

ACA 40-063

Bonds Aluminum Foil to Aluminum Foil

Adhesive

HEAT
ACTIVATED
ADHESIVE

PRODUCT DESCRIPTION—ACA 40-063 is a waterborne, heat activated adhesive. It is an internally plasticized acrylic acid copolymer where the acid groups promote adhesion to metal oxides on the metal surface. The adhesion can be partially cross-linked through these carboxyl groups to enhance heat resistance or chemical resistance. Since the polymer is acrylic, it performs well both indoors and outdoors. The adhesive must attain a temperature of at least 275°F and be under contact pressure during both heating and cooling for the best bond.

TYPICAL USE— ACA 40-063 is designed to bond aluminum foil to aluminum foil.

COATING METHOD—The waterborne adhesive may be applied by gravure, wire wound bar, or nip fed reverse roll coater on aluminum roll stock and forced air dried for a few seconds at 300° F to 400°F. Cooling rolls are recommended before wind up. The adhesive may be brush or spray applied on unique shapes.

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>
Color	Milky White Liquid

DRY ADHESIVE PEEL VALUES (8 MIL ALUMINUM FOIL, 180° PEEL)

<u>Metal</u>	<u>Adhesion thickness</u>	<u>Avg. Peel</u>	<u>Peak Peel</u>
8 mil Aluminum.....	0.25 mils	15 pli	16pli
8 mil Aluminum.....	0.50 mils	16 pli	20 pli

Heat seal at 100 psi, 400°F, 10 sec.

Viscosity with Brookfield DV11+ at 72°F, Spindle 3, 20 Rpm.

Peel Adhesion at 18° angle and jaw separation rate of 5 in/min.

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