

# ACA 20-527

## Heat Resistant, Rapid Drying Adhesive

### Adhesive

PRESSURE  
SENSITIVE  
ADHESIVE

**PRODUCT DESCRIPTION**—ACA 20-527 is a waterborne pressure sensitive adhesive. This pressure sensitive adhesive is very high in solids to facilitate rapid drying during the application process. The dry adhesive exhibits high shear resistance, resistance to high temperatures and sufficient tack to facilitate rapid assembly.

**TYPICAL USE**—ACA 20-527 bonds asphalt sound dampening parts to steel. ACA 20-527 will ensure that the die cut asphalt parts will remain well bonded and in registry on steel stamped parts even though the parts may be exposed to high temperatures or low temperatures during transportation and assembly. The pH of the adhesive has been adjusted so as to avoid flash rusting of the metal substrate. Heat age testing indicates that the asphalt does not migrate into the adhesive, a common cause of adhesive failure.

**COATING METHOD**—Application of the adhesive may be by brush or roller on the specific areas required followed by drying with forced air at elevated temperatures.

**CLEAN UP**— Wash the equipment with water to remove the wet adhesive. Dry adhesive may require a toluene wash. Toluene is an inflammable, volatile solvent and should be used in conformance with OSHA guidelines.

### WET ADHESIVE PROPERTIES

<u>Test</u>	<u>Value</u>	<u>Test</u>	<u>Value</u>
pH . . . . .	5.0 ± 0.5	Percent VOC by volume . . . . .	1.2
Viscosity (cps) . . . . .	5500-6500	Percent water by weight . . . . .	40.06
wt./gal. (lbs.) . . . . .	8.6	Percent water by volume . . . . .	41.22
Percent solids by weight . . . . .	58.9	Percent of VOC per gallon . . . . .	0.089
Percent solids by volume . . . . .	57.6	Pounds of VOC per gallon less water . . . . .	0.152
Percent VOC by weight . . . . .	1.04		

### DRY COATED PROPERTIES (1 MIL FILM, 2 MIL MYLAR)

<u>Test</u>	<u>Value</u>
Peel (189° 20 minute dwell) (pli) . . . . .	1.25
Shear Resistance (hours) . . . . .	300+
Tack (Polyken) . . . . .	260 - 300

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