**Chemical nature**

Aqueous dispersion of an acrylate copolymer that crosslinks at room temperature.

**Technical data**

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Solids content</td>
<td>approx. 55 %</td>
</tr>
<tr>
<td>pH</td>
<td>approx. 4.5 – 6.5</td>
</tr>
<tr>
<td>Viscosity (EN ISO 3219)</td>
<td>approx. 50 – 150 mPas</td>
</tr>
<tr>
<td>Glass transition temperature</td>
<td>approx. –20 °C</td>
</tr>
</tbody>
</table>

**Advantages**

Acronal 3640 is used in the manufacture of adhesives for film lamination. It is particularly suitable for glossy films, as it adheres well to suitably corona-treated olefinic surfaces as well as to acetate- and polyester-films.

Adhesives made of Acronal 3640 crosslink at room temperature once they have dried. This results in an increase in cohesion, which improves the resistance to embossing and grooving.

The properties of Acronal 3640 in foaming and wetting must be adjusted to the requirements of the coating machine by adding suitable auxiliaries. As a result of special care in manufacture, the amount of coagulate and grid in the product is very small. It is nevertheless recommended to pass adhesives made with Acronal 3640 through a fine filter before use.

If Acronal 3640 X is to be mixed with other dispersions, attention must be paid to the pH value. It should not exceed the neutral range.

We recommend adding a preservative to adhesives based on Acronal 3640 to protect from microbial attack. The suitability of such additives must be verified and monitored in trials.

Manufacturers must carefully carry out their own trials when developing adhesives based on Acronal 3640. There are a lot of factors in production and processing that we cannot cover exhaustively in our trials, but which can influence the compatibility with other components of adhesives, their wetting or the adhesion to different substrates. Acronal 3640 has a shelf life of six months at 10–30 °C.

The product must not be allowed to come into contact during storage with metals or alloys that are susceptible to corrosion. It is important to ensure that containers are kept tightly sealed and the headspace of bulk storage tanks must be kept saturated with water vapor. The product must not be exposed to high temperature and it must be protected from frost.

Acronal 3640 is fully protected against microbial attack in the form in which it is supplied, but we recommend treating it with a biocide in order to prevent problems with microorganisms from occurring during storage and processing.

The data contained in this publication are based on our current knowledge and experience. They do not constitute the agreed contractual quality of the product and, in view of the many factors that may affect processing and application of our products, do not relieve processors from carrying out their own investigations and tests. The agreed contractual quality of the product at the time of transfer of risk is based solely on the data in the specification data sheet. Any descriptions, drawings, photographs, data, proportions, weights, etc. given in this publication may change without prior information. It is the responsibility of the recipient of our product to ensure that any proprietary rights and existing laws and legislation are observed.

Edition: November 2015

This data sheet will be rendered invalid if it is superseded by a later version.

® = registered trademark of BASF SE