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API ADVANCED POLYMERS INTERNATIONAL

Technical Data Sheet

Gel-Tac® Adhesive 374M-1000

Product Description

Gel-Tac 374M-1000 adhesive is a waterbased adhesive for use in applications that require the properties of low to medium tack and clean removability.

Application

Gel-Tac 374M-1000 adhesive is designed for transfer coating onto polypropylene substrates. 374M-1000 can be coated onto release liner using conventional coating methods such as reverse roll and extrusion.

Physical Property

Total Solids:	41% - 43%
Viscosity:	800cps - 1400cps*
pH:	8.5 - 10.0
Vehicle:	Water
Particle Size:	20 micron average

*Note: Viscosity measured at 10 rpm, 22+/- 1o Celsius, using spindle #2.

Handling & Storage

Gel-Tac 374M-1000 may separate overtime. This is typical of this type of adhesive. Mix before use; adhesive will readily redisperse with mild agitation. Check pH in open coating pans and adjust to 9.0-9.5 with ammonium hydroxide solution, if necessary. If the pH of the adhesive falls below 8.0, coagulation may occur. Air operated diaphragm pumps are recommended to pump the adhesive. Avoid the use of high speed centrifugal pumps. The adhesive will clean up with water and mild soap when wet; dried material may require clean up with a solvent such as acetone or ethyl acetate. Personnel should wear gloves & splash goggles when handling material. Keep container closed to maintain proper pH. Protect the material from freezing conditions.

Typical Performance Properties

Adhesive coated onto 1 mil. polyester film.
Adhesive coat weight 12 gsm/dry.
90o Peel (PSTCS-1-1)

30 min. dwell	178.3g/2.5 cm
24 hour dwell	253g/2.5 cm
Loop tack	224.9g/2.5 cm
Polyken tack	237g

Shelf Life

Gel-Tac adhesive should be stored at temperatures between 50oF and 100oF. Keep containers closed to maintain stability of the adhesive. Shelf life is 6 months.

Packaging

Gel-Tac® adhesive is supplied in 1000kg totes or 200kg drums.

Regulatory Status

Gel-Tac 374M-1000 is in compliance with the following regulations: EN 71 Part 3: 1994, CONEG, Toy Safety Limits (ASTM 963.96a Metals Only), Hasbro Limits (Heavy Metals Only).

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Recommendations of Advanced Polymers International, if any, regarding the use of this product are based upon testing methods believed to be reliable. All component materials are of the highest quality and our manufacturing process is conducted in accordance with the highest of standards. However, we do not recommend that this product be used in any way which violates any law or infringes upon any valid patents. We make no warranties, express or implied, regarding this product or its use, including merchantability and fitness for a particular purpose. The manufacturer is not liable for any consequential, incidental or special damages of any kind.

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