

KIWOPRINT® D 162

Acrylate and dispersion based pressure sensitive adhesive

KIWOPRINT D 162 is used for the production of self-adhesive film, labels and conveyors made of paper, cardboard, rigid PVC, polyester film, pre-treated polyethylene and polypropylene, polyurethane, fibre glass, resopal etc. For special applications, KIWOPRINT D 162 can also be used for the production of dry and wet transfers. Materials bonded with KIWOPRINT D 162 can be stored for a minimum of 1 year without any decrease of adhesive strength, if covered with a suitable silicone paper and kept dry and dark at room temperature.

PREPARATION

Observe the following advice when producing self-adhesive materials:

1. Check the requirements, such as e.g. requested adhering strength, climatic strain, temperatures and UV resistance.
2. Chose the correct substrate and test compatibility with KIWOPRINT D 162 (e.g. soft PVC film influences the adhesive layer):
3. In case of a direct contact of KIWOPRINT D 162 with the printing inks, check compatibility of the inks. Kind and type of ink can influence the adhesive.
4. The correct choice of the mesh count is decisive for screen printing applications. The coarser the mesh, the higher is the build-up thickness and therefore the adhesion strength. For the production of temporary lacquer transfers, usually a mesh of 77 to 100 threads/ cm is used.
5. For screen printing applications, water resistant emulsions of the AZOCOL range can be used. Ask KIWO for advice.
6. Choose the correct covering material. Use very smooth silicone paper or siliconized film. The adhesive layer depends on the covering material, the smoother the silicone liners, the smoother the adhesive layer (within 24 h). Furthermore, silicone liners must be adapted to the adhesive in order to avoid disturbances when removing them.

The suitability of the adhesive together with each component i.e. substrate, ink, liner, adhesion partner etc. must be tested before production parts are made. Special attention should be made for the long-term compatibility with the component materials. Also one must check the influences of the liner material and the state or nature of the substrate's structure or roughness. Silicone release agents, plasticizer migration etc. must be checked for and ruled out before one continues

APPLICATION

When screen printing, optimum adjustment of the printing machine determines the print result. Best results are achieved with stencils with high tension (25-30N/cm). Snap-off should be high (2-4 mm), print velocity average (from 400 mm/s). This largely prevents the formation of bubbles. High air humidity facilitates working with dispersion based adhesives During short printing breaks the stencil should be flooded with adhesive. If the printing breaks are longer than 3-5 minutes. the screen has to be cleaned.

Water can be used to clean fresh adhesive. Dried adhesive can be removed with PREGAN 1014 E.

Stir well before use. KIWOPRINT D 162 should not be thinned for application. Thinning with water is possible, however, thus printability, solids content, coating thickness and consequently the adhesive strength is reduced.

The adhesive can be dried at room temperature or, in industrial production, in tunnel dryer. Temperatures of up to +70°C can be applied without damaging the adhesive. Drying time depends on the applied adhesive thickness, kind of substrate, drying temperature and air flow. Test and optimize the most suitable values at your facility. Completely dried adhesive layers are transparent.

Notice: Make sure the adhesive has dried through completely to remove any remains of liquid components from the adhesive layer.

Only completely dry adhesives achieve highest bonding values. After drying the adhesive can be covered with silicone paper for further applications. A bubble-free laminating of the liner is recommended, as enclosed air influences the adhesive layer.

To avoid die cutting problems, the adhesive layer should end 0,5 – 1,0 mm in front of the punch line. Back-lit areas will not be printed as the adhesive film has an influence on the light intensity.

TECHNICAL DATA

BASIS	Aqueous dispersion of an acrylate polymer
COLOUR	Wet: white Dry: transparent
VISCOSITY	Approx. 6000 mPas (Brookfield RVT, spindle 4, 20 r/min., 20°C)
SOLIDS CONTENT	Approx. 52 %
pH-VALUE	Approx. 7,5
DENSITY	Approx. 1,03 g/cm ³
PEEL VALUE	Approx. 12 N/ inch (after 1 min bonding time) Approx. 22 N/ inch (after 24 h bonding time)

90 µm adhesive thickness onto 50 µm polyester film. Tested according to PSTC 1. Measured at 23°C with peel tester type L 500 from Lloyd Instruments. Load cell 100 N, class 1, DIN EN ISO 7500-1 for tension and pressure, peel speed 300 mm/min., peel angle: 180°. Applied to polished

stainless steel using a hand roller (10 pounds, rolled 5 x in each direction) and measured after the corresponding bonding time at 23°C. Adhesion area: 2,54 x 10 cm.

**DYNAMIC
SHEAR STRENGTH**

Approx. 115 N/ inch²

90 µm adhesive thickness onto 50 µm polyester film. Measured at 23°C with peel tester type L 500 from Lloyd Instruments, load cell 2500 N, class 1, DIN EN ISO 7500-1 for tension and pressure, peel speed 0,1 inch/min. Bonded onto a 50 µm polyester film using a hand roller (10 pounds, rolled 5x in each direction). Adhesion area: 1 x 1 inch. Measurement after 24 hours.

**STATIC
SHEAR STRENGTH**

Approx. 660 s

90 µm adhesive thickness onto 50 µm polyester film. Bonded onto a 50 µm polyester film using a hand roller (10 pounds, rolled 5x in each direction). Adhesion area: 1 x 1 inch. Measurement after a bonding time of 24 hours. After 15 min. tempered in a drying cabinet at +105°C the shear stress was tested by hanging an extra weight of 1 kg onto the sample.

TACK VALUE

Approx. 1150 g

90 µm adhesive thickness onto 50 µm polyester film. Measured with Polyken Tack-Tester at 23°C, adhesion: 1 s, peel speed; 0,5 cm/s. Measured with specimen holder A.

**HEAT
SHEAR STRENGTH**

Approx. > +170°C

90 µm wet adhesive thickness on 50 µm polyester film and dried at 50°C. Tested according to ASTM D 4498 (SAFT = Shear Adhesion Failure Temperature). Bonded onto a 50 µm polyester film using a hand roller (10 pounds, rolled 5x in each direction). Adhesion area: 1 x 1 inch. Test after 24 h earliest. After drying for 15 min in a drying cabinet at +40°C, shear strength is tested by hanging a 500 g weight onto the sample. Test is started at 40°C, temperature is then increased every 10 min. by 5°C until the sample falls off the substrate.

UV RESISTENCE

Good

**HEALTH HAZARDS/
ENVIRONMENTAL
PROTECTION**

Please follow further information given in the material safety data sheet.

STORAGE

1 year (at 20 - 25°C and tightly closed original container). Protect against freezing.

KIWOPRINT D 162 should not get into contact with unprotected metal for a longer period of time.