Adhesives Formulary Handbook (Reprint)
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Adhesives surround us in nature and in our daily lives. Adhesive, or glue, is a mixture in a liquid or semi-liquid state that is capable of holding materials together by surface attachment. An adhesive is a compound that adheres or bonds two items together so as to form a single unit. Adhesives may come from either natural or synthetic sources. Adhesives and sealants virtually touch every part of our lives. Some modern adhesives are extremely strong, and are becoming increasingly important in modern construction and industry. A large and growing number of adhesives are available in the market. Adhesives for this growing market range from the simplest glues and mucilages for furniture making and repair, to metal to metal bonding for frame construction. There is no end in sight to the new materials, new formulation, and new uses to which adhesives will be put in the future. Formulations generally are compounded to satisfy a special need or needs. Therefore, uniformity of neither product nor end use exists. Applicators of different adhesives are designed according to the adhesive being used and the size of the area to which the adhesive will be applied. The adhesive is applied to either one or both of the materials being bonded. The pieces are aligned and pressure is added to aid in adhesion and rid the bond of air bubbles. Adhesives are of great use across innumerable industrial and commercial applications.

Some of the fundamentals of the book are water based industrial type adhesives, home construction and related adhesives, water based wallpaper adhesive, fabric adhesives, water based adhesive for bonding non woven fabric to non woven fabric by knife coating, film adhesives, water based food packing adhesive for bonding, flocking adhesives, foam adhesives, water based adhesive for bonding urethane, industrial adhesives, bag seam and bottom paste adhesives, solid fiber, fiberboard and corrugated board adhesives, packaging adhesives etc.

This indispensable book contains numerous essential adhesive formularies distinguished by application. This book will be an invaluable resource to its readers, upcoming entrepreneurs, scientists, existing industries, technical institutions, etc.

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Hot Melt General Purpose Label Adhesive (Resin)
Hot Melt Label Adhesive (Ethylene-Vinyl Acetate/Polyethylene/Resin)
Hot Melt Label Adhesive for Difficult Substrates (Ethylene-Vinyl Acetate/Polyterpene)
Hot Melt Hot Pick-Up Label Adhesive (Resins/Polyvinyl Butyal)
Hot Melt Pressure Sensitive Label Adhesive (Resins/Rubbers)
Hot Melt Pressure Sensitive Label Adhesive (Resins/Rubbers)

Hot Melt Pressure Sensitive Label Adhesive (Rubber/Resin)

Hot Melt Pressure Sensitive Permanent Label Adhesive (Polypropylene/Resin/Polybutene)

Hot Melt Label and Closure Adhesive (Ethylene-Vinyl Acetate/Resin)

19. PAPER AND PACKAGING TYPE ADHESIVES

Hot Melt Carton Sealing Adhesive (Ethylene-Vinyl Acetate/Resin)

Hot Melt Carton Sealing Adhesive for Low Temperature Applications (Ethylene-Vinyl Acetates/Polyterpene)

Hot Melt Carton and Case Sealing Adhesive (Ethylene-Vinyl Acetate/Resins)

Hot Melt Case Sealing Adhesive (Polyethylene/Polyterpene/Ethylene-Vinyl Acetate)

Hot Melt Fast Assemble Carton and Case Sealing Adhesive (Ethylene-Vinyl Acetate/Resin/Polyethylene/Rubber)

Hot Melt Curtain Coater Adhesive (Polyterpene/Ethylene-Vinyl Acetate)

Hot Melt Adhesive for Form and Fill Pouches (Ethylene-Vinyl Acetate/Resin)

Hot Melt Adhesive for Frozen Food Cartons (Ethylene-Vinyl Acetate/Polyterpene)

Hot Melt Glassine and General Purpose Paper Adhesive (Polyamides)

Hot Melt Paper Laminating Adhesive (Polybutene/Resin/Rubber)

Hot Melt Laminating Adhesive for Paper, Film and Foil (Polyterpene/Polypropylene)

Hot Melt Packaging Adhesive (Ethyl Cellulose/Resins)

Hot Melt Packaging Adhesive (Ethyl Cellulose/Resins)

Hot Melt Packaging Adhesive (Ethyl Cellulose/Resins)

Hot Melt Packaging Adhesive (Ethyl Cellulose/Resins)

Hot Melt Packaging Adhesive (Ethyl Cellulose/Resins)
Hot Melt Packaging Adhesive (Resins/Polyvinyl Butyral)
Hot Melt Polyethylene Adhesive (Polyamides)
Hot Melt Adhesive for Soap Wrappers and Bands (Ethylene-Vinyl Acetate)
Hot Melt Tray-Forming and Case-Sealing Adhesive (Polyethylenes/Polyterpene)
Hot Melt Wax Paper Adhesive (Resins/Polyvinyl Butyral)

20. PRESSURE SENSITIVE ADHESIVES

Hot Melt Pressure Sensitive Adhesive (Polybutenes/Resin)
Hot Melt Pressure Sensitive Adhesive (Polybutenes/Resin)
Hot Melt Pressure Sensitive Adhesive (Polybutenes/Resins/Polypropylene)
Hot Melt Pressure Sensitive Adhesive (Polypropylene/Rosin)
Hot Melt Pressure Sensitive Adhesive (Polypropylene/Rosin)
Hot Melt Pressure Sensitive Adhesive (Polypropylene/Rosin/Polybutene)
Hot Melt Pressure Sensitive Adhesive (Polyterpene/Ethylene-Vinyl Acetate/ Polyethylene)
Hot Melt Pressure Sensitive Adhesive (Polyterpene/Isoprene-Styrene/Polybutene/ Resin)
Hot Melt Pressure Sensitive Adhesive (Polyterpene/Isoprene-Styrene/Polybutene/ Resin)
Hot Melt Pressure Sensitive Adhesive (Polyterpene/Isoprene-Styrene/Polybutene/ Resin)
Hot Melt Pressure Sensitive Adhesive (Polyterpene/Isoprene-Styrene/Polybutene/ Resin)
Hot Melt Pressure Sensitive Adhesive
(Polyterpene/Styrene-Isoprene-Styrene/Styrene-Butadiene)

Hot Melt Pressure Sensitive Adhesive
(Polyterpenes/Ethylene-Vinyl Acetate)

Hot Melt Pressure Sensitive Adhesive
(Resin/Rubber)

Hot Melt Pressure Sensitive Adhesive
(Rubber/Polyterpene/Polybutene/Resin)

Hot Melt Pressure Sensitive Adhesive
(Rubber/Polyterpene/Polybutene/Resin)

Hot Melt Pressure Sensitive Adhesive
(Rubber/Polyterpene/Resin/Polybutene)

Hot Melt Pressure Sensitive Adhesive
(Rubber/Resins)

Hot Melt Low-Cost Pressure Sensitive Adhesive
(Polypropylene/Resin/Polybutene)

Hot Melt Low-Cost Pressure Sensitive Adhesive
(Polypropylene/Resin)

Hot Melt Sprayable Pressure Sensitive Adhesive
(Polyterpene/Styrene-Isoprene-Styrene/Styrene-Butadiene)

SECTION V
HOT MELT COATINGS

21. INDUSTRIAL TYPE COATINGS

Hot Melt Stop-Off Plating Coating (Cellulose Acetate Butyrate)

Hot Melt Strippable Coating (Cellulose Acetate Butyrate)

Hot Melt Strippable Coating (Cellulose Acetate Butyrate)
Butyrate/Resin
Hot Melt Strippable Coating (Ethyl Cellulose)
Hot Melt Strippable Coating (MIL-P-149B, Type II) (Cellulose Acetate Butyrate)
Hot Melt Strippable Coating (MIL-P-149B, Type II) (Cellulose Acetate Butyrate)
Hot Melt Strippable Coating (MIL-P-149B, Type II) (Cellulose Acetate Butyrate)
Hot Melt Strippable Coating (MIL-P-149B, Type II) (Cellulose Acetate Butyrate)
Hot Melt Strippable Coating (MIL-P-149B, Type II) (Cellulose Acetate Butyrate)
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Hot Melt Strippable Coating (MIL-P-149B, Type II) (Cellulose Acetate Butyrate)
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Hot Melt Strippable Coating (MIL-P-149B, Type II) (Cellulose Acetate Butyrate)
Hot Melt Strippable Coating (MIL-P-149B, Type II) (Cellulose Acetate Butyrate)
Hot Melt Strippable Coating (MIL-P-149B, Type II) (Cellulose Acetate Butyrate)
Hot Melt Strippable Coating For Metal Parts (MIL-P-149A,) (Ethyl Cellulose)

22. PAPER AND PACKAGING TYPE COATINGS
Hot Melt Coating for Aluminum Foil Soap Wrappers (Ethylene-Vinyl Acetate/ Polyethylene/Resin)
Hot Melt Coating for Film with Heat-Sealable Properties (Ethylene-Vinyl Acetate/ Resin/Polybutene)
Hot Melt Coating for Frozen Food Cartons (Polyethylene)
Hot Melt Food-Packaging Coating (Resin/Ethyl Cellulose)
Hot Melt Frozen Food-Packaging Coating (Resin/Ethyl Cellulose)
Hot Melt General Barrier Coating for Corrugated Containers (Ethylene-Vinyl Acetate/Polyterpene/Polyethylene)
Hot Melt General Purpose Coating (Polyterpene/Ethylene-Vinyl Acetate)
Hot Melt Heat-Sealable Paper Coating (Ethylene-Vinyl Acetate/Resin)
Hot Melt High Gloss Display Coating (Ethylene-Vinyl Acetate/Polyterpene/ Polyethylene)
Hot Melt High Gloss Low-Viscosity Display Coating (Polyethylene/Polyterpene)
Hot Melt High Gloss General Purpose Coating (Polyethylene)
Hot Melt High Gloss Packaging Coating (Ethylene-Vinyl Acetate/Polyterpene)
Hot Melt High Gloss Packaging Coating for
All Food Cartons (Polyethylene)
Hot Melt High Gloss Paper Coating with
Heat-Sealable Properties (Resin)
Hot Melt High Gloss Paper Coating with
Heat-Sealable Properties (Resin)
Hot Melt Hot Tack Coating for Non-porous
Surfaces (Ethylene-Vinyl Acetate-Acid/
Polyterpene)
Hot Melt Impregnant for Corrugated Boxes
(Resin)
Hot Melt Impregnant for Corrugated Boxes
(Resin)
Hot Melt Impregnant for Corrugated Boxes
(Resin)
Hot Melt Label Coating Adhesive
(Polyethylene/Polyterpene/Polybutene)
Hot Melt Low Cost Adhesive Coating
(Resin/Rosin)
Hot Melt Low Cost Adhesive Coating (Resin/
Rosin/Butyl)
Hot Melt Packaging Coating for Bread Wrappers
(Resin/Ethyl Cellulose)
Hot Melt Packaging Coating for Curtain
Coater Application on Frozen Food
Cartons (Ethylene-Vinyl Acetate/Resin)
Hot Melt Packaging Coating for Curtain
Coater Application on Frozen Food Cartons
(Resins)
Hot Melt Packaging Coating for Curtain
Coater Application on Frozen Food Cartons
(Resins)
Hot Melt Packaging Coating for Curtain Coater
Application on Frozen Food Cartons (Resins)
Hot Melt Packaging Coating for Curtain
Coater Application on Frozen Food Cartons
(Resins)
Hot Melt Packaging Coating for Folding Food
Cartons (Resin)
Hot Melt Packaging Coating for Folding Food
Cartons (Resin)
Hot Melt Packaging Coating for Folding Food
Cartons (Resins)
Hot Melt Packaging Coating for Folding Food
Cartons (Resin)
Hot Melt Paper Coating (Cellulose Acetate
Butyrate)
Hot Melt Paper Coating (Cellulose Acetate/Butyrate/Resin-Vinyl Acetate)
Hot Melt Paper Coating (Resin)
Hot Melt High Gloss Paper Coating for Curtain Coaters (Ethylene-Vinyl Acetate/Polyethylene)
Hot Melt Paper Coating for Curtain Coaters (Ethylene-Vinyl Acetate/Polyethylene)
Hot Melt Paper Coating with Heat Sealable Properties (Resin/Rosin)
Hot Melt Paper and Packaging Coating (Resins/Ethyl Celulose)
Hot Melt Pattern Coating and High Gloss Carton Coating (Ethylene-Vinyl Acetate/Polyethylene)
Hot Melt Pattern Coating and High Gloss Carton Coating (Ethylene-Vinyl Acetate/Polyethylene)
Hot Melt Pattern Coating and High Gloss Carton Coating (Polyethylene)

SECTION VI
MISCELLANEOUS ADHESIVES ANOATINGS

23.EPOXY ADHESIVES

Epoxy General Purpose Adhesive (Two Component: Epoxy/Curing Agent)
Epoxy Adhesive for Bonding Wet to Cured Concrete (Two Component: Epoxy/Curing Agent)

24.OIL-BASED ADHESIVES

Acoustical Tile Adhesive-Low Cost Type (Tall Oil Pitch/Resin)
Cove Base Tile Adhesive-Low Cost Type (Tall Oil Pitch/Resin)
Oil-Based Floor Tile Adhesive-Natural High-Quality Low Cost Type (Soyabean Oil Pitch/Resin)
Oil-Based Floor Tile Adhesive-White High-Quality Moderate Cost Type (Soyabean Oil Pitch/Rosin)

25.PLASTISOL ADHESIVES AND COATINGS

Plastisol Adhesives for Bonding Vinyl Plastisol or Vinyl Sheets to Many Substrates (Vinyl Chlorides)
Plastisol Adhesives for Bonding Vinyl Film to Fabric by Roller Coat Application (Vinyl Chloride)

Plastisol Fire-Retardant Continuous Coating for Fabric (Vinyl Chloride/Chlorinated Paraffin)

Plastisol Flame-Retardant Coating for Metal, Wood and Fabrics (Polyvinyl Chloride)

Plastisol Spread-Coating Compound (Vinyl Chloride)

Plastisol Weather-Resistant Coating for Metal, Wood and Fabrics (Vinyl Chloride)

26. RESIN EMULSIONS FOR FURTHER COMPOUNDING

Resin Emulsion for Compounding Emulsion Adhesives (Resin)

Resin Emulsion Base for Compounding Emulsion Adhesives (Resin)

Resin Emulsion for Compounding Emulsion Adhesives (Resin)

SECTION VII
MISCELLANEOUS PATCHING AND SEA COMPOUNDS

27. CAULKING COMPOUNDS

Oil-Based Caulking Compounds (TT-C-598) (Oil)

Oil-Based Caulking Compounds - General Purpose Grade (Linseed Oil/Polybutene)

Oil-Based Caulking Compounds - General Purpose Rope Grade (Polybutene)

Oil-Based Caulking Compounds - Gun Grade (Soyabean Oil/Polybutene)

Oil-Based Caulking Compounds - Gun Grade (Polybutene)
Oil-Based Caulking Compounds - Aluminum Gun Grade (TT-C-598b) (Soyabean Oil)
Oil-Based Caulking Compounds - High-Quality Moderate-Cost Gun Grade (Soyabean Oil/Polybutene)
Oil-Based Caulking Compounds - Low-Cost Gun Grade (Soyabean Oil/Polybutene)
Oil-Based Caulking Compounds - Natural Special Gun Grade (Soyabean Oil/Polybutene)
Oil-Based Caulking Compounds - High-Quality Knife Grade (Oils)
Oil-Based Caulking Compounds - High-Quality Knife Grade (Soyabean Oils)
Oil-Based Caulking Compounds - Household Tub Grade (Resin)
Oil-Based Caulking Compounds - White Durable Grade (Soyabean Oil)
Polyuretane Caulking Compounds - Flexible Grade (Two Component: Urethane-Polyol)
Polyuretane Caulking Compounds - Flexible Grade (Two Component: Urethane-Polyol)
Polyuretane Caulking Compounds - Flexible Grade (Two Component: Urethane-Polyol)
Solvent-Based Caulking Compound - Aluminum Grade (Butyl/Polyterpenes)
Solvent-Based Caulking Compound - White Grade (Butyl/Polyterpenes)
Solvent-Based Caulking Compound - High-Quality Grade (TT-S-001657) (Polybutene/Butyl)
Solvent-Based Caulking Compound - High-Quality Grade (TT-S-001657) (Polybutene/Butyl/Resin)
Solvent-Based Caulking Compound - High-Quality Grade (TT-S-001657) (Polybutene/Resin)
Solvent-Based Caulking Compound - High-Quality Flexible Gun Grade (Polybutene/Butyl phenolic)
Solvent-Based Caulking Compound - High-Quality General-Purpose Grade (TT-S-001657) (Polybutene/Butyl/Resin)
Solvent-Based Caulking Compound - Non-skinning Gun Grade (Polybutene/Soyabean Oil)
Solvent-Based Caulking Compound - Gun Grade (Butyl)
Water-Based Caulking Compound - General
Purpose Grade (Acrylic)
Water-Based Caulking Compound - General
Purpose Grade (Ethylene-Vinyl Acetate)
Water-Based Caulking Compound - General
Purpose Grade (Ethylene-Vinyl Acetate)
Water-Based Caulking Compound - High-Quality
Gun Grade (Acrylic)
Water-Based Caulking Compound - High-Quality
Gun Grade (Acrylic)
Water-Based Caulking Compound - High-Quality
Gun Grade (Acrylic)
Water-Based Caulking Compound - High-Quality
Flexible Grade (Vinyl Acetate-Acrylic)
Water-Based Caulking Compound - High-Quality
Moderate-Cost Gun Grade (Acrylic)
Water-Based Caulking Compound - White Gun
Grade (Acrylic)
Water-Based Caulking Compound - White High-Quality
Low-Cost Household Tub Grade (Acrylic)

28. CEMENT, CONCRETE AND PLASTER
PATCHING COMPOUNDS

Cement Topping Mix - Dry Type (Sand/Cement/Vinyl Acetate/Vinyl Alcohol)
Plaster Patching Compound - Dry Type (Plaster/Vinyl Acetate)
Patching Compound for Masonry - Trowel Grade (Three Component: Epoxy-Hardener-Sand)
Water-Based Patching Compound for Concrete - High Quality Paste Type (Acrylic)

29. GLAZING COMPOUNDS

Oil Based Glazing Compound - Elastic Grade (Soyabean Oil/Polybutene)
Oil Based Glazing Compound - Greenhouse Grade (Mineral Oil/Linseed Oil)
Oil Based Glazing Compound - High-Quality Grade (Oils)
Oil Based Glazing Compound - High-Quality Elastic Grade (Oils)
Oil Based Glazing Compound - Professional Grade (Soyabean Oil/Linseed Oil)
Water-Based Glazing Compound - High-Quality Exterior Grade (Acrylic)

30. GROUTING COMPOUNDS

Grouting Compound - Dry Type for Ceramic Tiles (Calcium Carbonate/Cement)
Water-Based Grouting Compound - Prepared High Quality Convenience Type for Tiles (Acrylic)

31. JOINT CEMENTS

Joint Cement - Dry Type (Calcium Carbonate/Micas)
Joint Cement - Dry Type (Calcium Carbonate/Mica/Vinyl Acetate)
Joint Cement - Dry Type (Calcium Carbonate/Micas/Vinyl Acetate/Vinyl Alcohol)
Joint Cement - Dry Type (Calcium Carbonate/Mica/Vinyl Acetate/Vinyl Alcohol)
Water Based Joint Cement - Paste Type (Calcium Carbonate/Vinyl Acetate)

32. MASTICS

Oil-Based Mastic - High-Quality Moderate-Cost Type for Ceramic Tiles (Soyabean Oil/Resin)
Oil-Based Mastic - High-Quality Moderate-Cost Type for Ceramic Tiles (Resin)
Rubber-Based Mastic - High-Quality Knife-Sealer Grade (Polybutene)
Solvent-Based Mastic - Trowelable Grade (Resin)
Water-Based Mastic - High-Quality Type for Bonding Insulation to Epoxy-Coated Surfaces (Vinyl Acetate-Acrylate)
Water-Based Mastic - High-Quality Type for Bonding Insulation to Various Substrates (Vinyl Acetate-Acrylate)
Water-Based Mastic - White High-Quality Low-Cost Type for Wall Tiles (Resin/Styrene-Butadiene)
Water-Based Mastic - Natural High-Quality Low-Cost Type for Wall Tiles (Resin/Styrene-Butadiene)
Water-Based Mastic - Natural High-Quality Moderate-Cost Type for Ceramic Tiles
(Resin/Styrene-Butadiene)
Water-Based Mastic - Natural High-Quality
Moderate-Cost Type for Ceramic Tiles
(Styrene-Butadiene)
Water-Based Mastic - White High-Quality
Moderate-Cost Type for Ceramic Tiles
(Resin/Styrene-Butadiene)

33. PUTTIES

Oil-Based Putty - Metal Sash Grade
  (Linseed Oil)
Oil-Based Putty - Plumberâ€™s Grade (Oils)
Oil-Based Putty - Stainless Grade (Linseed Oil/ Soyabean Oil)
Oil-Based Putty - White Commercial Grade
  (Mineral Oil/Linseed Oil)
Oil-Based Putty - White High-Quality Grade
  (Linseed Oils)

34. SEALANTS

Hot Melt Sealant (Phenolic/Butyl/Ethylene-Vinyl Acetate)
Hot Melt Sealant (Butyl/Phenolic/Ethylene-Vinyl Acetate)
Hot Melt Sealant (Resins/Ethylene-Vinyl Acetate/Butyl)
Rubber-Based Sealant Tape Adhesive (Polybutenes)
Sealant - High-Quality Gun Grade (Polymercaptan)

35. SEAM COMPOUNTS

Oil-Based Seam Sealer for Automotive Use
  (Mineral Oil/Gilsonite)
Oil-Based Seam Compound - Marine-Use Grade
  Linseed Oil/Marine Oil)

36. SOLDERS

Cold Solder (Two-Component: Epoxy-Hardener)
Cold Solder (Two-Component: Polyester-Hardener)
Cold Solder (Two-Component: Polyester-
37. PACKLING COMPOUNDS

Spackling Compound - Dry Type
(Calcium Carbonate)
Spackling Compound - Dry Type (Calcium Carbonate/Vinyl Acetate/Vinyl Alcohol)

Section VIII: Trademarked Raw Materials
Section IX: Suppliers’ Addresses

Sample Chapter:
## PRESSURE SENSITIVE ADHESIVES

### HOT MELT PRESSURE SENSITIVE ADHESIVE (POLYBUTENES/RESIN)

<table>
<thead>
<tr>
<th>Sl.</th>
<th>Raw Materials</th>
<th>Percent by Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Vistanex MML-100 Isobutene Polymer</td>
<td>35.0</td>
</tr>
<tr>
<td>2.</td>
<td>Polybutene 128 Isobutene Polymer</td>
<td>18.0</td>
</tr>
<tr>
<td>3.</td>
<td>Abitol Resin</td>
<td>21.0</td>
</tr>
<tr>
<td>4.</td>
<td>Mineral Oil</td>
<td>26.0</td>
</tr>
<tr>
<td></td>
<td></td>
<td>100.0</td>
</tr>
</tbody>
</table>

### HOT MELT PRESSURE SENSITIVE ADHESIVE (POLBUTENES/RESIN)

<table>
<thead>
<tr>
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<th>Raw Materials</th>
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<tbody>
<tr>
<td>1.</td>
<td>Vistanex MML-100 Isobutene Polymer</td>
<td>35.0</td>
</tr>
<tr>
<td>2.</td>
<td>Polybutene 128 Isobutene Polymer</td>
<td>22.0</td>
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<tr>
<td>3.</td>
<td>Staybelite Ester 3 Resin</td>
<td>17.0</td>
</tr>
<tr>
<td>4.</td>
<td>Mineral Oil</td>
<td>26.0</td>
</tr>
<tr>
<td></td>
<td></td>
<td>100.0</td>
</tr>
</tbody>
</table>

### HOT MELT PRESSURE SENSITIVE ADHESIVE (POLUBUTENES/RESINS)

<table>
<thead>
<tr>
<th>Sl.</th>
<th>Raw Materials</th>
<th>Percent by Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Vistanex MML-100 Isobutene Polymer</td>
<td>2.</td>
</tr>
<tr>
<td>2.</td>
<td>Polybutene 128 Isobutene Polymer</td>
<td>10.0</td>
</tr>
<tr>
<td>3.</td>
<td>Staybelite Ester 3 Resin</td>
<td>18.0</td>
</tr>
<tr>
<td>4.</td>
<td>Staybelite Ester 10 Resin</td>
<td>9.0</td>
</tr>
<tr>
<td>5.</td>
<td>Mineral Oil</td>
<td>27.0</td>
</tr>
</tbody>
</table>

**Key Properties**
Good peel strength

HOT MELT PRESSURE SENSITIVE ADHESIVE (POLYBUTENES/RESINS/POLYPROPYLENE)

<table>
<thead>
<tr>
<th>Sl.</th>
<th>Raw Materials</th>
<th>Per cent by Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Vistanex MML-100 Isobutene Polymer</td>
<td>27</td>
</tr>
<tr>
<td>2.</td>
<td>Polybutene 128 Isobutene Polymer</td>
<td>14</td>
</tr>
<tr>
<td>3.</td>
<td>Polypropylene (Amorphous)</td>
<td>13</td>
</tr>
<tr>
<td>4.</td>
<td>Hercolyn D Resin</td>
<td>13</td>
</tr>
<tr>
<td>5.</td>
<td>Piccolyte -115 Polyterpene Resin</td>
<td>13</td>
</tr>
<tr>
<td>6.</td>
<td>Mineral Oil</td>
<td>20</td>
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</tbody>
</table>

Key Properties
Excellent peel strength

HOT MELT PRESSURE SENSITIVE ADHESIVE (POLYPROPYLENE/ROSIN)

<table>
<thead>
<tr>
<th>Sl.</th>
<th>Raw Materials</th>
<th>Per cent by Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Polytac R-1000 Amorphous Polypropylene</td>
<td>60.0</td>
</tr>
<tr>
<td>2.</td>
<td>Tall Oil Rosin</td>
<td>40.0</td>
</tr>
</tbody>
</table>

Physical Constants
Brookfield Viscosity @ 340°F: 1,100 cp
Softening Point (Ring and Ball): 300°F (149°C)

Key Properties
Excellent elongation
Relatively low cost
Low odour

HOT MELT PRESSURE SENSITIVE ADHESIVE (POLYPROPYLENE/ROSIN)

<table>
<thead>
<tr>
<th>Sl.</th>
<th>Raw Materials</th>
<th>Parts by wet weight</th>
<th>Percent by wet weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Polytac R-1000 Amorphous Polypropylene</td>
<td>50.0</td>
<td>50.5</td>
</tr>
<tr>
<td>2.</td>
<td>Tall Oil Rosin</td>
<td>34.0</td>
<td>34.3</td>
</tr>
</tbody>
</table>
3. Paraffin Wax (190°C-195°F Melting Point) 154.0 15.2

99.0 100.0

Physical Constants
Brookfield Viscosity @ 340°F: 1,000 cp
Softening Point (Ring and Ball): 290°F (143°C)

Key Properties
Tacky and stringy
Relatively low cost
Low odour

HOT MELT PRESSURE SENSITIVE ADHESIVE (POLYPROPYLENE/ROSIN/POLYBUTENE)

<table>
<thead>
<tr>
<th>Sl.</th>
<th>Raw Materials</th>
<th>Per cent by Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Polytac R-1000 Amorphous Polypropylene</td>
<td>50.0</td>
</tr>
<tr>
<td>2.</td>
<td>Rosin (Hydrogenated)</td>
<td>30.0</td>
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<tr>
<td>3.</td>
<td>dopol H-300 Isobutene Polymer</td>
<td>20.0</td>
</tr>
</tbody>
</table>

Physical Constants
Brookfield Viscosity @ 340°F: 1300 cp

Key Properties
Excellent surface tack
Relatively low cost
Low odour

HOT MELT PRESSURE SENSITIVE ADHESIVE (POLYTERPENE/ETHYLENE-VINYL ACETATE/POLYETHYLENE)

<table>
<thead>
<tr>
<th>Sl.</th>
<th>Raw Materials</th>
<th>Per cent by Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Ethylene/Vinyl Acetate Copolymer Resin (Melt Index of 2-3)</td>
<td>24.88</td>
</tr>
<tr>
<td>2.</td>
<td>Micromcrystalline Wax (180°F Melting Point)</td>
<td>24.88</td>
</tr>
<tr>
<td>3.</td>
<td>Epolene C-15 Polyethylene Resin</td>
<td>12.44</td>
</tr>
<tr>
<td>4.</td>
<td>Wingtack 115 Polyterpene Resin</td>
<td>37.30</td>
</tr>
</tbody>
</table>
5. Wingstay L Antioxidant 0.50

100.00

Softening Point (Ring and Ball): 201°F (94°C)
Brookfield Viscosity @ 300°F: 10,500 cp
Brookfield Viscosity @ 325°F: 7,200 cp
Brookfield Viscosity @ 350°F: 5,100 cp

Key Properties
Suitable for high tempera-Low volatility
True hot melt-Viscosity stable under
Adhesive applications prolonged heat-Good hot tack and wet ability

HOT MELT PRESSURE SENSITIVE ADHESIVE (POLYTERPENE/ISOPRENE-STYRENE/POLYBUTENE/RESIN)

<table>
<thead>
<tr>
<th>Sl.</th>
<th>Raw Materials</th>
<th>Parts by wet weight</th>
<th>Percent by wet weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Solprene 418 Plastomer</td>
<td>100</td>
<td>26.88</td>
</tr>
<tr>
<td>2.</td>
<td>Wingtack 95</td>
<td>150</td>
<td>40.32</td>
</tr>
<tr>
<td></td>
<td>Polyterpene Resin</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3.</td>
<td>Amoco 18-210 Resin</td>
<td>40</td>
<td>10.75</td>
</tr>
<tr>
<td>4.</td>
<td>Indopol H-300 Isobutene Polymer</td>
<td>80</td>
<td>21.51</td>
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<tr>
<td>5.</td>
<td>Irganox 1010 Antioxidant/Stabilizer</td>
<td>2</td>
<td>0.54</td>
</tr>
</tbody>
</table>

372 100.00

Formulation Note
Other elastomers, besides Solprene 418, may give excellent results in similar compounds.

Physical Constants
Quick Stick Adhesion (PSTC-5): 4.1 lb
Peel Adhesion (PSTC-1): 11.4 lb
Shear Adhesion (Amoco): 135.0 sec

Key Properties
Tacky-Improved quick stick
Strengthened and reinforced-adhesion and peel
compound-adhesion
Should find application in self-stick floor tiles, special
tapes and specialty labels-Excellent shear adhesion

HOT MELT PRESSURE SENSITIVE ADHESIVE (POLYTERPENE/ISOPRENE-STYRENE/POLYBUTENE/RESIN)

<table>
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<tr>
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<tbody>
<tr>
<td></td>
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<td></td>
<td></td>
</tr>
</tbody>
</table>
1. Solprene 418 Plastomer     100     26.88
2. Wingtack 95
   Polyterpene Resin      150     40.32
3. Amoco 18-290 Resin   40      10.75
4. Indopol L-14 Isobutene
   Polymer                80      21.51
5. Irganox 1010
   Antioxidant/Stabilizer 2       0.54

372 100.00

Formulation Note
Other elastomers, besides Solprene 418, may give excellent results in similar compounds.

Physical Constants
Rolling Ball Tack (PSTC-6): 1.3 cm

Key Properties
Tacky
Strengthened and reinforced compound
Should find application in self-stick floor tiles, speciality tapes and speciality labels Improved rolling ball tack

HOT MELT PRESSURE SENSITIVE ADHESIVE (POLYTERPENE/ISOPRENE-
STYRENE/POLYBUTENE/RESIN)

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<td>26.88</td>
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<td>2.</td>
<td>Wingtack 95</td>
<td>150</td>
<td>40.32</td>
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<td>3.</td>
<td>Amoco 18-290 Resin</td>
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<td>10.75</td>
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<td>4.</td>
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<td>5.</td>
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<td>2</td>
<td>0.54</td>
</tr>
</tbody>
</table>

372 100.00

Formulation Note
Other elastomers, besides Solprene 418, may give excellent results in similar compounds.

Physical Constants
Quick Stick Adhesion (PSTC-5): 4.3 lb
Peel Adhesion (PSTC-1): 13.7 lb
Shear Adhesion (Amoco Test): 28.9 lb
Key Properties
Tacky
Strengthened and reinforced compound
Should find application in self-stick floor tiles, speciality tapes and speciality labels
Improved quick stick adhesion and peel adhesion
Good Shear Adhesion

HOT MELT PRESSURE SENSITIVE ADHESIVE (POLYTERPENE/ISOPRENE-STYRENE/POLYBUTENE/RESIN)

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<tr>
<th>Sl.</th>
<th>Raw Materials</th>
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<tbody>
<tr>
<td>1.</td>
<td>Solprene 418 Plastomer</td>
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<td>33.11</td>
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<td>2.</td>
<td>Wingtack 95 Polyterpene Resin</td>
<td>150</td>
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<td>Amoco 18-210 Resin</td>
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<td>5.</td>
<td>Irganox 1010 Antioxidant/Stabilizer</td>
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<td>0.66</td>
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302 100.00

Formulation Note
Other elastomers, besides Solprene 418, may give excellent results in similar compounds.

Physical Constants
Quick Stick Adhesion (PSTC-5): 11.6 lb
Peel Adhesion (PSTC-1): 10.7 lb
Shear Adhesion (Amoco Test): 42.8 sec.

Key Properties
Tacky
Strengthened and reinforced compound
Should find application in self-stick floor tiles, speciality tapes and speciality labels
Improved quick stick adhesion and peel adhesion
Good Shear Adhesion

HOT MELT PRESSURE SENSITIVE ADHESIVE (POLYTERPENE/RESIN)

<table>
<thead>
<tr>
<th>Sl.</th>
<th>Raw Materials</th>
<th>Percent by Weight</th>
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<tbody>
<tr>
<td>1.</td>
<td>Wingtack 95 Polyterpene Resin</td>
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<td>2.</td>
<td>Kraton 1107 Thermoplastic Crumb Rubber</td>
<td>28.66</td>
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<tr>
<td>3.</td>
<td>Dow 276-V2 Resin</td>
<td>23.65</td>
</tr>
</tbody>
</table>
Key Properties
Good hot tack and wettability
Excellent shear and peel adhesion
Low volatility
Viscosity stable under prolonged heat

HOT MELT PRESSURE SENSITIVE ADHESIVE (POLYTERPENE/STYRENE-BUTDIENE-STYRENE)
WT1.96

Sl. | Raw Materials | Parts by weight | Percent by weight |
---|---|---|---|
1. | Ingtack 76 Polyterpene Resin | 28 | 54.90 |
2. | Styrene/Butadiene/Styrene Block Copolymer | 12 | 23.53 |
3. | Ufflo 6054 Naphthenic Oil | 10 | 19.61 |
4. | Antioxidant | 1 | |

Physical Constants
Initial Performance:
Rolling Ball tack: 0.2 inch
180 Peel: 48 oz/inch
Dynamic Shear: 35 psi

Aged Performance:
Rolling Ball Tack: 0.2 inch
180 Peel: 51 oz/inch
Dynamic Shear: 39 psi

Key Properties
Excellent adhesive characteristics
Good heat and oxidation stability
Light colour

HOT MELT PRESSURE SENSITIVE ADHESIVE (POLYTERPENE/STYRENE-ISOPRENE-STYRENE/STYRENE-BUTADIENE)

Sl. | Raw Materials | Parts by weight | Percent by weight |
---|---|---|---|
1. | Wingtack 95 Polyterpene Resin | 35.0 | 34.48 |
2. | Pliolite S5-D Styrene-Butadiene Resin | 22.5 | 22.17 |
<table>
<thead>
<tr>
<th>Sl.</th>
<th>Raw Materials</th>
<th>Parts by weight</th>
<th>Percent by weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>M&amp;M 7512 Petrolatum</td>
<td>40</td>
<td>34.78</td>
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<td>2.</td>
<td>Elvax 260 Ethylene/Vinyl Acetate Resin</td>
<td>30</td>
<td>26.09</td>
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<tr>
<td>3.</td>
<td>Wingtack 95 Polyterpene Resin</td>
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<td>26.09</td>
</tr>
<tr>
<td>4.</td>
<td>Wingtack 10 Polyterpene Resin</td>
<td>15</td>
<td>13.04</td>
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</table>

Physical Constants
Brookfield Viscosity (#2/20 RPM) @ 300°F: 2,300 cp
Brookfield Viscosity (#2/20 RPM) @ 325°F: 1,300 cp
Brookfield Viscosity (#2/20 RPM) @ 350°F: 1,000 cp
Softening Point (Ring and Ball): 165°F (74°C)
Lowered molten viscosity with little effect on softening point
Wingtack 10 Polyterpene Resin gives the following properties to the compound:
Increased tack adhesion
Modified shear and peel strength
Helps prevent stringing on hot melt applicators and air bubble formation on roller applicators
Reduced possibility of degradation
Assists in pressure-sensitive properties

**HOT MELT PRESSURE SENSITIVE ADHESIVE (RESIN/RUBBER)**

<table>
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<tr>
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</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Kraton 1107 Thermoplastic Crumb Rubber</td>
<td>100</td>
<td>32.79</td>
</tr>
<tr>
<td>2.</td>
<td>Escorez 5320 Hydrocarbon Resin</td>
<td>140</td>
<td>45.90</td>
</tr>
<tr>
<td>3.</td>
<td>Shellflex 371 Extender Oil</td>
<td>60</td>
<td>19.67</td>
</tr>
<tr>
<td>4.</td>
<td>Butyl Zimate Accelerator</td>
<td>5</td>
<td>1.64</td>
</tr>
<tr>
<td></td>
<td>Total</td>
<td>305</td>
<td>100.00</td>
</tr>
</tbody>
</table>

**Formulation Note**
The Shellflex 371 Extender Oil is added to improved the compatibility and reduce the melt viscosity of the Escorez 5320 Hydrocarbon Resin with the Kraton 1107 Thermoplastic Crumb Rubber. A better compromise between melt viscosity and pressure sensitive adhesive properties might be with less or no Shellflex 371 at all.

**Physical Constants**
Appearance: Transparent
Brookfield Viscosity @ 350°F (Initial): 14,500 cp
Brookfield Viscosity @ 350°F (Aged 72 hours at 300°F): 10,000 cp
Percent Change in Viscosities: -31%
Rolling Ball Tack: 0.3 inch (Low values desirable)
180°F Peel Adhesion: 92 oz/inch (12 inches/minute to steel)
20°F Hold (Â½ inch Â· Â½ inch Contact Area, 400 gram Load): 63 minutes
178°F Vertical Hold (Â½ inch Â· Â½ inch Contact Area, 1,000 gram Load): 1.3 hours

**Key Properties**
Somewhat higher holding power than comparative aliphatic hydrocarbon resin
Good melt stability upon aging

**HOT MELT PRESSURE SENSITIVE ADHESIVE (RESIN/RUBBER)**

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Kraton 1107
Thermoplastic Crumb Rubber

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<td>4</td>
<td>Butyl Zimate Accelerator</td>
<td>5</td>
<td>1.64</td>
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</table>

Physical Constants
Brookfield Viscosity @ 350°F: 42,500 cp
Properties of 1.5 mil Adhesive Film on 1.5 mil Polyester film:
Rolling Ball Tack: 2.0 inched (Low values desirable)
Peel Adhesion: 88 ounces/inch (12 inches/minute to steel)
Hold (1/2 inch x 1/2 inch Contact Area, 400 gram Load): 740 minutes
178°F Verticle Hold (1/2 inch x 1/2 inch Contact Area, 1,000 gram Load): 30 hours

Key Properties
Excellent compatibility
Very good holding power
Adequate tack rating

HOT MELT PRESSURE SENSITIVE ADHESIVE (RESIN/RUBBER)

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<td>4</td>
<td>Butyl Zimate Accelerator</td>
<td>5</td>
<td>1.64</td>
</tr>
</tbody>
</table>

Physical Constants
Brookfield Viscosity @ 350°F: 14,500 cp
Properties of 1.5 mil Adhesive Film on 1.5 mil Polyester film:
Rolling Ball Tack: 0.3 inched (Low values desirable)
180°F Peel Adhesion: 92 ounces/inch (12 inches/minute to steel)
Hold (1/2 inch x 1/2 inch Contact Area, 400 gram Load): 63 minutes
178°F Verticle Hold (1/2 inch x 1/2 inch Contact Area, 1,000 gram Load): 1.3 hours

Key Properties
Soft, relatively low viscosity compound with excellent tack properties
High concentration of oil as a diluent lowers strength or holding power

HOT MELT PRESSURE SENSITIVE ADHESIVE RUBBER/POLYTERPENE /POLYBUTENE/RESIN)

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<tbody>
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<td>Kraton 1107</td>
<td>100.0</td>
<td>33.22</td>
</tr>
<tr>
<td></td>
<td>Thermoplastic Crumb Rubber</td>
<td></td>
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<tr>
<td>2.</td>
<td>Wingtack 95</td>
<td>100.0</td>
<td>33.22</td>
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<tr>
<td></td>
<td>Polyterpene Resin</td>
<td></td>
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<tr>
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<td>Polyterpene Resin 40.0</td>
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<tr>
<td></td>
<td>Indopol L-14 Isobutene Polymer</td>
<td>60.0</td>
<td>19.94</td>
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<tr>
<td>5.</td>
<td>Irganox 1010</td>
<td>1.0</td>
<td>0.33</td>
</tr>
<tr>
<td></td>
<td>Antioxidant/Stabilizer</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Formulation Note
Other elastomers, besides Kraton 1107, may give excellent results in similar compounds.

Physical Constants
Rolling Ball Tack (PSTC-6): 2.3 cm
Quick Stick Adhesion (PSTC-5): 2.0 lb
Peel Adhesion (PSTC-1): 2.5 lb
Shear Adhesion (Amoco Test): 1.6 sec

Key Properties
Tacky
Strengthened and reinforced compound
Should find application in self-stick floor tiles, specialty tapes and labels and where solvent-free coating provide economic or environmental advantages
Improved rolling ball tack, quick stick adhesion and peel adhesion

HOT MELT PRESSURE SENSITIVE ADHESIVE RUBBER/POLYTERPENE/ POLYBUTENE/RESIN)

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<td></td>
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<tr>
<td>3.</td>
<td>Amoco 18-290 Resin</td>
<td>20.0</td>
<td>7.66</td>
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4. Indopol H-1500
   Isobutene Polymer  40.0  15.34

5. Irganox 1010
   Antioxidant/Stabilizer  1.0  0.38

   261.0  100.00

Formulation Note
Other elastomers, besides Kraton 1107, may give excellent results in similar compounds.

Physical Constants
Quick Stick Adhesion (PSTC-5): 5.3 lb
Peel Adhesion (PSTC-1): 10.7 lb
Shear Adhesion (Amoco Test): 37.6 sec

Key Properties
Tacky
Strengthened and reinforced compound
Should find application in self-stick floor tiles, specialty tapes and labels and where solvent-free coatings
provide economic or environmental advantages
Improved quick stick adhesion and peel adhesion
Good shear adhesion

HOT MELT PRESSURE SENSITIVE ADHESIVE RUBBER/POLYTERPENE/
POLYBUTENE/RESIN)

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<td>19.94</td>
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<td>5.</td>
<td>Irganox 1010 Antioxidant/Stabilizer</td>
<td>1.0</td>
<td>0.33</td>
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</table>

   301.0  100.00

Formulation Note
Other elastomers, besides Kraton 1107, may give excellent results in similar compounds.

Physical Constants
Rolling Ball Tack (PSTC-6): 2.3 cm
Quick Stick Adhesion (PSTC-5): 2.0 lb  
Peel Adhesion (PSTC-1): 2.5 lb  
Shear Adhesion (Amoco Test): 1.6 sec  

Key Properties  
Tacky  
Strengthened and reinforced compound  
Should find application in self-stick floor tiles, speciality tapes and labels and where solvent-free coatings provide economic or environmental advantages  
Improved rolling ball tack, quick sick adhesion and peel adhesion  

HOT MELT PRESSURE SENSITIVE ADHESIVE RUBBER/POLYTERPENE/RESIN /POLYBUTENE)  

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<td>3.</td>
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<td>4.</td>
<td>Indopol H-1500</td>
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<td>Isobutene Polymer</td>
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<td>Antioxidant/Stabilizer</td>
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<td></td>
<td>281.0</td>
<td>100.00</td>
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Formulation Note  
Other elastomers, besides Kraton 1107, may give excellent results in similar compounds.

Physical Constants  
Quick Stick Adhesion (PSTC-5): 4.5 lb  
Peel Adhesion (PSTC-1): 12.0 lb  
Shear Adhesion (Amoco Test): 32.3 sec  

Key Properties  
Tacky  
Strengthened and reinforced compound  
Should find application in self-stick floor tiles, speciality tapes and labels and where solvent-free coatings provide economic or environmental advantages  
Improved quick stick adhesion and peel adhesion  
Good shear adhesion  

HOT MELT PRESSURE SENSITIVE ADHESIVE RUBBER/POLYTERPENE/RESIN /POLYBUTENE)  
[tdIrganox 1010 Antioxidant/Stabilizer
Formulation Note
Other elastomers, besides Kraton 1107, may give excellent results in similar compounds.

Physical Constants
Quick Stick Adhesion (PSTC-5): 1.8 lb
Peel Adhesion (PSTC-1): 5.8 lb
Shear Adhesion (Amoco Test): 263.0 sec

Key Properties
Tacky
Strengthened and reinforced compound
Should find application in self-stick floor tiles, speciality tapes and labels and where solvent-free coatings provide economic or environmental advantages
Improved quick stick adhesion and peel adhesion
Excellent shear adhesion

HOT MELT PRESSURE SENSITIVE ADHESIVE RUBBER/POLYTERPENE/RESIN
(POLYBUTENE)

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<th>Percent by weight</th>
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<tr>
<td>3.</td>
<td>Amoco 18-290 Resin</td>
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<td>15.94</td>
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<td>4.</td>
<td>Indopol H-100 Isobutene Polymer</td>
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<td>3.98</td>
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<td>5.</td>
<td>Ethyl Antioxidant 330</td>
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<tr>
<td></td>
<td>275.0</td>
<td>100.00</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Sl.</th>
<th>Raw Materials</th>
<th>Parts by weight</th>
<th>Percent by weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Kraton 1107</td>
<td>100.0</td>
<td>36.36</td>
</tr>
<tr>
<td></td>
<td>Thermoplastic Crumb Rubber</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2.</td>
<td>Wingtack 95 Polyterpene Resin</td>
<td>100.0</td>
<td>36.36</td>
</tr>
<tr>
<td>3.</td>
<td>Amoco 18-210 Resin</td>
<td>50.0</td>
<td>18.19</td>
</tr>
<tr>
<td>4.</td>
<td>Indopol H-1500 Isobutene Polymer</td>
<td>20.0</td>
<td>7.27</td>
</tr>
<tr>
<td>5.</td>
<td>Ethyl Antioxidant 330</td>
<td>5.0</td>
<td>1.82</td>
</tr>
<tr>
<td></td>
<td>275.0</td>
<td>100.00</td>
<td></td>
</tr>
</tbody>
</table>
Formulation Note
Other elastomers, besides Kraton 1107, may give excellent results in similar compounds.

Physical Constants
Rolling Ball Tack (PSTC-6): 19.3 cm
Peel Adhesion (PSTC-1): 2.4 lb
Shear Adhesion (Amoco Test): 3,309 sec

Key Properties
Tacky
Strengthened and reinforced compound
Should find application in self-stick floor tiles, speciality tapes and labels and where solvent-free coatings provide economic or environmental advantages
Improved rolling ball tack, quick stick adhesion and peel adhesion
Excellent shear adhesion

HOT MELT PRESSURE ADHESIVE (RUBBER/RESIN)

<table>
<thead>
<tr>
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<th>Parts by weight</th>
<th>Percent by weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Zonarez 7115 Polyterpene Resin</td>
<td>40.0</td>
<td>39.8</td>
</tr>
<tr>
<td>2.</td>
<td>Styrene/Isoprene Block Copolymer</td>
<td>60.0</td>
<td>59.7</td>
</tr>
<tr>
<td>3.</td>
<td>Antioxidant</td>
<td>0.5</td>
<td>0.5</td>
</tr>
<tr>
<td></td>
<td></td>
<td>100.5</td>
<td>100.00</td>
</tr>
</tbody>
</table>

Formulation Note
Recommended application temperature is 350°F to 390°F (177°C to 199°C)

Key Properties
Improved tack and adhesion of pressure-sensitive
Improved flexibility at high and low temperatures
Excellent stability
High quality

HOT MELT PRESSURE SENSITIVE ADHESIVE (RUBBER/RESINS)

<table>
<thead>
<tr>
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<th>Raw Materials</th>
<th>Parts by weight</th>
<th>Percent by weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Kraton 1107 Thermoplastic Crumb Rubber</td>
<td>100</td>
<td>32.79</td>
</tr>
<tr>
<td>2.</td>
<td>Escorez 5280 Hydrocarbon Resin</td>
<td>100</td>
<td>32.79</td>
</tr>
<tr>
<td>3.</td>
<td>Cumar LX-509 Resin</td>
<td>40</td>
<td>13.11</td>
</tr>
</tbody>
</table>
Formulation Note
The Shellflex 371 Extender Oil is added to improve the compatibility and reduce the melt viscosity of the Escorez 5280 Hydrocarbon Resin with the Kraton 1107 Thermoplastic Crumb Rubber. A better compromise between melt viscosity and pressure sensitive adhesive properties might be with less or no Shellflex 371 at all.

Physical Constants
Appearance: Opaque
Brookfield Viscosity @ 350°F (Initial): 11,200 cp
Brookfield Viscosity @ 350°F (Aged 72 hours @ 300°F): 7,500 cp
Percent Change in Viscosities: -33%
Rolling Ball Tack: 0.1 inch (Low values desirable)
180°F Peel Adhesion: 76 ounces/inch (12 inches/minute to steel)
20°F Hold (Å½ inch Å­- Å½ inch Contact Area, 400 gram Load): 52 minutes
178°F Vertical Hold (Å½ inch Å­- Å½ inch Contact Area, 1,000 gram Load): 1.3 hours

Key Properties
Somewhat higher holding power than comparative aliphatic hydrocarbon resin
Good melt stability upon aging

HOT MELT LOW-COST PRESSURE SENSITIVE ADHESIVE POLYPROPYLENE/RESIN/POLYBUTENE)

<table>
<thead>
<tr>
<th>Sl.</th>
<th>Raw Materials</th>
<th>Percent by Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Polytac R-1000 Amorphous Polypropylene</td>
<td>70.0</td>
</tr>
<tr>
<td>2.</td>
<td>Escorez 1315 Hydrocarbon Resin</td>
<td>20.0</td>
</tr>
<tr>
<td>3.</td>
<td>Indopol H-300 Isobutene Polymer</td>
<td>10.0</td>
</tr>
</tbody>
</table>

Physical Constants
Brookfield Viscosity @ 340°F: 3,000 cp
Softening Point (Ring and Ball): 295°F

Key Properties
Relatively low cost
Low odour

HOT MELT LOW-COST PRESSURE SENSITIVE ADHESIVE POLYPROPYLENE/RESIN)
Key Properties
Superior bonding strength
No delamination after 24 hours at 140°F
Relatively low cost
Low odour

HOT MELT SPRAYABLE PRESSURE SENSITIVE ADHESIVE POLYTERPENE/STYRENE-ISOPRENE-STYRENE/STYRENE-BUTADIENE

<table>
<thead>
<tr>
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<th>Percent by weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Wingtack 95 Polyterpene Resin</td>
<td>40.0</td>
<td>39.41</td>
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<tr>
<td>2.</td>
<td>Pliolite S5-D Styrene-Butadiene Resin</td>
<td>12.5</td>
<td>12.32</td>
</tr>
<tr>
<td>3.</td>
<td>Process Oil</td>
<td>20.0</td>
<td>19.70</td>
</tr>
<tr>
<td>4.</td>
<td>Styrene/Isoprene/Styrene Block Copolymer</td>
<td>27.5</td>
<td>27.09</td>
</tr>
<tr>
<td>5.</td>
<td>Butyl Zimate Accelerator</td>
<td>1.5</td>
<td>1.48</td>
</tr>
</tbody>
</table>

Formulation Notes

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