b>660</b>
■ ■ ■	high viscosity, fast-setting, for absorbent materials	<b>Köratex</b>	<b>678</b>
■ ■ ■	high viscosity, fast-setting, for absorbent synthetic materials	<b>Köratex</b>	<b>683</b>
■ ■ ■	resistant to plasticizers, favourable brushing properties, PUR-based	<b>Körplast</b>	<b>159 NV</b>
■ ■ ■	high heat resistance, short open time, CR-based	<b>Körapren</b>	<b>1075</b>
■ ■ ■	resistant to plasticizers, very tacky, NBR-based	<b>Köralit</b>	<b>41 MA</b>





Cleaners / Solvents / Specialities



cleaning / diluting agent for PUR-adhesives	Körasolv	CA
cleaning / diluting agent for CR-adhesives	Körasolv	CR
multi-purpose brush cleaner, washing agent for PVC	Körasolv	M
multi-purpose cyanoacrylate for instant bonding, flexible	Kö-Cement	C 3
moulding compounds for model construction	Köraform	
hot melt for cardboard packaging, high initial bond strength, short open time	Köramelt	610
black, antistatic, for mixing into CR-adhesives	Paste	CR
black, antistatic, for mixing into PUR-adhesives	Paste	PU
colourless, antistatic, for mixing into CR- and PUR-adhesives	Antistaticum	
multi-purpose lubricant and release agent for refillable Kömmerling spraying tin	Ködiscoll	88184
flexible, cork / rubber based	Bottom filler	

solvent-based PUR-adhesives	Köraplast
solvent-based CR-adhesives	Körapren
solvent-free latex adhesives	Köratex
solvent-free dispersions	Köracoll
solvent-free and solvent-based primers	Körabond
solvent-free hotmelts	Köramelt
isocyanate containing hardeners	Köracur

The foregoing information represents values obtained in our laboratory and has been supplied in good faith. It shall not be construed to be legally binding. In particular, it shall not exempt the purchaser from taking responsibility for testing the product supplied so as to determine its suitability for the intended application. Warranty is made exclusively for the constantly high quality of our products.