

# ACA 30-115

## Bonds Metal to Non-Polar Plastics

Adhesive

HEAT  
ACTIVATED  
ADHESIVE

**PRODUCT DESCRIPTION**—ACA 30-115 is a heat activated, water-borne adhesive. ACA 30-115 is based upon a saturated polyurethane with a modified epoxy resin and an adhesion promoter designed for non-polar adherents.

**TYPICAL USE**— ACA 30-115 is designed to bond aluminum to non-polar and polar surfaces such as carbon black filled polypropylene. It may also bond other metals to similar plastics. ACA 30-115 may also be used as a primer for our TPO and PP adhesives.

**COATING METHOD**—The adhesive may be applied to the metal foil by gravure printing, nip-fed reverse roll or wire wound bar coating methods. Brush, spray, or a paint roller may be used for unique shapes. If necessary the adhesive may be diluted with water. The adhesive may be air dried or dried in a forced air oven at about 300°F for a few seconds. It may be necessary to run chill rolls on the oven output to avoid roll blocking.

Adhesive activation typically occurs at 400°F, 100 Psi, for 10 seconds. Conditions may be different depending upon the heat sealer and specific adherents.

**CLEAN UP**— Wash the equipment with water to remove the wet adhesive. The dry coating may require a toluene wash. Toluene is a flammable solvent and must be used according to OSHA safety standards.

### WET ADHESIVE PROPERTIES

Test	Value	Test	Value
pH . . . . .	8 - 9	Percent VOC by volume . . . . .	.1.62
Viscosity (cps) . . . . .	1050	Percent water by weight . . . . .	.66.23
wt./gal. (lbs.) . . . . .	.8.62	Percent water by volume . . . . .	.68.48
Percent solids by weight . . . . .	.32.40	Percent of VOC per gallon . . . . .	.0.12
Percent solids by volume . . . . .	.29.90	Pounds of VOC per gallon less water . . . . .	.0.37
Percent VOC by weight . . . . .	.1.37		

**NON-WARRANTY NOTICE**—Our recommendations, if any, for use of this product are based on tests believed to be reliable. The greatest care is exercised in the selection of our materials and in our manufacturing operations. We make no recommendation to use this product in any manner which conflicts with existing laws and/or patents and WE MAKE NO WARRANTIES, EXPRESS OR IMPLIED, REGARDING THIS PRODUCT OR ITS USE, INCLUDING MERCHANTABILITY AND FITNESS FOR PARTICULAR PURPOSE. THE MANUFACTURER IS NOT LIABLE FOR ANY CONSEQUENTIAL, INCIDENTAL OR SPECIAL DAMAGES OF ANY KIND.



**PEEL ADHESION OF ACA 30-115**

Metal	Plastic	Adhesive Thickness (mils)	Average Peel (pli)	Peak Peel (pli)
8 mil Aluminum. . . .	GM test	0.3	23	25
8 mil Aluminum. . . .	Black PP	0.3	21	23
8 mil Aluminum. . . .	natural PP	0.3	23	25
8 mil Aluminum . . . .	ABS	0.3	23	28
8 mil Aluminum. . . .	Santoprene™ 103-40	0.3	15	19
8 mil Aluminum. . . .	Santoprene™ 103-5 D	0.3	11	25
8 mil Aluminum . . . .	Santoprene™ 101-53	0.3	4	5
8 mil Aluminum. . . .	Santoprene™ 101-65	0.3	6	8
8 mil Aluminum. . . .	Santoprene™ 101-73	0.3	5	7
8 mil Aluminum . . . .	Santoprene™ 101-80	0.3	9	11
8 mil Aluminum. . . .	Santoprene™ 101-87	0.3	13	16
8 mil Aluminum. . . .	TPV	0.3	7	8
8 mil Aluminum. . . .	PVC	0.5	25	37

Peel Adhesion— 180° angle, 5 ipm, 72°F  
 Heat Seal— 400°F, pressure and time variable

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