HOT MELT ADHESIVE

PA Hot Melt Adhesive Rod for Shoe Back Counters

UR-S970

The back counter — the stiffened heel section that gives a shoe its shape at the back, also called the heel counter — is bonded with a polyamide hot melt adhesive. United supplies it as UR-S970 — a solid rod, coiled and sized to drop straight into the melt tank of a counter cementing machine. It is a single-component polyamide, 100% solids and solvent-free: the machine melts it, lays a bead along the heel seat and counter line, and the counter is pressed into place while the melt is still open.

KEY FEATURES

- Polyamide (PA) chemistry — a stiff, high-cohesive bond line that holds the heel curve instead of creeping under load
- Better heat stability than EVA counter melts — the bond survives a closed container, a warm store room and a shoe box in transit
- Solid rod, coiled — loads straight into the tank: no film to cut, no release paper, no dust
- 100% solids, solvent-free — no solvent fume, no extraction ducting, no drying tunnel
- Sets on cooling — the counter is fixed the moment the press opens, so cycle time belongs to the machine
- Wide substrate coverage — leather, PU-coated leather, microfibre, textile and cellulose counter board
- Matched to your machine — softening point, viscosity and rod size confirmed against your tank and cycle

TECHNICAL SPECIFICATIONS

Property	Value / how it is specified
Model	UR-S970
Chemistry	Polyamide (PA), single component
Form	Solid rod, coiled
Solids content	100% — no solvent, no water
Softening point / melt range	Set per grade; the figure is confirmed on the datasheet for the grade you order
Melt viscosity	Set per grade to suit your pump, nozzle and bead weight
Rod size	Supplied to the diameter your feed channel accepts
Bond character	Stiff, high cohesive strength; sets by crystallisation on cooling
Substrates	Leather, PU-coated leather, microfibre, textile and cellulose counter board
Packing	Coiled rod in cartons; carton weight confirmed per order
Storage	Cool, dry, ventilated, out of direct sunlight; shelf life as stated on the datasheet

RECOMMENDED PROCESSING CONDITIONS

Step	What happens
1. Preparation	Counter board and upper are cut and skived; bonding surfaces must be clean, dry and free of release agent
2. Melting	The coiled rod is loaded into the tank and melted at the temperature set for the grade
3. Application	The machine lays a bead along the heel seat and up the counter line
4. Assembly	The counter is positioned on the upper and pressed into the heel curve
5. Setting	The melt crystallises as it cools; the bond is fixed when the press opens — no oven, no clamp time

TYPICAL APPLICATIONS

Formal and casual shoes — the standard counter bond for men's and women's lines

Safety, work and uniform boots — stiff counters that must not soften or creep in service

Children's footwear — short cycles and small counters, with no oven in the line

Moulded and pre-formed counters — bonding the counter into the heel before lasting

Any counter line running a rod-fed tank — no film, no powder, no solvent

PACKAGING AND STORAGE

- Supplied in standard export packaging; roll width, length and liner options confirmed on order.
- Store in a dry, ventilated place below 30 °C, away from direct sunlight, moisture and ignition sources.
- Shelf life: 12 months in unopened original packaging. Reseal opened rolls and use them within the period stated above.

> **Handling note:** Hot melt adhesives are applied molten. Use a suitable dispenser or laminator with accurate temperature control and keep hands clear of the melt and heated surfaces.

The values above are typical test results obtained under standard laboratory conditions and are provided for reference in product selection. They do not constitute a specification or warranty of performance in a particular application, because bonding results depend on substrate, equipment, line speed and ambient conditions. We recommend a trial run on your own production line before commercial use. Shanghai United Industry Co., Ltd reserves the right to revise this document without notice.

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