



ADHESIVES & COATINGS, INC
QURETECH®
TECHNICAL DATA SHEET

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Providing Advanced Water-based and Energy
Curable Coatings and Adhesives
For Over 25 Years
Clean, Safe, Worker Friendly

FlexTac 7441

Lay-Flat Lithographic Laminating Adhesive

FlexTac 7441 is a high solids, high performance vegetable based adhesive developed for lithographic label laminating applications. This adhesive is formulated with enhanced wet tack properties to overcome “floating” of the litho-label sometimes encountered with other adhesives. Inherent rheological characteristics provide excellent processing on the adhesive coater along with ease of cleanup, cost reduction and superior product versatility.

FDA Status	Complies with 21CFR175.105
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Applications	Lithographic Label Laminating
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Typical Properties

Total Solids (1)	63.0 ± 1.0 %
Viscosity ₁ (2)	850 ± 50 cps
pH	6.5 ± 0.5
Weight per Gallon @ 25°C	11.4 ± 0.2 lbs.
Storage Life	3 months at room temperature
Application Method	Roll coaters eg. Pot Devin, Automatän, FMC

Viscosity variations are available for different roller configurations and seasonal weather changes.

(1) Forced air oven 16 hours at 65° C

(2) Brookfield RVT, Spindle #3 @ 20 RPM at 25°C



FlexTac 7448

Glue Lap Adhesive

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FlexTac 7448 is a high performance vinyl acetate copolymer based emulsion adhesive developed primarily for use as a glue lap adhesive on folding cartons. FlexTac 7448 is fast setting and exhibits superior adhesion and water resistance on the clay coated and polycoated chipboards typically used for high quality graphic cartons. FlexTac 7448 is a higher viscosity version of FlexTac 7449 for use in bottom pots of wheel applicators.

FDA Status

Complies with 21CFR175.105

Applications

Glued lap adhesive

Typical Properties

Total Solids (1)	53.0 ± 1.0 %
Viscosity ₁ (2)	2250 ± 250 cps
pH	8.0 ± 0.5
Weight per Gallon @ 25°C	9.0 ± 0.1 lbs.
Storage Life	3 months at room temperature

Application Method

Wheel

Viscosity variations are available for custom built or machine manufacturer specific requirements. Tinted color variations as well as U.V tracer containing formulations are also available.

(1) Forced air oven 2 hours at 105° C

(2) Brookfield RVT, Spindle #4 @ 20 RPM at 25°C



FlexTac 7449

Glue Lap Adhesive

FlexTac 7449 is a high performance vinyl acetate copolymer based emulsion adhesive developed primarily for use as a glue lap adhesive on folding cartons. FlexTac 7449 is fast setting and exhibits superior adhesion and water resistance on the clay coated and polycoated chipboards typically used for high quality graphic cartons. The formulation is particularly well suited for high-pressure extrusion systems such as Valco, Mactron, and HHS. The product machines cleanly and will not build-up or clog the assorted orifice diameters typically used on these systems. FlexTac 7449 is a higher performing version of FlexTac 7476 and will exhibit improved adhesion to more difficult substrates.

FDA StatusComplies with 21CFR175.105

ApplicationsGlue lap adhesive for the packaging industry

Typical Properties

Total Solids (1)	52.0 ± 1.0 %
Viscosity ₁ (2)	400 ± 50 cps
pH	8.0 ± 0.5
Weight per Gallon @ 25°C	9.0 ± 0.1 lbs.
Storage Life	3 months at room temperature
Application Method	High pressure extrusion systems

Viscosity variations are available to accommodate different orifice sizes and system pressure/requirements. Tinted color variations as well as U.V tracer containing formulations are also available.

(1) Forced air oven 2 hours at 105° C

(2) Brookfield RVT, Spindle #2 @ 20 RPM at 25°C

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FlexTac 7450

Single Face Laminating Adhesive

FlexTac 7450 is a high performance vinyl acetate polymer based emulsion adhesive developed primarily for bonding a wide variety of lithographic labels to single face corrugated. Fast setting and clean machining, FlexTac 7450 has excellent lay-flat properties and provides fiber-tearing bonds out of the compression section of Asitrade single facers. Modified versions of the adhesive are available that perform well in foamed applications.

FDA Status

Complies with 21CFR175.105

Applications

Single Face Lithographic Label laminating

Typical Properties

Total Solids (1)
Viscosity₁ (2)
pH
Weight per Gallon @ 25°C

57.0 ± 1.0 %
1050 ± 50 cps
5.0 ± 0.5
9.1 ± 0.1 lbs.

Storage Life

3 months at room temperature

Application Method

Reverse roll coaters typically found on Asitrade and Black Brothers laminators

Viscosity variations are available to accommodate reverse roll coaters and slot die coating heads used in conjunction with Anilox rollers

(1) Forced air oven 2 hours at 105° C

(2) Brookfield RVT, Spindle #3 @ 20 RPM at 25°C

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FlexTac 7465

Remoistenable Envelope Front Gum

FlexTac 7465 is a high solids, high performance product developed as a remoistenable adhesive for use on envelope front gum applications. This adhesive is formulated to be fast setting, non-blocking and has inherent rheological characteristics designed to provide excellent processing on the adhesive coater. FlexTac 7465 exhibits excellent adhesive properties and will not discolor tinted papers. FlexTac 7465 is a higher solids version of FlexTac 272 and also provides improved adhesion to difficult envelope stock.

Additionally, two versions of FlexTac 7465 are available that compensate for climate changes – winter and summer versions. The winter version – which will normally run well fall, winter, and spring – has slightly longer open time to compensate for lower humidity conditions. The summer version has less open time to compensate for higher humidity levels typically encountered during the summer months.

FDA Status

Complies with 21CFR175.105

Applications

Front Gum Adhesive for Envelopes

Typical Properties

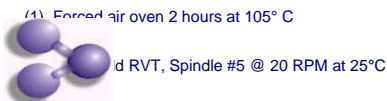
Total Solids (1)	71.5 ± 1.0 %
Viscosity ₁ (2)	3250 ± 250 cps
pH	3.0 ± 0.5
Weight per Gallon @ 25°C	10.5 ± 0.2 lbs.
Storage Life	3 months at room temperature
Application Method	Roll coater

Viscosity variations are available for different roller configurations and seasonal weather changes.

FlexTac 7465 was direct coated onto 24# bond paper at 1 wet mil. The adhesive was then allowed to air dry for 24 hours. After drying, the adhesive was then remoistened and laminated to 24# bond paper. The bond was immediately rated as follows:

Immediate Bond:	Deep fiber tear
Layflat of Dried Adhesive Film:	Excellent

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FlexTac 7467

Tube Winding Adhesive

FlexTac 7467 is a high performance vinyl acetate based emulsion adhesive developed primarily for tube winding applications. FlexTac 7467 has very aggressive wet tack properties and excellent adhesion to standard kraft and weakly bleached chip stocks as well as lightly coated overwraps. FlexTac 7467 also finds utility as a low cost adhesive for build-up pads and other corrugated conversion applications.

FDA Status

Complies with 21CFR175.105

Applications

Primarily tube winding, corrugated build-up pads

Typical Properties

Total Solids (1)	31.0 ± 1.0 %
Viscosity ₁ (2)	2000 ± 200 cps
pH	4.4 ± 0.4
Weight per Gallon @ 25°C	8.8 ± 0.1 lbs.
Storage Life	3 months at room temperature
Application Method	Knife, roll coater, some spray applications.

Viscosity variations are available for custom built or machine manufacturer specific requirements along with custom tinted colors.

(1) Forced air oven 2 hours at 105° C

(2) Brookfield RVT, Spindle #3 @ 20 RPM at 25°C

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FlexTac 7472

Lay-Flat Lithographic Laminating Adhesive

FlexTac 7472 is a high solids, high performance vegetable based adhesive developed for lithographic label laminating applications. Inherent rheological characteristics provide excellent processing on the adhesive coater along with ease of clean up during machine downtime. Unique formulation features reduce and eliminate the “cob webbing” effect sometimes seen in other adhesives in drier climates or during the coldest winter months.

FDA Status	Complies with 21CFR175.105
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Applications	Lithographic Label Laminating
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Typical Properties

Total Solids (1)	56.0 ± 1.5 %
Viscosity ₁ (2)	1000 ± 100 cps
pH	5.5 ± 0.5
Weight per Gallon @ 25°C	11.2 ± 0.2 lbs.
Storage Life	3 months at room temperature
Application Method	Roll coaters eg. Pot Devin, Automatän, FMC

Viscosity variations are available for different roller configurations and seasonal weather changes.

(1) Forced air oven 16 hours at 65° C

(2) Brookfield RVT, Spindle #3 @ 20 RPM at 25°C

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FlexTac 7475

Lithographic Label Laminating Adhesive

FlexTac 7475 is a high performance vinyl acetate polymer based emulsion adhesive developed primarily for bonding a wide variety of lithographic labels to chipboard and double-faced corrugated board. Fast setting and clean machining, FlexTac 7475 has excellent lay-flat properties and provides fiber-tearing bonds out of the nip roller section of the laminator. FlexTac 7475 is the product of choice where high performance at an economical price is desired. Modified versions of the adhesive are available that perform well in foamed applications.

FDA Status	Complies with 21CFR175.105
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Applications	Lithographic Label laminating
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Typical Properties

Total Solids (1)	38.5 ± 1.5 %
Viscosity ₁ (2)	2000 ± 100 cps
pH	5.5 ± 0.5
Weight per Gallon @ 25°C	9.0 ± 0.1 lbs.
Storage Life	3 months at room temperature
Application Method	Commercial laminators such as Pot Devin and Automatän

Viscosity variations are available to accommodate modified roller configurations or custom built laminators.

(1) Forced air oven 16 hours at 65° C

(2) Brookfield RVT, Spindle #3 @ 20 RPM at 25°C

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FlexTac 7476

Glue Lap Adhesive

FlexTac 7476 is a high performance vinyl acetate copolymer based emulsion adhesive developed primarily for use as a glue lap adhesive on folding cartons. FlexTac 7476 is fast setting and exhibits good adhesion and water resistance on the clay coated and polycoated chipboards typically used for high quality graphic cartons. The formulation is particularly well suited for high-pressure extrusion systems such as Valco, Mactron, and HHS. The product machines cleanly and will not build-up or clog the assorted orifice diameters typically used on these systems. FlexTac 7476 is a more economical version of FlexTac 7449 and will provide fiber-tearing bonds on the majority of carton stocks in commercial use in the packaging market.

FDA StatusComplies with 21CFR175.105

ApplicationsGlue lap adhesive for the packaging industry

Typical Properties

Total Solids (1)	52.0 ± 1.0 %
Viscosity ₁ (2)	400 ± 50 cps
pH	8.0 ± 0.5
Weight per Gallon @ 25°C	9.0 ± 0.1 lbs.
Storage Life	3 months at room temperature
Application Method	High pressure extrusion systems

Viscosity variations are available to accommodate different orifice sizes and system pressure/requirements. Tinted color variations as well as U.V tracer containing formulations are also available.

(1) Forced air oven 2 hours at 105° C

(2) Brookfield RVT, Spindle #2 @ 20 RPM at 25°C

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FlexTac 7486

Honeycomb Adhesive

FlexTac 7486 is a high performance vinyl acetate based emulsion adhesive developed primarily for manufacturing Kraft-based honeycomb. FlexTac 7486 has very aggressive wet tack properties and excellent adhesion to standard kraft and weakly bleached chip stocks as well as lightly coated overwraps. FlexTac 7486 also finds utility as a low cost adhesive for build-up pads and other corrugated conversion applications such as tube winding.

FDA Status

Complies with 21CFR175.105

Applications

Honeycombs, tube winding

Typical Properties

Total Solids (1)

24.0 ± 1.0 %

Viscosity₁ (2)

1850 ± 150 cps

pH

4.8 ± 0.1

Weight per Gallon @ 25°C

8.8 ± 0.1 lbs.

Storage Life

3 months at room temperature

Application Method

Knife, roll coater, some spray and extrusion applications.

Viscosity variations are available for custom built or machine manufacturer specific requirements along with custom tinted colors.

(1) Forced air oven 2 hours at 105° C

(2) Brookfield RVT, Spindle #4 @ 20 RPM at 25°C