



## Technical Data Bulletin

### 11770 PermaBond Gravure Clear Adhesive

This water-based product has been specifically formulated to meet the credit card industry laminating requirements. It provides a sturdy bond with high peel strength when applied to PVC, vinyl or other credit card laminates. The PermaBond Clear Gravure Adhesive offers extremely fast dry times and is suitable for use on both flexographic and gravure applications.

#### Physical Characteristics:

|                        |   |
|------------------------|---|
| Viscosity:             | 30 seconds $\pm$ 5, #3 Zahn Cup 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:           | 15 ounces per gallon  |
| Solids Content:        | 30 $\pm$ 2% N.V.  |
| Weight per Gallon:     | 8.6 $\pm$ 0.25 pounds per gallon  |
| Coating Weight:        | Recommend no less than .24 - .30 grams be applied. Higher or lower deposits may be required depending on laminating requirements. |
| Instron Peel Strength: | Typical peel strength exceeds 6.500 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.  |

Effective 01/25/01

**More than a shade superior**  
117 East 14<sup>th</sup> Avenue North Kansas City, Missouri USA 64116  
800-746-5567 \* 816-221-5567 \* fax 816-221-4820