



BSI Standards Publication

**Data sheets — Footwear tests
materials and test adhesives**

National foreword

This Published Document is the UK implementation of CEN/TR 15990:2021. It supersedes PD CEN/TR 15990:2010, which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee PRI/52, Adhesives.

A list of organizations represented on this committee can be obtained on request to its committee manager.

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English Version

Data sheets - Footwear tests materials and test adhesives

Fiches techniques - Matériaux et colles pour essais des articles chaussants

Datenblätter - Schuh-Testwerkstoffe und Schuh-Testklebstoffe

This Technical Report was approved by CEN on 21 June 2021. It has been drawn up by the Technical Committee CEN/TC 193.

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Contents

Page

| | |
|------------------------------|----|
| European foreword..... | 3 |
| Introduction | 4 |
| 1 Scope..... | 6 |
| 2 Normative references..... | 6 |
| 3 Terms and Definitions..... | 7 |
| 4 Test materials..... | 7 |
| 4.1 Test material L1..... | 7 |
| 4.2 Test material L2..... | 8 |
| 4.3 Test material SBR..... | 8 |
| 4.4 Test material NBR..... | 9 |
| 4.5 Test material SBS | 10 |
| 4.6 Test material PVC..... | 10 |
| 4.7 Test material EVA..... | 11 |
| 5 Test adhesives..... | 12 |
| 5.1 Test adhesive CR1 | 12 |
| 5.2 Test adhesive CR2 | 13 |
| 5.3 Test adhesive PU1..... | 13 |
| 5.4 Test adhesive PU2..... | 14 |
| 5.5 Test adhesive PUD1..... | 14 |
| 5.6 Test adhesive PUD2..... | 15 |

European foreword

This document (CEN/TR 15990:2021) has been prepared by Technical Committee CEN/TC 193 “Adhesives”, the secretariat of which is held by UNE.

This document supersedes CEN/TR 15990:2010.

The main technical changes in comparison to the previous version are as follows:

- New information providers for test materials L1, L2, SBR and SBS in 3.1, 3.2, 3.3, 3.5 respectively,
- Update of company names.

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Introduction

For testing adhesive bonds some important European Standards have been developed by CEN/TC 193/Working Group 5 “Adhesives for Leather and Footwear” in close cooperation with European Shoe Institutes and the “Association of European Adhesive and Sealant Manufacturers (FEICA)”:

- EN 1392:2006, *Adhesives for leather and footwear materials — Solvent-based and dispersion adhesives — Testing of bond strength under specified conditions*
- EN 15062:2006, *Adhesives for leather and footwear materials — Solvent-based and dispersion adhesives — Testing ageing of bonds under specified conditions*
- EN 15307:2014, *Adhesives for leather and footwear materials — Sole-upper bonds — Minimum strength requirement*

These European Standards intend to serve:

- the manufactures of shoe materials for testing the bondability of their products;
- the adhesive manufactures to determine the bond properties of their adhesives;
- the shoe industry to test the suitability of the materials and/or adhesives before applying in their production line and for quality control.

In the footwear industry a large number of different solvent and dispersion adhesives are applied for sole-upper bonding offering a broad range of technical effects. The most important and most often adhesives used are based on polyurethane and polychloroprene. For research, development and quality certification purposes some simply formulated 1- and 2-part “reference test adhesives” have been developed which can be considered as typical adhesives of these types. In footwear manufacture also a great number of the different sole and upper materials are used. From the most important and most often applied some materials have been selected as “reference test materials”.

The annexed data sheets offer for each of these reference test adhesives and reference test materials some information and specify some properties. CEN/TC193 Working Group 5 takes care for a continuous updating of these data sheets. For further information on a reference test adhesive or a reference test material (e.g. on availability and supply) please contact the European Shoe Institute mentioned in its data sheet:

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1 Scope

For research, development and quality certification purposes, some simply formulated 1- and 2-part “reference test adhesives” have been developed and, from the most important and most often applied, some materials have been selected as “reference test materials”. This document offers for each of these reference test adhesives and reference test materials some information and specify some properties. CEN/TC 193/WG 5 takes care for a continuous updating of these data sheets.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 1392, *Adhesives for leather and footwear materials - Solvent-based and dispersion adhesives — Testing of bond strength under specified conditions*

EN 12092, *Adhesives - Determination of viscosity*

EN ISO 868, *Plastics and ebonite - Determination of indentation hardness by means of a durometer (Shore hardness) (ISO 868)*

EN ISO 1183-1, *Plastics - Methods for determining the density of non-cellular plastics - Part 1: Immersion method, liquid pycnometer method and titration method (ISO 1183-1)*

EN ISO 3376, *Leather - Physical and mechanical tests - Determination of tensile strength and percentage elongation (ISO 3376)*

EN ISO 4045, *Leather - Chemical tests - Determination of pH and difference figure (ISO 4045)*

EN ISO 4048, *Leather - Chemical tests - Determination of matter soluble in dichloromethane and free fatty acid content (ISO 4048)*

EN ISO 5398-3, *Leather - Chemical determination of chromic oxide content - Part 3: Quantification by atomic absorption spectrometry (ISO 5398-3)*

ISO 34 (all parts), *Rubber, vulcanized or thermoplastic - Determination of tear strength*

ISO 37, *Rubber, vulcanized or thermoplastic - Determination of tensile stress-strain properties*

ISO 247 (all parts), *Rubber - Determination of ash*

ISO 1407, *Rubber - Determination of solvent extract*

ISO 278, *Rubber vulcanized or thermoplastic - Determination of density*

ISO 549, *Rubber, vulcanized or thermoplastic - Determination of abrasion resistance using a rotating cylindrical drum device*

ISO 48 (all parts), *Rubber, vulcanized or thermoplastic - Determination of hardness*