HOT MELT ADHESIVE

PES Hot Melt Adhesive Rod for Shoe Foreparts

UR-S971

UR-S971 is a thermoplastic copolyester (PES) hot melt adhesive supplied as milky-white rods of 3.8–3.95 mm diameter, coiled and ready to feed. The round section runs through the feed channel without twisting, so the bead stays even. It melts at 165–178 °C, runs at 210–235 °C on the forepart cementing machine, and sets in 3–5 seconds as it cools — so the lasted forepart moves straight to the next station with no clamp time and no drying tunnel.

KEY FEATURES

- Sets in 3–5 seconds — the melt crystallises quickly on cooling, so the adhesive keeps pace with an automatic forepart line instead of holding it up
- Working window 210–235 °C, melting range 165–178 °C — a forgiving band that keeps the bead flowable from tank to nozzle without scorching the polymer
- Melt index 35–48 g/10 min (210 °C / 0.325 kg) — steady, repeatable flow, so the bead is the same width at the start and at the end of a shift
- Rod diameter held to 3.8–3.95 mm — consistent feed through the machine, with no jamming and no manual topping-up
- Tough, flexible bond with wide temperature tolerance — the forepart flexes thousands of times without cracking, whitening or creeping at the edge
- Solvent-free: no smoke, no odour, no VOCs — a cleaner workshop, no extraction ducting and no solvent-recovery cost

TECHNICAL SPECIFICATIONS

Property	Value
Appearance	Milky white rod, coiled
Main component	Thermoplastic copolyester (Co-PES)
Rod diameter	3.8-3.95 mm
Melting range	165-178 °C (GB/T 19466.3-2004)
Density	1.20 g/cm³
Melt index	35-48 g/10 min (210 °C / 0.325 kg, GB/T 3682-2000)
Bonding temperature	210-235 °C
Setting time	3-5 s
Packaging	12 coils / 25 kg / carton
Storage	Ventilated, dry, dark room; shelf life approx. 12 months

RECOMMENDED PROCESSING CONDITIONS

Parameter	Value
Adhesive temperature	210-235 °C (adjust within the band to bead size and line speed)
Substrate preparation	Bonding area must be clean and dry
Application	Heat in the shoe forepart cementing machine and inject onto the parts
Assembly	Overlap the bonding surfaces and press
Setting	3-5 s; the bond sets instantly while cooling, so no holding time is needed

TYPICAL APPLICATIONS

Shoe foreparts and toe areas — bonding the upper around the forepart on automatic forepart cementing machines

Dress, casual and work footwear — wide adaptability across the upper materials and constructions used in general footwear production

Children's and small-size footwear — a 3–5 second set keeps short cycles short and keeps small lasts from springing open

Any line running a rod-fed hot melt tank — no film to cut to shape, no powder handling, no solvent to dry off

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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