

KIWOPRINT® D 154

Acrylic based, screen printable, pressure sensitive adhesive, APEO-free

KIWOPRINT D 154 is a high quality, screen printable, pressure sensitive adhesive for the production of self-adhesive components for the automotive and electronic industry (touch panels, visual instrument panels, front panels, electrical devices). KIWOPRINT D 154 is permanently very sticky, very high heat resistant and cohesive. The dried adhesive film is colourless and does not turn yellow.

PRECAUTIONS

For the production of self-adhesive materials the following facts have to be considered:

1. Check requirements like adhesion strength, climatic load, temperature and UV-resistance.
2. Choose a suitable substrate and test for compatibility with KIWOPRINT D 154 (e.g. soft PVC may interact with the adhesive layer).
3. If direct contact between printing ink and adhesive may occur, test for compatibility, as some inks may interact with the adhesive layer. For technical applications, usually a mesh of 21-140 (T) is being used.
4. When screen printing, the selection of the mesh type is essential for the desired result. The coarser the mesh count, the thicker the adhesive layer and the higher the adhesive values.
5. When screen printing, water resistant emulsions of the AZOCOL range must be used. Ask KIWO for advice.
6. Choose a suitable release liner. Very smooth silicone paper or siliconized film should be used. The adhesive layer orients itself to the release liner and the smoother the release liner is, the smoother the adhesive layer will be after 24 hours. In addition, the silicone layer must be compatible to assure a proper release from the adhesive.

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 long-term compatibility with the component materials. Furthermore, the influences of the liner material and the state or nature of the substrate's structure or roughness needs to be verified. Silicone release agents, plasticizer migration etc. must be checked for and ruled out.

This data sheet is for your information. A legally binding assurance of the product's suitability for a specific purpose cannot be derived from it and no liability can be assumed for any potential damages that may occur. Our products are subject to continuous production and quality control and leave our company in perfect condition.

This product is intended solely for industrial applications and not for use by the end consumer. We recommend to our customers to always test the product themselves since only in this way – also after production – can the freedom from certain substances and the suitability for a particular purpose be verified. The user has to test the product for suitability for the intended application. We reserve the right to modify product specifications. Tests that are not part of the specifications of the product mentioned above have not been carried out.

All information applies only to the above-mentioned product obtained from Kissel + Wolf GmbH. It corresponds to our current state of knowledge, but is not a confirmation of a particular application and is not automatically replenished. All information is valid for a maximum of 12 months (annexes may be provided with their own date) or until legal changes are made in this time period. The recipient of our product is solely responsible for observing any possible property rights as well as existing laws and regulations. Property rights of third parties must be observed. Our terms and conditions of sale and delivery shall apply.

APPLICATION

When screen printing, optimal adjustment of the printing machine can determine the print result. Best printing results can be achieved with a high mesh tension (25 - 30 N/cm). The snap-off should be high (5 - 10 mm), the printing speed also high (from 400 mm/min.). This largely prevents the formation of bubbles. High air humidity facilitates the application of dispersion adhesives. During short breaks the stencil should be flooded with adhesive. If the breaks are longer than 5 -10 min. 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 prior to use. KIWOPRINT D 154 should not be thinned for application. Thinning with water is possible, however, it reduces the solids content, coating thickness and consequently the adhesive strength.

The adhesive can be dried by room temperature or by tunnel dryer for industrial production. Drying temperatures up to +70°C do not have any influence on the adhesive. Drying time depends on the quantity of adhesive to be dried, substrate type, drying temperature and air movement. Best values have to be determined or optimized by yourself.

Only properly dried adhesive layers (transparent film) give highest bond values. For further processing the applied adhesive must be completely dry, only then should the silicone paper or film be applied. Avoid air traps between release liner and adhesive as trapped air will influence the adhesive surface.

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.

ADHERING

The bond of self-adhesive components produced using KIWOPRINT D 154 can be improved by:

1. Dust and oil free parts.
2. Optimum application temperature: 20 - 60°C.
3. Additional pressure (approx. 20 N/ cm²) with a heated silicone rubber pad (40 - 50°C).
4. Preventing air bubbles and stretching the substrate during application.
5. Flat and smooth substrate (i.e. pressure molding parts without burrs or sprue marks).
6. Sufficient adhesion surface area relative to total surface area.

TECHNICAL DATA

BASE	Aqueous acrylic dispersion
COLOUR	Wet: white Dry: colourless, transparent
VISCOSITY	Approx. 16.000 mPas (Brookfield RVT, spindle 6, 20 r/min., 20°C)
SOLIDS CONTENT	Approx. 67,5%
pH-VALUE	Approx. 5
DENSITY	Approx. 1,02 g/cm ³
PEEL STRENGTH	Approx. 12 N/inch (after 1 minute bonding time) Approx. 25 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 5x in each direction) and measured after the corresponding bonding time at 23°C. Adhesion area: 2,54 x 10 cm.
STATIC SHEAR STRENGTH	Approx. 900 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.
DYNAMIC SHEAR STRENGTH	Approx. 132 N/ inch ² 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.
TACK VALUE	Approx. 1100 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. +130°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-RESISTANCE

Very 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 154 should not come into contact with unprotected metal for a longer period of time.