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# TECHNICAL DATA SHEET

## WATERBASED COATINGS

### AL600-45

### AQUALINE IN-LINE BLISTERPACK ADHESIVE

- ◆ Dedicated blisterpack adhesive for use with PVC blisters.
- ◆ Excellent adhesive and bond characteristics.
- ◆ Optimum press stability with exceptional high gloss and drying potential.

#### TECHNICAL CHARACTERISTICS:

Viscosity (DIN 4 @ 20°C)	43-47 Seconds (can be altered if required)
PH	7.8-8.2
Solids	Approx 42%
Gloss (Sheen @ 60° on Gloss Art)	55-65
Drying Speed	Medium – Fast
Rub Resistance	Good
Slip Values	Low
Heat Resistance	110°C.

AL600-45 is suitable for use in the carton, commercial and magazine sectors, and is recommended for food work if contact is indirect. AL600-45 is not suitable for direct food contact. AL600-45 is also suitable for use on toy packaging and certain school materials. For further technical details, please consult the 'Health and Safety' data sheets.

#### APPLICATION CHARACTERISTICS

Single/Double Sided	Single
Recommended Minimum back up time	N/A
Minimum Substrate Grammage	115 gsm
Glueable	Yes
Foil Blockable	Yes
UV Varnishable	Yes
Recommended film weight	5-8gsm wet

AL600-45 is suitable for application via the majority of in-line coaters on Heidelbergs, Komori's, Mitsubishi, Roland, KBA, Ryobi, etc... Application can be via conventional three roller methods or new technology enclosed chamber anilox systems.



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#### **GENERAL TECHNICAL DETAILS:**

AL600-45 has been formulated for in-line application, in order to provide optimum adhesion for subsequent blister work. In order to avoid poor adhesion, it is imperative to check that all materials used in the job are recommended for blister application. This includes the ink and substrate. Pulse Printing Products can supply dedicated inks suitable for blister application.

For best adhesion, a heavier than normal film weight must be applied, with recommended weights in the region of 5-8 gsm. This figure however is not easy to measure, and press trials should be conducted prior to production runs in order to determine maximum film weights without experiencing blocking. A good indication of suitable film weight is the 'orange peel' effect where the coated film appears to ripple.

Due to the heavier film weights that are required for optimum adhesion, a light application of spray powder should be employed.

AL600-45 has been formulated for use with PVC blisters, although excellent results have also been achieved with A PET and PET G.

During the application of blister to board, it is recommended that the platen is maintained at 140-180°C, and has a dwell time of 2-5 seconds. Pressure should be at 40-60 p.s.i.

**Due to the implications involved in substandard work, Pulse Printing Products strongly recommend production trials of AL600-45 prior to long runs. Pulse Printing Products cannot be responsible for work which has not been previously tested.**

#### **STORAGE AND HANDLING:**

Waterbased emulsions should not be exposed to temperatures below 5°C or above 35°C. During cold months, it is recommended that containers are kept off of cold floors and stored on pallets. The Pulse Printing Products range of 'AquaLine' emulsions have a 12 month shelf life - if unopened and stored in the correct conditions. Manufacture date is available on the label.

Waterbased emulsions are non hazardous and require no special storage or labelling.

#### **DISCLAIMER:**

The information contained in this product data sheet is correct to the best of our knowledge at the date of issue. It is intended as a guide for the optimum use of the named product and is not intended as a warranty or as a specification. The information relates only to the product specified and may not be suitable for combinations with other materials or in processes other than those specifically described herein.