**DESCRIPTION**

Vitel® 3300B is a thermoplastic, high molecular weight, linear saturated copolyester resin. This flexible amorphous polymer, slightly tacky at room temperature, offers high elongation and moderate tensile values. The long term solution stability in aromatic or ketone solvent systems makes V3300B a very good adhesive binder for attaching difficult to adhere webs to a variety of substrates resulting in flexibility, improved pigment binding and electrical resistance.

V3300B is often used with a polyisocyanate as a two part laminating adhesive. When used in conjunction with a Bostik hardener, the strength and temperature resistance of V3300B is increased. The major applications of V3300B are in adhesive applications or as a modifier for hard resinous coatings. When used as a modifier, V3300B improves flexibility and adhesion to a variety of substrates.

**PACKAGING**

V3300B is sold in pellets packed in poly bags. Elevated warehouse temperatures may cause more cold flow in the resin and difficulties in the removal of the wrapping film. Please contact your Bostik representative for additional packaging options.

**SHELF LIFE**

The shelf life of V3300B is approximately 9 months when stored in the sealed, original container at temperatures of 5°C to 35°C.

---

### TYPICAL PHYSICAL PROPERTIES

<table>
<thead>
<tr>
<th>Description</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>Appearance</td>
<td>Clear to pale yellow slabs</td>
</tr>
<tr>
<td>CIE Lab Color</td>
<td>L*: 95 (min.)</td>
</tr>
<tr>
<td></td>
<td>b*: 30 (max.)</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>1.22</td>
</tr>
<tr>
<td>Shore Hardness, A</td>
<td>67</td>
</tr>
<tr>
<td>Tensile Strength</td>
<td>500 psi</td>
</tr>
<tr>
<td>Elongation at Break</td>
<td>800%</td>
</tr>
</tbody>
</table>

### TYPICAL POLYMER PROPERTIES

<table>
<thead>
<tr>
<th>Description</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>Molecular Weight</td>
<td>63,000</td>
</tr>
<tr>
<td>Acid Number</td>
<td>0 - 2</td>
</tr>
<tr>
<td>Hydroxyl Number</td>
<td>3 - 6</td>
</tr>
<tr>
<td>Intrinsic Viscosity</td>
<td>0.80</td>
</tr>
<tr>
<td>Glass Transition Point</td>
<td>16°C (61°F)</td>
</tr>
<tr>
<td>Softening Point</td>
<td>125°C (257°F)</td>
</tr>
</tbody>
</table>
**STORAGE & HANDLING**

Like all synthetic resins, V3300B can retain or develop static charge due to its handling. Precautions should be taken to avoid a static discharge. Use caution near flammable vapors.

Elevated warehouse temperatures may cause more cold flow in the resin and difficulties in the removal of the wrapping film. Under typical ambient conditions, Bostik Vitel® 3300B is considered an inert material.

**APPLICATION TECHNIQUES**

Vitel® 3300B is most frequently applied from solution so solvent selection is important. Solvation can be obtained using PU grades (<0.1% H2O content) of ethyl acetate, acetone, MEK or a mixture of these solvents. An appropriate mixing vessel (explosion proof) with agitation should be used. Solutions of 30 - 40% total solids can be made, however, the viscosity and solids content should be adjusted to application equipment and substrate needs.

Once in solution, V3300B 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.

A coating weight of at least 2 g/m² (dry) is recommended, but optimum adhesion is obtained with an application weight of approximately 3 g/m². For aggressive requirements, the coating weight needs to be increased to 4 g/m² or higher.

**DILUTION**

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**

Vitel® 3300B in solution has very good pot life stability. If the container is well sealed, the solution will keep for at least 6 months at room temperature storage.

When used in conjunction with curative, pot life will vary. However, it is not recommended to hold the reactive solution for more than 8 hours before application.

**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 70°C (158°F) but 125°C (257°F) is recommended.

**FDA 21 CFR NUMBERS**

V3300B complies with the positive lists of many internationally accepted guidelines for the production of articles intended to come into indirect contact with foodstuff. Please contact your Bostik Representative with the specific application.

**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

Limited Warranty found at www.bostik.com/us or call 800.726.7845. 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. The information, data, and recommendations made herein are based on Bostik’s research only and are not guaranteed to be accurate. The performance of the product, its shelf life, and application characteristics will depend on many variables, including but not limited to the kind of materials to which the product will be applied, the environment in which the product is stored or applied, and the equipment used for application. Any change in any of these variables can affect the product’s performance. Bostik does not warrant the product’s suitability for any particular application. 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.

Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute permission, inducement, or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

BOSTIK HOTLINE

Smart help
1-800-726-7845

Bostik, Inc.
11320 W. Watertown Plank Road
Wauwatosa, WI 53226
www.bostik-us.com

This document supersedes all previously published literature.
08.20.2018