



Technical Bulletin

10745 Permabond Screen Adhesive

This water-based product has been specifically formulated to meet the credit card industries laminating requirements. It provides a sturdy bond with high peel strength when applied to PVC, vinyl, or other credit card laminates.

Physical Characteristics:

Viscosity:	2,000 – 2,500 cps, at 72° F
Thinner:	Product is provided ready to use, however, it may be thinned with up to 5% de-ionized water as needed
VOC Content:	<1% per gallon
Solids Content:	42 ± 2% N.V.
Weight per Gallon:	8.8 ± 0.25 pounds per gallon
Mesh Selection:	Use a 230 – 355 (90 - 140 cm) plain weave monofilament mesh
Emulsion Selection:	Stencil and block-out must be solvent and water resistant. Use of dual cure emulsions designed for minimized stencil build up and smoothness over mesh are best
Clean-up:	Most conventional solvent cleaners work well
Instron Peel Strength:	Typical peel strength exceeds 8.25, depending on coating weight
Laminating:	Requires a temperature of at least 280 - 305° F, with a heat dwell time of fourteen to sixteen (14 - 16) minutes
Handling & Storage:	Product is temperature sensitive, protect from freezing

INSTRUCTIONS FOR DRYING #10745 CLEAR ADHESIVE:

1. 60 - 70°C (140° - 160°F) OVEN TEMPERATURE FOR APPROXIMATELY 15 - 45 SECONDS OVEN SPEED WILL VARY DEPENDING UPON LENGTH OF OVEN AND COATING.

Effective 01/25/01

More than a shade superior

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