TOYO CHEM CO., LTD.
TEL：03-3272-0940
https://www.artiencegroup.com

ORIBAIN　BPW 6615

1. Features

ORIBAIN BPW 6615 is a one-component, water-based, emulsion-type acrylic adhesive.

2. Specification

	Product name ＜ **BPW 6615** ＞
Appearance	Light yellow emulsion
Non-volatile content	60.0±1.0 %
Viscosity	4500±500 mPa･s
pH	7.5 ± 0.5

Viscometer: Brookfield, spindle No. 4 , 60 rpm at 25°C

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3. Performance

Test Item: Measurement				Value
Peel strength［N/25mm］	23℃-50%RH	SUS	Immediately	28.0
			24hrs	29.1
		PE	Immediately	18.0
			24hrs	28.2
Heat Aging Resistance［N/25mm］	Pressed 20min → 80℃ 4hrs → Room Temp 1hr	SUS		29.3
		PE		25.6
Holding Power［mm/70,000sec］	40℃-1Kg	SUS		8173
Softening Point〔℃〕		SUS		115
Ball Tack (J. Dow Method)　［#］				11

＜**Sample Preparation Conditions**＞

Release paper	:	Polyester laminate quality paper separator
Substrate	:	Commercial quality paper
Coating method	:	Transfer coating
Coating weight	:	approx. 25g/m² (dry)
Drying:	:	105℃ for 75 seconds in hot air oven
Aging	:	After coating, 23℃-50%RH, more than 1 day

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4. Handling and Storage

Storage : Store indoors at 5-40℃. Avoid direct sunlight and freezing.
Handling : Use protective equipment such as rubber gloves to prevent direct skin contact with the sample.

* The general description, recommended uses, application data and statements in the product literature and label are guidelines only. Users should test this product in advance to verify suitability for particular uses.

5. General Test Methods

＜Peel strength＞

Leave the sample and adherend under the test conditions for at least 30 minutes. Then, apply the sample to the adherend and press with a 2kg roller back and forth once before measuring.
Measure Peel strength using a tensile tester, pulling at 180 degrees at 300 mm/min.

Sample size	:	25mm width × 100mm length
Adherend	:	SUS plate, PE plate
immediately	:	Measure immediately after applying
24hrs	:	Measure after 24hrs in test conditions.
Test conditions	:	23℃-50%RH

<Heat Aging Resistance>

Place the sample and the adherent under measurement conditions for more than 30 minutes, bond them, and measure after pressing once back and forth with a 2Kg roller. Leave for 20 minutes at 23℃-50%RH. After that, heat at 80℃ for 4 hours. After heating, leave at 23℃-50%RH for 1 hour, then measure adhesion force. Measurement is conducted using a tension tester by folding the sample back at 180 degrees and peeling off at a speed of 300mm/min, displaying its strength.

<Softening Point>

Place the sample and the adherent under measurement conditions, press once back and forth with a 2Kg roller. After 24 hours at 23℃-50%RH, apply a 500g load at 38℃, leave for 15 minutes, and then raise the temperature by 3℃ every 5 minutes until the sample falls, showing that temperature.

Sample size	:	25mm width × 100mm length
Test area	:	25mm width × 25mm length
Adherend	:	SUS plate
weight	:	500g
Storage Time		23℃-50%RH, 24 hours
Test conditions		38℃/15min → Increase Temp by 3℃/5min

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＜**Holding Power**＞

Apply the sample to the adherend and press with a 2kg roller back and forth once at 23°C and 50% RH. Leave the applied sample for 20 minutes under test conditions, then apply a 1kg load and measure the time to fall or the creep distance.

Sample size	:	25mm width × 100mm length
Test area	:	25mm width × 25mm length
Adherend	:	SUS plate
Test conditions	:	40℃ (no humidity)
weight	:	1Kg

＜**Ball Tack (J. Dow Method)**＞

Roll a steel ball (1/32-32/32 inches) down a 30-degree inclined plane with a 10cm approach run onto a 10cm section of the adhesive surface. The ball size that stops near the center of the adhesive surface is recorded as the result. Conduct the test under conditions of 23°C and 50% RH.

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