



Technical Data Bulletin

19042 UV Permabond Flexo Laminating Adhesive

This clear UV Based product has been specifically formulated to meet the specialty, secured card, and 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 Flexo Laminating Adhesive offers extremely fast dry times and is suitable for use on all flexographic 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% with _____ 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 6.5 to 10.5 bcm of dry film 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.

Storage

Care should be taken to store ink in tightly closed containers located in a cool (60-80°F/15-27°C) dark place. After long production runs excess product should be properly disposed. With suitable conditions, unopened adhesive is expected to have a shelf life of approximately twelve (12) months from date of manufacture.

Effective 04/06/09

We strongly recommend a preliminary test of printing and curing on the products intended to use, in order to ascertain exactly the procedure, the working times and the obtained effect. MIX WELL BEFORE USE. Follow the indications on the package, ask for the safety data sheets and always follow the indications contained therein.

IMPORTANT— Only the correct use of the product will allow satisfactory results. For this reason, closely related to the product supplied, Polymeric must decline all direct and indirect responsibility for the proper or improper use of the product. Make certain that product is right for the desired use, work according to the instructions given in our technical data sheets. Before use contact Technical Service

More than a shade superior
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