



Vitel® 3350B

COPOLYESTER LAMINATING RESIN

KEY FEATURES

- High flexibility and clarity
- Strong adhesion to PET, metals, vinyls and treated olefins (PP or PE)
- Excellent stability in solution

DESCRIPTION

Vitel® 3350B is an amorphous, linear, saturated copolyester resin designed to have high flexibility and good solubility in common solvents (e.g. Ethyl acetate, MEK, Toluene). Its excellent clarity and tackiness at ambient temperatures make it well suited for laminating clear, flexible films. Vitel® 3350B can be formulated with other soluble grade Vitel® resins to impart better flexibility and improve adhesion of the system. Additionally, this resin can be used in conjunction with a curing agent, such as Boscodur® 21, when extreme moisture resistance and strength are required.

PACKAGING

Vitel® 3350B is sold in slab form (packed in poly bag) since the resin will cold flow at ambient temperatures.

SHELF LIFE

The shelf life of Vitel® 3350B is approximately 9 months when stored in original, sealed bags at temperatures between 5 and 35 °C.

STORAGE & HANDLING

Elevated warehouse temperatures may cause more cold flow in the resin and difficulties in the removal of the wrapping film. Static charges may also develop due to the unwrapping of this film. Precautions against a static discharge should be taken particularly in areas where solvent vapors exist. Otherwise, there are no special precautions necessary in handling this resin. Under typical ambient conditions, Vitel® 3350B is an inert material.



TYPICAL PHYSICAL PROPERTIES

Description	Results
Appearance	Amber slabs
Specific Gravity	1.22
CIE Lab Color	L* : 95 (min.) b* : 10 (max.)

TYPICAL POLYMER PROPERTIES

Description	Results
Softening Point (Ball & Ring)	125 °C
Molecular Weight (Mw)	70,000 Da
Acid Number	1-3 mgKOH/g
Hydroxyl Number	3-6 mgKOH/g
Intrinsic Viscosity	0.80 dl/g
Glass Transition Temperature	16 °C

APPLICATION TECHNIQUES

Vitel® 3350B is most frequently applied from solution, therefore, 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, the system can be used on all dry laminating machines, with smooth or rotogravure rollers. The adhesive system should be processed at a solids content of approximately 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 coating weight of approximately 3 g/m². For aggressive requirements, the coating weight needs to be increased to 4 g/m² or higher.

DILUTION

Dilution can be done with PU grades (< 0.1% H₂O content) of ethyl acetate, acetone, MEK, or a mixture of these solvents.

SOLUTION POT LIFE

Vitel® 3350B in solution has excellent 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 a curative, pot life will vary, but it is not recommended to hold the reactive solution 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.

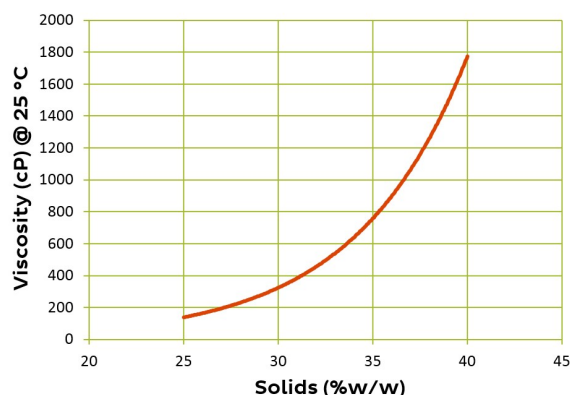
ACTIVATION TEMPERATURE

The minimum activation temperature for this product is 194 °F (90 °C) but 257 °F (125 °C) is recommended.

FOOD LEGISLATION

Vitel® 3350B 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.

VISCOSITY CURVE - Methyl Ethyl Ketone



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

The Limited Warranty for this product can be found at www.bostik-us.com/resource-center/warranties or by calling 1-800-726-7845 (choose option 2, then option 2 again). 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. 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.

BOSTIK HOTLINE

Smart help
1-800-726-7845

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