



Adhesives for Film Laminating

Flextra® PWF1510

Water-Based Dry Bond

Manufacturer

H.B. Fuller Company
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Product Description

Flextra® PWF1510 is an acrylic - polyurethane laminating adhesive. It can be blended with either Flextra® XR2990 or WD6318 to form a two-component system.

An FDA letter is available upon request.

Coreactant Mixing Information

- with Flextra® XR2990
(Polyaziridine coreactant)
◇ PWF1510 : XR2990 mix ratio = 98:2
- with Flextra® WD6318
(Polyisocyanate coreactant)
◇ PWF1510 : WD6318 mix ratio = 97:3

Typical Film Structures

- OPP to OPP
- OPP to Metalized OPP
- OPP to LDPE
- PET to Metalized PET
- PET to LDPE
- Cellophane to PET
- PLA to PLA
- PET to CPP
- Nylon to CPP

Typical Applications

- Snack food packaging
- Dry goods packaging
- Aqueous food packaging
- Salad bags
- Some medical and industrial packaging
- Coffee pouches
- Stand-up pouches
- Condiment (including hot fill) packaging

Flextra® PWF1510 Typical Application Properties

Pot Life with Coreactant	8 - 12 hours
Coat Weight	1.2 - 1.7 lbs / ream 2.0 - 2.7 gsm
Slit Time	8 - 12 hours
Full Cure Time	24 - 48 hours

Flextra® PWF1510 Typical Physical Properties of

Solids Content	38%
Pounds per Gallon	8.5
Specific Gravity	1.02
Shelf Life	3 months
Viscosity (73°F / 23°C)	70 cPs
Color	Milky White
pH	8.3

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Surface Preparation

Contaminants such as slip additives, oil, dust, corrosion and dirt negatively affect the adhesion of any adhesive. Surfaces must be clean, dry and free from surface contaminants. A surface energy of 40 dynes/cm² or higher is recommended for optimum wet-out. Never use a film in which the dyne level measures less than 38 dynes.

Cleanup

After draining the pan of remaining adhesive, warm water and a stiff nylon or brass brush may be used for cleaning. It is recommended that the adhesive be cleaned before it dries. Dried adhesive may be removed with a brass brush and ethyl acetate, orange oil degreaser, or other cleaning solvents.

Disposal

Dispose the material in compliance with state and local regulations.

Coreactant Mixing Instructions

The adhesive must be stirred with a vortex prior to the addition of the coreactant. Pour the coreactant slowly into the edge of the vortex. Mix for an additional 5 to 10 minutes after all of the coreactant has been added to insure that it is entirely dispersed.

Caution: Adding the coreactant all at once or without proper stirring will shock the adhesive. As a result the coreactant will not properly mix in.

Caution: Flextra[®] WD6318 has to be added slowly to allow dispersion. Rapid addition will cause it to settle to the bottom of the drum or sump.

Caution: While the maximum pot life of this mix is 12 hours, the suggested pot use is 8 hours. Always cover the top of the mix vessel in order to prevent the formation of skin.

Health, Safety and Handling

Consult MSDS for Flextra[®] PWF1510, XR2990, and WD6318.

Protect from freezing. Product is not freeze-thaw stable.

Defoamer

If foaming is present in the sump or pan, the addition of a small amount of WB6328 defoamer is recommended.

If added to the adhesive mix: Slowly add 4 grams of defoamer per 5 gallons of mixed adhesive (adhesive plus coreactant). This is equivalent to a rate of 0.02% defoamer. Additional defoamer can added if foaming persists. Do not exceed 20 grams per 5 gallons of mixed adhesive. If foaming persists, contact HB Fuller.

To knock down foam already formed in the pan, premix one part WB6328 into 10 parts of a 50:50 blend of IPA and water.

The WB6328 is available directly from Emerald Foam Control (864) 862-4474 under the trade name Foamblast 327.

www.hbfuller.com

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