

# ACA 40-005

## Bonds PET and PET/Polyester fabric to metals; Primer Adhesive

Adhesive

HEAT  
ACTIVATED  
ADHESIVE

**PRODUCTY DESCRIPTION**—ACA-40-005 is a waterborne heat activated adhesive.

**TYPICAL USE**—ACA-40-005 is primarily designed to bond PET and polyester fabrics to metal. ACA-40-005 may also be used as a primer to bond PET with thermoplastic olefin, thermoplastic elastomer, and polypropylene (TPO/TPE/PP) compounds.

**COATING METHOD**—Application of the wet adhesive can be via roller, brush, spray or traditional coil coating methods such as gravure or knife over roll coaters. The wet adhesive can be dried via forced air or simply allowed to air dry. Dry the adhesive thoroughly before heat activation to prevent steam blisters. ACA-40-005 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.

**USE AS A PRIMER**—ACA-40-005 may also be used as a primer adhesive to bond PET with TPO/TPE/PP compounds. In this case a second adhesive such as ACA-40-035 should be used at the TPO/TPE/PP interface.

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

### WET ADHESIVE PROPERTIES

Test	Value	Test	Value
pH . . . . .	9.0-9.6	Percent VOC by volume . . . . .	.3.702
Viscosity (cps) . . . . .	500 ± 150	Percent water by weight . . . . .	.42.130
wt./gal. (lbs.) . . . . .	.8.8	Percent water by volume . . . . .	.44.466
Percent solids by weight . . . . .	.54.815	Percent of VOC per gallon . . . . .	.0.269
Percent solids by volume . . . . .	.54.832	Pounds ov VOC per gallon less water . . . . .	.0.484
Percent VOC by weight . . . . .	.3.056	Color . . . . .	Milky White Liquid

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

TEST	AVG	PEAK
Peel (pli) . . . . .	17 . . . . .	20

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