



# Technical Datasheet

Bostik, Inc.

## FLEXCRYL™ ClearCycle 1000 Acrylic Emulsion Polymer

Product Description	FLEXCRYL ClearCycle 1000 acrylic emulsion polymer is a coater ready pressure sensitive adhesive specifically designed to be used on BOPP labels and washed off in the PET recycling wash process. FLEXCRYL ClearCycle 1000 is designed for clean bottle to bottle recycling to support a sustainable circular economy.
Suggested Uses	<ul style="list-style-type: none"><li>• To be used on clear or opaque BOPP labels where PET recycling is required.</li><li>• Pressure sensitive labels will adhere well to PET substrates including the following:<ul style="list-style-type: none"><li>• PET bottles</li><li>• PET trays</li><li>• PET thermoforms</li></ul></li></ul>
Characteristics	<ul style="list-style-type: none"><li>• Excellent anchorage to BOPP film</li><li>• Excellent adhesion to PET substrate</li><li>• Adhesive and BOPP label are cleanly removed from the PET flake in the sink float step of the PET recycling process</li><li>• Adhesive does not require surface treatment of BOPP</li><li>• Adhesive displays "All Temperature" properties to -18°F (-28°C)</li><li>• APEO free</li><li>• APR approved for PET recycling</li><li>• APR critical guidance test code PET-CG-02</li><li>• Following laboratory study, PET-CG-02 BOPP PS labels can be removed within 5 minutes or less</li></ul>
Regulatory	The ingredients in this product are in compliance with the following chemical inventories: Toxic Substances Control Act Inventory (TSCA), Non Domestic Substances List (NDSL), European Inventory of Existing Chemical Substances (EINECS).

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### Typical Properties:

Percent Solids	58%
Brookfield Viscosity @ 77°F Spindle #3 @ 20 rpm	1200
pH	7.2
Film Appearance	Clear
Stabilization System	Anionic

Sample Prep	
Coating method	Transfer
Drying conditions	2 min 15 194°F (90°C)
Adhesive Film Thickness	0.5 mil
Facestock	2 mil (50.8 micron) Mylar Polyester
Substrate	Stainless Steel

Adhesion Properties	
PSTC-101, 180° Peel Adhesion	
(15 minute dwell)	1.8 lbs/in
(24 hour dwell)	1.8 lbs/in

Tack Properties	
PSTC-16 Loop Tack	3.0 lbs/in <sup>2</sup>

Cohesive Properties	
PSTC-107, Shear Adhesion	
(1X1X1kg)	14 hours

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### Typical BOPP Performance

Sample Prep	
Coating method	Transfer
Drying conditions	2 min 15 194°F (90°C)
Adhesive Film Thickness	0.5 mil
Facestock	2 mil White Opaque BOPP
Substrate	Stainless Steel

Adhesion Properties	
PSTC-101, 180° Peel Adhesion	
(15 minute dwell)	1.5 lbs/in
(24 hour dwell)	1.5 lbs/in
PSTC-101, 90° Peel Adhesion (15 min.) @ -18°C	
	1.4 lbs/in

Loop Tack	
PSTC-16 Loop Tack	2.2 lbs/in <sup>2</sup>
PSTC-16 @ -18°C	0.7 lbs/in <sup>2</sup>

### Notice

All information presented herein is believed to be accurate and reliable, and is solely for the user's consideration, investigation and verification. The information is not to be taken as an express or implied representation or warranty for which Bostik, Inc. assumes legal responsibility. Any warranties, including warranties of merchantability, fitness for use or non-infringement of intellectual property rights of third parties, are herewith expressly excluded.

Since the user's product formulations, specific use applications and conditions of use are beyond the control of Bostik. Bostik makes no warranty or representation regarding the results which may be obtained by the user. It shall be the sole responsibility of the user to determine the suitability of any of the products mentioned for the user's specific application.

Bostik requests that the user reads, understands and complies with the information contained herein and the current Safety Data Sheet.

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