



## 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.

<b>TYPICAL PROPERTIES</b>	
<b>APPEARANCE</b>	<b>CLEAR TO SLIGHTLY HAZY</b>
<b>TOTAL SOLIDS</b>	<b>29%</b>
<b>VISCOSITY</b>	<b>400cps</b>
<b>pH</b>	<b>8</b>

<b>UNWIND ADHESION VALUE - g/2"(5cm)</b> <b>BASED ON PREMIUM OPP PACKING TAPE WITH SIS-BASED PSA</b>	
<b>GREEN (OFF-SLITTER)</b>	<b>EASY - 300</b>
<b>AGE 150°F (65°C) FOR 72 HR</b>	<b>MODERATE - 550</b>
<b>AGE 120°F (49°C) AT 90% RH FOR 72HR</b>	<b>MODERATE - 450</b>
<b>SHELF STORAGE 12 MONTHS</b>	<b>MODERATE - 450</b>

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