

Enerdyne UV-4511

Adhesive for DieLESS Foil – API

Developed using a proprietary resin technology that does not require the use of acrylate monomer diluents. The result is extremely low extraction potential with lower press side odor, improved worker safety and reduced potential for skin irritation. Formulated as an Energy Curable adhesive for the DieLESS foil process, it is recommended for paper and paperboard substrates and clear film labels.

Typical Properties

Viscosity as supplied:	1600 – 1800 cps @ 25°C
Application viscosity:	As received
Weight per gallon:	9.2 lbs./gal.
Wet color:	Light straw
Color after curing:	Clear, high gloss
Shelf life:	12 months from manufacture date

Suggested Application/Cure Data

Intended for DieLESS foil process:	Must be used in combination with a DieLESS foil. DieLESS Foil should be applied to the Enerdyne UV-4511 printed adhesive and cured through the foil then the carrier film rewound. Additional UV curing will maximize final adhesion.
Application method:	Flexographic, offset gravure, reverse gravure, and dampener coater.
Recommended coating weight:	2.0 – 3.0 lbs. per 3000 square feet
Cure conditions:	50 ft/min/300 watts per inch lamp (~149 millijoules/square centimeter)
Cleanup:	Use cleaning methods and materials normally used with UV products.

Typical Performance Properties

Adhesion:	Excellent when tested with 610 tape
Scuff resistance (100 Sutherland rubs 4# weight)	No foil scuff or transfer when properly cured and overprinted with an approved topcoat.

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