



Formula 640

DESCRIPTION

Formula 640 is formulated to provide low viscosity for bonding UV coated paper and cartons.

NON-TOXIC

The components in Formula 640 have been analyzed by a qualified toxicologist and this product is certified to be non-toxic. Additionally, Formula 640 meets FDA CFR 175.105 adhesive requirements for indirect contact with food.

TYPICAL USES

Bonding UV coated paper.

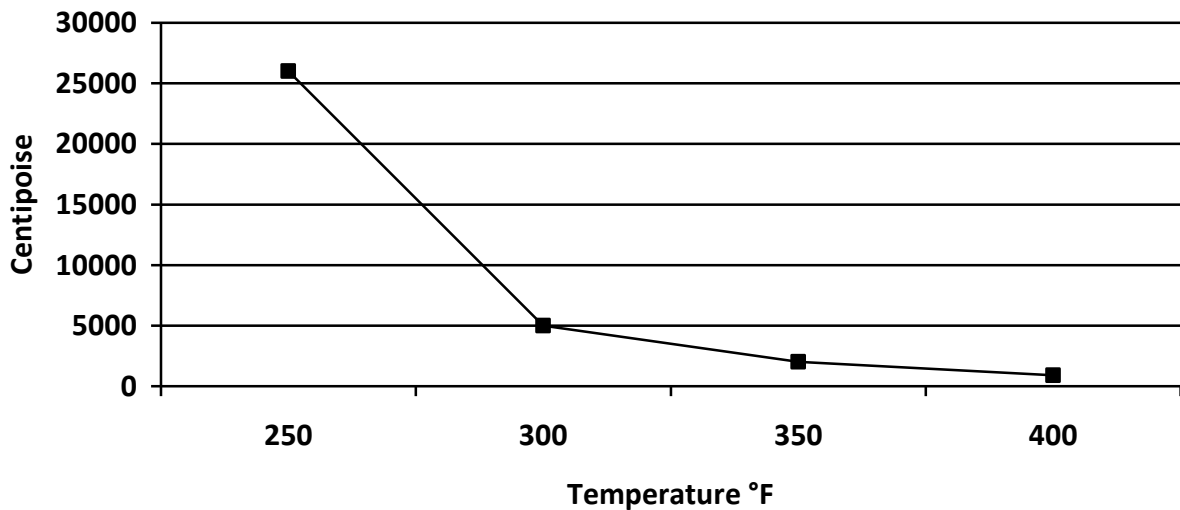
PRODUCT SPECIFICATIONS

Softening point	194°F (90°C)
Viscosity @ 350°F (176°C), centipoise	2,000
Specific gravity	0.98
Shear tensile strength on pine, psi	450
Adhesive tensile on pine, psi	359
Adhesive tensile on steel, psi	372
Hardness @ 72°F (25°C)	97
Heat resistance	130°F (54°C)
Compression set time (seconds)	3 - 5 sec
Open Time (seconds)	50 sec

Test Method

ASTM E28-67
Brookfield Thermosel
ASTM 1475
ASTM D-1002
ASTM D-1344-78
ASTM D-1344-78
Shore "A"
AdTech
AdTech
AdTech

VISCOSITY PROFILE



APPLICATION

For optimum performance, Formula 640 should be applied in one of AdTech's reliable hand held hot melt applicators.

IMPORTANT NOTICE: All statements, technical information and recommendations contained herein are based on tests we believe to be reliable but the accuracy of completeness thereof is not guaranteed, and the user should determine the suitability of the product for the intended use. AdTech disclaims any responsibility for any warranties of merchantability and fitness for purpose, verbal recommendations of its representatives and consequential damages.