



Vitel® 3350B

COPOLYESTER LAMINATING RESIN

KEY FEATURES

- Low glass transition temperature
- Good adhesion to variety of substrates: PET, metals, vinyls and treated olefins (PP or PE)
- Good flow characteristics

DESCRIPTION

Bostik Vitel® 3350B is an amorphous, linear, saturated polyester with solubility in certain common solvents (e.g. Ethyl acetate, MEK, Toluene). V3350B is a low Tg polymer that is designed to be used as part of a solvent-based laminating adhesive. The low glass transition temperature yields highly flexible films. The Tg can be modified to meet application requirements by blending this product with other Vitel® resins and can be used as a modifier in other Vitel® formulations to impart flexibility and improve adhesion.

KEY BENEFITS

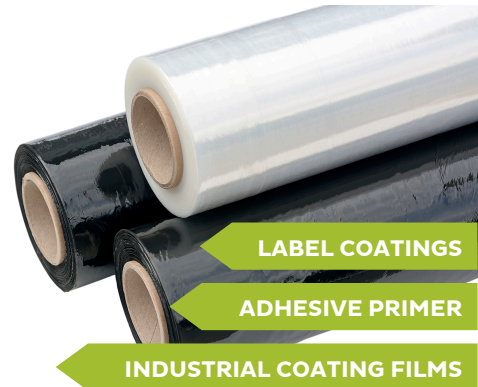
- Excellent flexibility
- Compatible with other Vitel® resins to formulate to achieve desired performance
- Good solution stability

PACKAGING

V3350B cold flows at ambient temperature and is sold in slab form (packed in poly bag).

SHELF LIFE

The shelf life for V3350B is approximately 9 months when stored in originally closed containers at temperatures between 41 and 95°F (5-35°C).



TYPICAL PHYSICAL PROPERTIES

Description	Results
Color	Amber
CIE Lab Color	L* : 95 (min.) b* : 10 (max.)
Intrinsic Viscosity (dL/g)	0.80
Specific Gravity	1.22
Melt flow (ASTM E 28-67)	257°F (125°C)
Odor / Taste	None / None

TYPICAL POLYMER PROPERTIES

Description	Results
Molecular Weight (Mw)	approx. 70,000
Acid Number	1-3
Hydroxyl Number	3-6
Glass Transition, Tg (ASTM E 28-67)	61°F (16°C)

STORAGE & HANDLING

Elevated warehouse temperatures may cause more cold flow in the resin and difficulties in the removal of the wrapping film. Static charges may also develop due to the unwrapping of this film. Precautions against a static discharge should be taken particularly in areas where solvent vapors exist. Otherwise, there are no special precautions necessary in handling this resin. Under typical ambient conditions, Bostik V3350B is an inert material.

DILUTION

Solvate at 30 - 40% total solids with agitation using an explosion proof mixing vessel. The viscosity and total solids can be adjusted to specific application equipment and substrate needs. Dilution may be done with PU grades (< 0.1% H₂O content) of Ethyl acetate, Acetone, MEK or a mixture of these solvents.

SOLUTION POT LIFE

Bostik Vitel® in solution has very good pot life stability. If container is well sealed solution will keep for at least 6 months at room temperature storage. When used in conjunction with curative, pot life will vary but not recommended to hold reactive solution more than 8 hours before application.

APPLICATION TECHNIQUES

Can be used on all dry laminating machines, with smooth or rotogravure rollers. The adhesive system should be processed at a solids content of approx. 20 - 23% when applied via gravure. Ideal coating viscosity is between 75 - 115 cP. At least 2 g/m² (dry) is recommended, but optimum adhesion is obtained with an application weight of approx. 3 g/m². For aggressive requirements, the coating weight needs to be increased to 4 g/m² or higher.

DRYING

Drying conditions must be adjusted to substrate, application weight and line speed in order to avoid the retention of solvents. The dried and fully cured adhesive film will be transparent and neutral in odor.

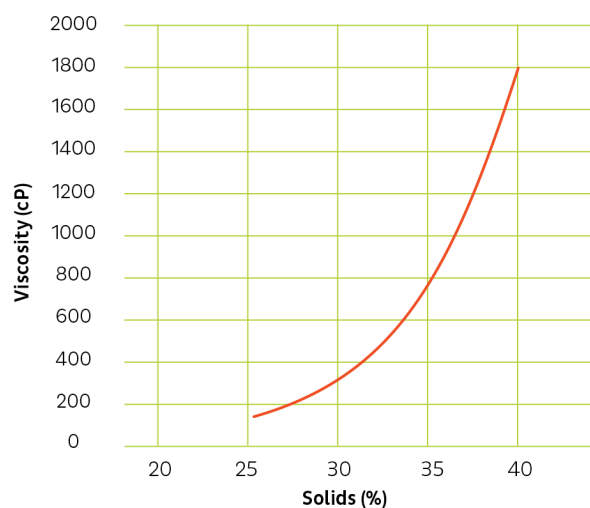
ACTIVATION TEMPERATURE

The minimum activation temperature for this product is 194°F (90°C) but 257°F (125°C) is recommended.

FDA 21 CFR NUMBERS

V3350B complies with the positive lists of many internationally accepted guidelines for the production of articles intended to come into direct and indirect contact with foodstuff. Please contact your Bostik representative with the specific application.

VISCOSITY CURVE - MEK



HEALTH & SAFETY PRECAUTIONS

The Safety Data Sheet should be consulted for proper handling, clean up and spill containment before use. Keep containers covered to minimize contamination.

LIMITED WARRANTY

The Limited Warranty for this product can be found at www.bostik-us.com/resource-center/warranties or by calling 1-800-726-7845 (choose option 2, then option 2 again). To the maximum extent allowed by law, Bostik disclaims all other express or implied warranties, including without limitation warranties of merchantability and fitness for a particular purpose. Unless otherwise stated in the limited warranty, the sole remedy for breach of warranty is replacement of the product or refund of the buyer's purchase price. Bostik disclaims any liability for direct, incidental, consequential, or special damages to the maximum extent allowed by law. Disclaimers of implied warranties may not be applicable to certain classes of buyers and some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitations may not apply to you. It is the buyer's obligation to test the suitability of the product for an intended use prior to using it. The Limited Warranty extends only to the original purchaser and is not transferable or assignable. Any claim for a defective product must be filed within 30 days of discovery of a problem, and must be submitted with written proof of purchase.

BOSTIK HOTLINE

Smart help
1-800-726-7845

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This document supersedes all previously published literature.
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