SUMITOMO CHEMICAL

SUMIKAFLEX 328HQ

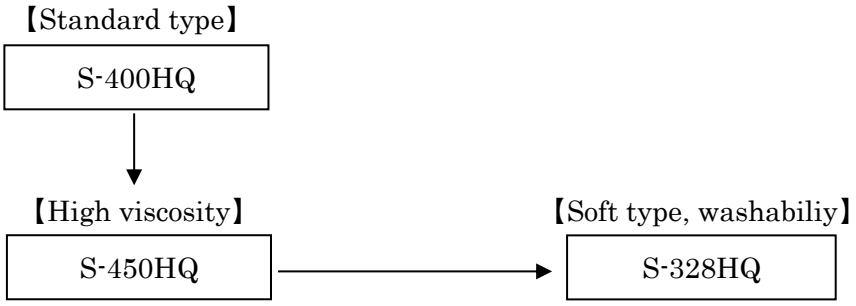
Type:	Ethylene-Vinyl acetate Copolymer Emulsion
Properties:	SUMIKAFLEX 328HQ (S-328HQ) is an ethylene vinyl acetate copolymer emulsion with poly-vinyl alcohol as a protective colloid. This product has high viscosity, and its film has good washability. Moreover, it is good at adhesion and the following properties for materials since it is more flexible than SUMIKAFLEX 450HQ.
Main application:	Adhesives for all Paper containers and crafts Construction and wood

Physical properties:

Appearance		Milky white
Solid content	(%)	56.0 ± 1.0
Viscosity	(mPa・s)	3000 – 5000
pH		4.0 – 7.0
Ave. particle size	(μm)	0.6
Density	(g/cm^3)	1.07
MFT	(°C)	0
Particle charge		Nonionic
Mechanical stability		Good
Tg	(°C)	−5
Tensile strength	(MPa)	9.0
Tensile elongation	(%)	700

＜Technical Information of SUMIKAFLEX 328HQ＞

1. Grade positioning



2. Emulsion properties

		S-328HQ
Appearance		Milky white
Solid content	(%)	56.0 ± 1.0
Viscosity	(mPa･s)	3000 – 5000
pH		4.0 – 7.0
TI		0.3 – 0.4
Ave. particle size	(μm)	0.6
Density	(g/cm^3)	1.07
MFT	(°C)	0
Particle charge		Nonionic
Mechanical stability		Good
Tg	(°C)	−5

3. Film properties

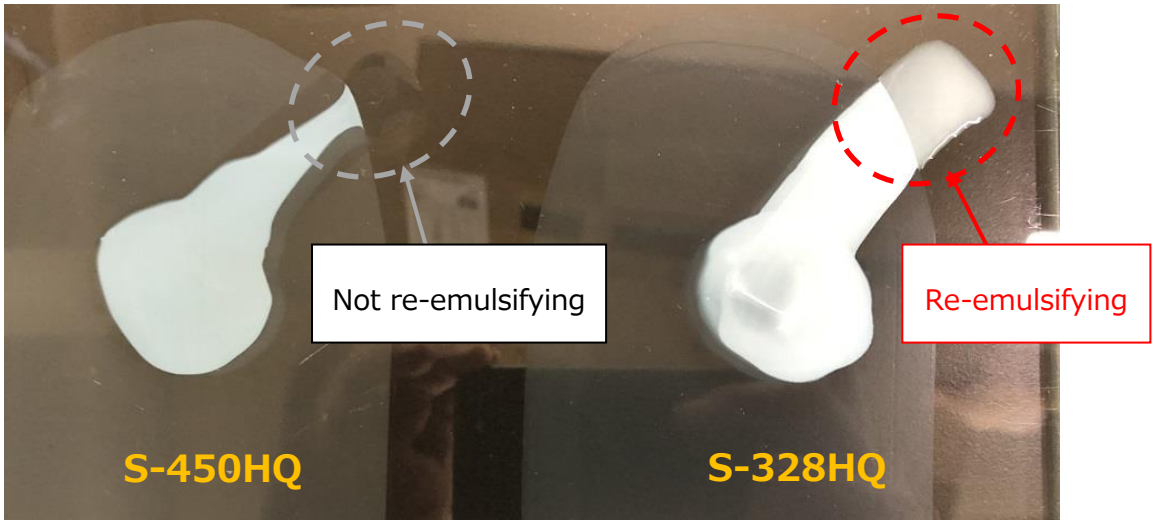
(1) Tensile strength

Item		S-328HQ	S-400HQ
Original	Elongation (%)	700	550
	Strength (MPa)	9.0	12.7

Test method

Thickness of film : 0.15 mm
Shape of film : Dumbbell No.3
Film forming condition and aging : 23°C × 65%RH × 4 days
Measurement speed : 500 mm/min

(2) Washability



Test method

Coat the emulsion on a glass plate by a 3 mil applicator
Dry at room temperature for about 3 hours
Drop approximately 0.2 cc of water on the coating surface
Check the re-emulsifying property after rubbing by with a finger

4. Applications

(1) Application of adhesion usage

		Open time (Time from coating to bonding)	
		Immediately	5 sec. later
Dry peeling strength (N/25mm)	S-328HQ	6.4	2.1
		Paper broken	Paper broken
	S-400HQ	4.8	0.5
		Paper broken	Interfacial peeling

Test method

Base material	: Paper/PET film (Lumirror #75-T60)
Coating weight	: 50 g/m^2 as wet on paper
Clamping	: Hand roller
Aging	: 4 days after clamping (23°C × 65%RH)
Dry peeling strength	: 25 mm width, 180° angle peeling
Peel speed	: 200 mm/min.