

# ACA 40-004

## Bonds Metal to PET; Primer Adhesive

Adhesive

HEAT  
ACTIVATED  
ADHESIVE

**PRODUCT DESCRIPTION**—ACA 40-004 is a waterborne heat activated adhesive.

**TYPICAL USE**—ACA 40-004 is primarily designed to bond PET to PET, as well as various other plastics and metals. ACA 40-004 may also be used as a primer to bond PET with TPO/TPE/PP compounds.

**COATING METHOD**—Application of the wet adhesive can be with a roller, brush, spray or traditional coil coating methods such as gravure or knife over roll coaters. The wet adhesive can be dried with forced air or simply allowed to air dry. Heat activation should not take place until the adhesive is thoroughly dry. ACA 40-004 has an activation temperature in the range of 350-450°F. Pressure is recommended during heat activation in order to ensure 100 percent contact of the adhesive with the substrates. After achieving activation temperature at the bond interface the part may be cooled immediately by mechanical means or allowed to cool naturally.

**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

<u>Test</u>	<u>Value</u>	<u>Test</u>	<u>Value</u>
pH . . . . .	9	Percent VOC by volume . . . . .	.4.1345
Viscosity (cps) . . . . .	2700	Percent water by weight . . . . .	36.4726
wt./gal. (lbs.) . . . . .	8.7	Percent water by volume . . . . .	38.7488
Percent solids by weight . . . . .	60.1370	Percent of VOC per gallon . . . . .	.0.3003
Percent solids by volume . . . . .	57.1167	Pounds of VOC per gallon less water . . . . .	.0.4903
Percent VOC by weight . . . . .	3.3904	Color . . . . .	Milky White Liquid

### DRY ADHESIVE PEEL VALUES (8 MIL ALUMINUM FOIL, 180° PEEL FROM PET SHEET)

<u>TEST</u>	<u>AVG</u>	<u>PEAK</u>
Peel (pli) . . . . .	17 . . . . .	20

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