High Tack
Pressure Sensitive Adhesive (PSA)

PRODUCT DESCRIPTION
The Tru-Bond™ PSA 750 High Tack Pressure Sensitive Adhesive (PSA) is a one-part, solventless liquid that cures to a tacky adhesive when exposed to UV/Visible light. This PSA can be cured directly through clear or translucent surfaces or cured first prior to assembly. The curing first method allows for the joining of parts at some future point. This product can bond a wide range of substrates including PE, PP, PET, TPU and most plastics, metals, glass, and ceramics. It can be sprayed, roll coated, bead or brush applied, screen printed or used in a flexographic printing process. Can be used in cold temperature attachment <10°F (-12°C).

PRODUCT CHARACTERISTICS
- **Chemical Class**: Acrylic
- **Appearance (uncured)**: Clear liquid
- **Components**: Single requires no mixing
- **Viscosity**: Low

TYPICAL PROPERTIES OF CURED MATERIALS
- **Color**: Optically Clear
- **Water absorption, ASTM D570 (24 hrs.)**: 1.93
- **Boiling Water, ASTM D570 (2 hrs.), %**: 1.40
- **Shore hardness**: <000 61
- **Temperature Range \( ^\circ F(\mathbf{C}) \)**: -40-200 (-40-93)

TYPICAL PROPERTIES OF UNCURED MATERIAL
- **Specific gravity \( @25^\circ C \)**: 1.0
- **Viscosity \( @25^\circ C, \text{ Brookfield RV} \)**: 750
- **Flashpoint, \( ^\circ F(\mathbf{C}) \)**: >212(100)
- **Non-Volatile Materials, %**: >99
- **VOC, %**: <1
- **Shelf life, months**: 24
- **Solubility**: ketones, oxygenated solvents

RoHS and REACH Compliant

Process Latitude of Tru-Bond UV PSA 750

### 180 Degree Peel
PET film 300mm*25mm*0.075mm; SS304 100mm*25mm*1mm apply the adhesive on the PET film first, cure, assemble the PET film on the 304 SS, and then roll with weight (2 Kg). Dwell 7 days.

<table>
<thead>
<tr>
<th>PSA 750 High Tack</th>
<th>Dose with Fusion D bulb at 100 mW/cm²</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Nominal Film Thickness</strong></td>
<td><strong>500 ml/cm²</strong></td>
</tr>
<tr>
<td>lbs/ inch N/25mm</td>
<td>lbs/ inch N/25mm</td>
</tr>
<tr>
<td>0.5 mil (12.5µm)</td>
<td>2</td>
</tr>
<tr>
<td>1.0 mil (25µm)</td>
<td>4</td>
</tr>
<tr>
<td>2.0 mil (50µm)</td>
<td>4</td>
</tr>
<tr>
<td>3.0 mil (75µm)</td>
<td>4</td>
</tr>
<tr>
<td>5.0 mil (125 µm)</td>
<td>4</td>
</tr>
</tbody>
</table>

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Strength Development of Tru-Bond UV PSA 750

ASTM D330 modified 0.05mm aluminum film to Stainless Steel,
2 mil (0.50mm) adhesive film thickness. 1500 ml/cm² Dosage with Metal Halide lamp at 50 mW/cm²

<table>
<thead>
<tr>
<th>Time</th>
<th>Room Temp.</th>
<th>Peel Temp.</th>
<th>Peel</th>
<th>Peel Temp.</th>
<th>Peel</th>
<th>Peel</th>
<th>Peel</th>
</tr>
</thead>
<tbody>
<tr>
<td>15 min.</td>
<td>90°</td>
<td>90°</td>
<td>90°</td>
<td>90°</td>
<td>90°</td>
<td>90°</td>
<td>90°</td>
</tr>
<tr>
<td>lbs./inch</td>
<td>N/25mm</td>
<td>lbs./inch</td>
<td>N/25mm</td>
<td>lbs./inch</td>
<td>N/25mm</td>
<td>lbs./inch</td>
<td>N/25mm</td>
</tr>
<tr>
<td>5.1</td>
<td>22.7</td>
<td>4</td>
<td>17.8</td>
<td>8.5</td>
<td>37.8</td>
<td>5.2</td>
<td>23.1</td>
</tr>
</tbody>
</table>

CONVERSIONS

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

WARRANTY

ITW will replace any material found to be defective. Because the storage, handling and application of this material are beyond our control, we can accept no liability for the results obtained.

STORAGE

Store the unopened product in a cool, dry, well ventilated location away from sources of heat. Optimal storage temperatures should range between 10 °C (50 °F) and 32 °C (90 °F). Do not expose the product to light. It may polymerize upon prolonged exposure to ambient or artificial light.

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