

KIWOPRINT® TC 2000

Screen printable, solvent based pressure sensitive adhesive

KIWOPRINT TC 2000 is a high-quality pressure sensitive adhesive for the production of self-adhesive materials made of paper, cardboard, rigid PVC, glass, metal and industrial foams as well as films made of polycarbonate, polyester, pre-treated polyethylene and polypropylene. Suitable for decals made by the wet or dry transfer method. Materials bonded with KIWOPRINT TC 2000 are very difficult to remove or even irremovable, depending on the characteristics of the substrate. Materials bonded with KIWOPRINT TC 2000 can be used at temperatures of approx. -20°C and +60°C and 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. In general, the adhesive film is sufficiently light fast. If direct influence of sunlight is to be expected, trials are absolutely essential. Bondings are resistant to water, reduced aqueous acids and alkalis as well as to many mineral oils. A test certificate according to EN 71 Part 3 (safety of toys – migration of certain elements) can be provided.

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. Choose the correct substrate and test compatibility with KIWOPRINT TC 2000 (e.g. soft PVC film influences the adhesive layer).
3. In case of a direct contact of KIWOPRINT TC 2000 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 technical applications usually a mesh of 21-140(T) is used.
5. For screen printing applications, solvent resistant emulsions of the AZOCOL range can be used. Ask KIWO for advice.
6. Choose the correct covering material. For surfaces of KIWOPRINT TC 2000, silicone liners with medium separation values are suitable.

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.

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, 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 medium (2-4 mm), print velocity average to high (from 400 mm/s). This largely prevents the formation of bubbles. During short printing breaks the stencil should be flooded with adhesive. If the printing breaks are longer than 5 - 10 min. the screen has to be cleaned.

Stir well before use. KIWOPRINT TC 2000 should not be thinned for application. Thinning with KIWOSOLV L 14 is possible, however, thus solids content, coating thickness and consequently the adhesive strength is reduced.

For clear recognition of the printed adhesive outline, KIWOPRINT TC 2000 can be dyed with pigments of the KIWOMIX C-series. Add up to max. 5%, depending on the desired colour depth. When using critical inks, foaming or levelling disturbances, usually can be eliminated by adding 1-3% KIWOMIX ZL 1058.

The adhesive can be dried at room temperature or in tunnel dryer for industrial production. 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.

Only completely dry adhesives achieve highest bonding values. For further processing the applied adhesive must completely be dry; only then should the silicone paper be applied. A bubble-free laminating of the liner is recommended, as enclosed air influences the adhesive layer.

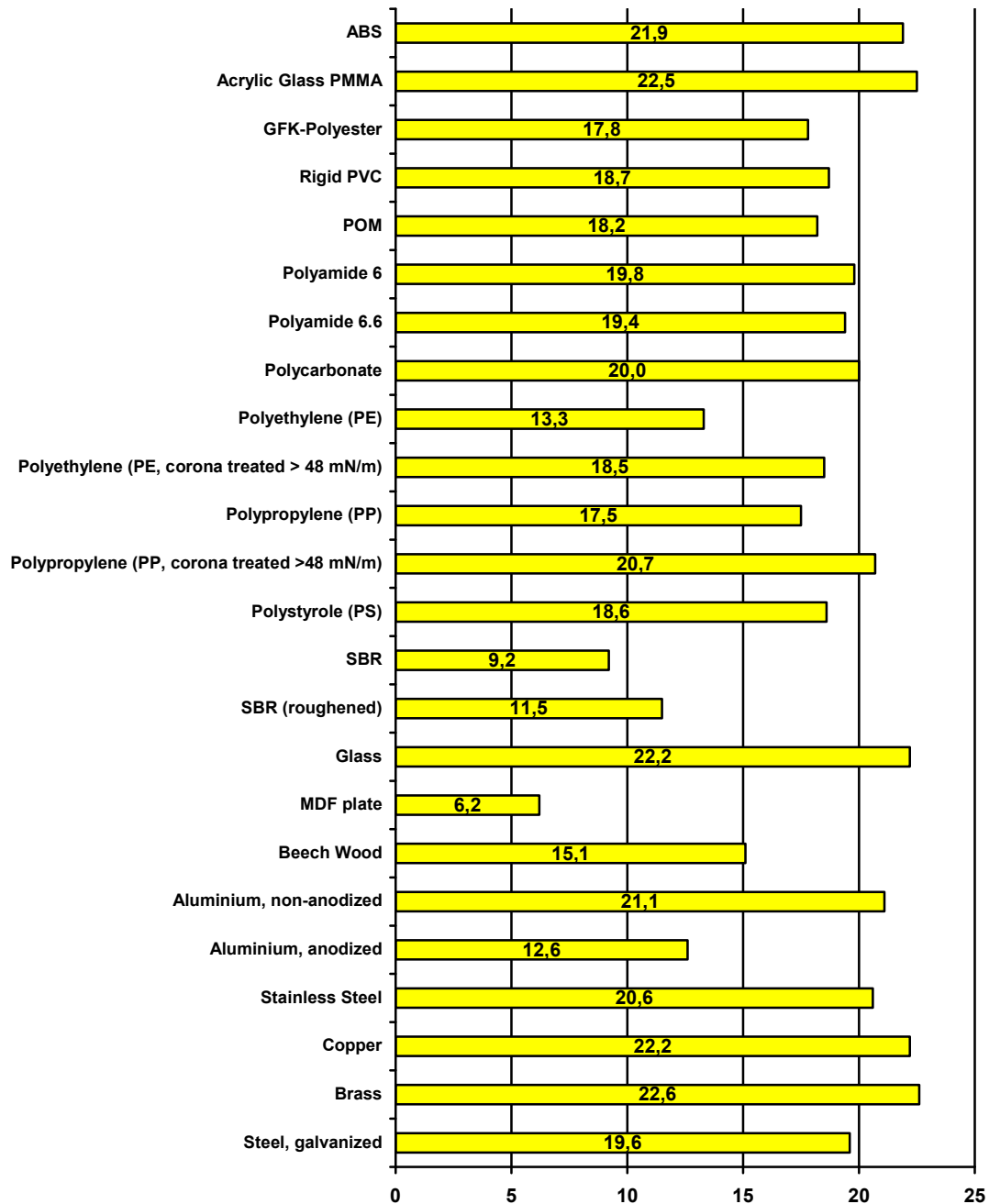
To avoid die cutting problems, the adhesive layer should end 0,5 – 1,0 mm in front of the punch line. Back-lit areas will not be printed as the adhesive film has an influence on the light intensity.

ADHERING

Adhesion of self-adhesive products with KIWOPRINT TC 2000 can be promoted by the following factors:

1. Substrate and adhering partners should be free of dust and stripping agents.
2. Optimum adhering temperature: 20-50°C.
3. Additional contact pressure (approx. 20 N/ cm²) with a heated silicone-rubber stamp (40-50°C).
4. Tension- and bubble free adhesion.
5. Even and smooth substrate (e.g. injection moulding part without holes and edges).
6. Sufficient adhesion area, compared to the total area.

Peel values of KIWOPRINT TC 2000 on different substrates:



N/ cm

Tested according to PSTC 1. Measured 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 angle: 180°, printed with 21-140(T) on 125 µm polycarbonate film, measured after 72 h-storage at normal climate (according DIN 50014-23/50-1). Peel speed 300 mm/min. Applied with a hand roller (according to PSTC standard: 10 pounds, rolled 5x in each direction). Adhesion area: 2,5 x 10 cm.

TECHNICAL DATA

BASIS	Synthesis caoutchouc
COLOUR	Wet: yellowish Dry: transparent
VISCOSITY	Approx. 2.500 mPas (Rhemoat RM 180, MS = 33, D = 100 s ⁻¹ , 23°C)
SOLIDS CONTENT	Approx. 49%
DENSITY	Approx. 0,92 g/cm ³
FLASH POINT	Approx. +25°C
DRYING/ CONSUMPTION	Applied on a 50 µm polyester film by screen printing:

Mesh	21-140 (T)	36-90 (T)	43-80 (T)
Drying (at 20°C)	Approx. 35 min	Approx. 20 min	Approx. 18 min
Drying (at 70°C)	Approx. 1,5 min.	Approx. 1 min	Approx 1 min
Thickness of the dry layer*	Approx. 30 µm	Approx. 15 µm	Approx. 12 µm
Theoretic consumption	Approx. 62 g/m ²	Approx. 31 g/m ²	Approx. 25 g/m ²

*Measuring according to DIN 50981, with stencil thickness gauge Permascope M11 of Helmut Fischer GmbH & Co.

PEEL VALUE	Approx. 20 N/ inch (after 1 min bonding time) Approx. 26 N/ inch (after 24 h bonding time)
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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. 129 N/ inch ²
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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. 43 s
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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. 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 PEEL RESISTANCE	Approx. +60°C 90 µm adhesive thickness onto 50 µm polyester film. Applied to polished stainless steel using a hand roller (10 pounds, rolled 5x in each direction), adhesion area: 2,54 x 10 cm. The bond is stabilised in a drying cabinet headfirst, temperature induced stress was tested by hanging a 30 g weight onto the sample (peel angle: 90°). Measurement at 40°C, temperature is then increased every 15 min. by 10°C until the sample falls off of the polished stainless steel.
HEAT SHEAR STRENGTH	Approx. +85°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	Conditionally
REDUCING/ CLEANING	KIWOSOLV L 14
HEALTH HAZARDS/ ENVIRONMENTAL PROTECTION	When working with KIWOPRINT TC 2000 ensure sufficient ventilation of the working areas. Please follow further information given in the material safety data sheet.
STORAGE	9 months (at 20 - 25°C and tightly closed original container)