



HITAC
ADHESIVES & COATINGS

A DIVISION OF AMERICAN POLYMERS CORP.

RA-13W WATER BASED RELEASE AGENT SOLUTION

RA-13W has been continuously used for more than fifteen years to provide effective release in a variety of pressure sensitive adhesive tapes, including OPP packaging tapes and polyethylene backed diaper fastening tapes with adhesives based on SIS block copolymers, SBR solvents and natural rubber. The release is also effective in polyester, vinyl, and filament tape constructions. Polypropylene and polyethylene films should be free of any lubricants, or other surface-finishing materials, and must be corona treated to 38 dyne/cm, or higher, to obtain effective release.

Coater-ready solutions are easily prepared by mixing **RA-13W** with water (deionized if the local water supply is too hard) to 1-5% total solids, depending on the adhesive, substrate and coating method, which can be Meyer bar #6-12, rotogravure roll #160-250 and stacked smooth rolls.

The following is a recommendation for initial laboratory evaluation: Coat the film placed on a glass plate with a 2% T.S. solution of **RA-13W** using a #6 Meyer rod and dry horizontally in air oven at 150°F (70°C) for 10 minutes or until completely dry. This may be followed by a pilot coater trial or production evaluation.

Unlike silicone release agents, crosslinking is neither necessary nor occurring on drying or tape storage.



Release properties develop by simply flashing off water in a production oven at 120-250°F (50-120°C), depending on substrate, web speed, oven length, dry air temperature, dry air velocity, and other configurations. These properties allow release coating and adhesive coating in a single step.

It is important to achieve complete drying. Use the highest possible drying temperature to maximize the running speed. The coating is dry when the film is clear and resists moderate finger rub.

TYPICAL PROPERTIES

APPEARANCE	CLEAR TO SLIGHTLY HAZY
TOTAL SOLIDS	29%
VISCOSITY	400cps
pH	8

UNWIND ADHESION VALUE - g/2"(5cm) BASED ON PREMIUM OPP PACKING TAPE WITH SIS-BASED PSA

GREEN (OFF-SLITTER)	EASY - 300
AGE 150°F (65°C) FOR 72 HR	MODERATE - 550
AGE 120°F (49°C) AT 90% RH FOR 72HR	MODERATE - 450
SHELF STORAGE 12 MONTHS	MODERATE - 450

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HITAC ADHESIVES & COATINGS
14722 SPRING AVENUE, SANTA FE SPRINGS, CA 90670
TEL: 562-802-8834 | FAX: 562-921-7363 | ORDERS@H2OBASE.COM | WWW.H2OBASE.COM